

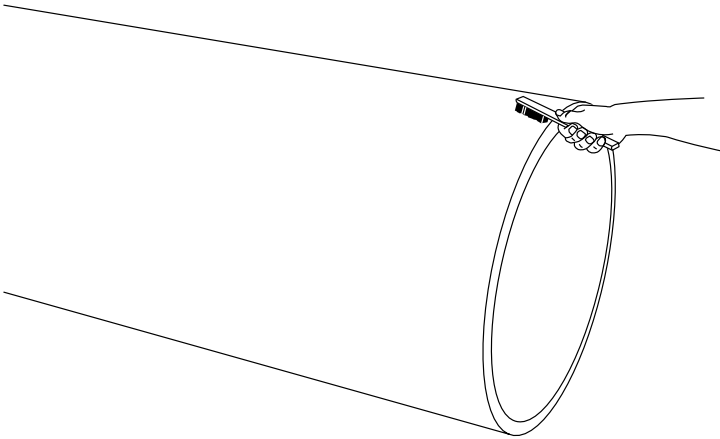
INSTALLATION INSTRUCTIONS

Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the coupling to ensure you have the proper size.

Style FC400 Flanged Steel Couplings (with reinforced end rings)

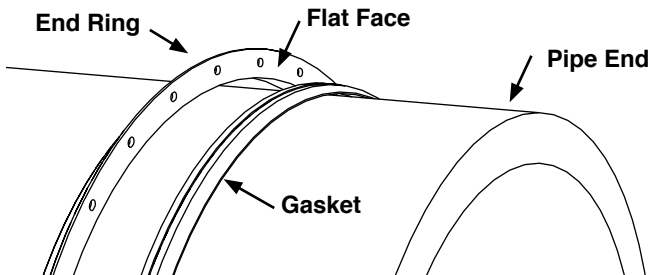
PIPE ENDS

Step 1 • Clean pipe end for a distance of 2" greater than the length of the flanged coupling. Check area where gaskets will seat on pipe and flange faces to make sure there are no dents, projections, gouges, etc. that will interfere with the gasket seals. Welds must be ground flush.

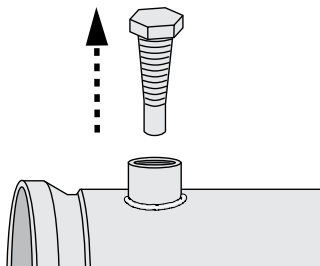


ASSEMBLY

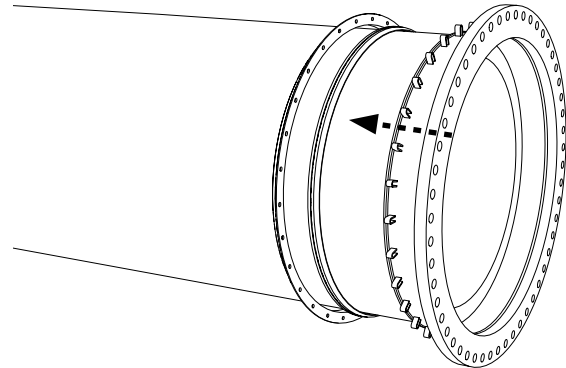
Step 2 • Place end ring on the pipe and position it so that the flat face is towards the pipe end. The end rings should easily slip on to the pipe. Once gaskets are inspected, clean, and free from damage and debris, lubricate gasket, and install on the pipe end, next to the end ring with the beveled edge towards pipe end.



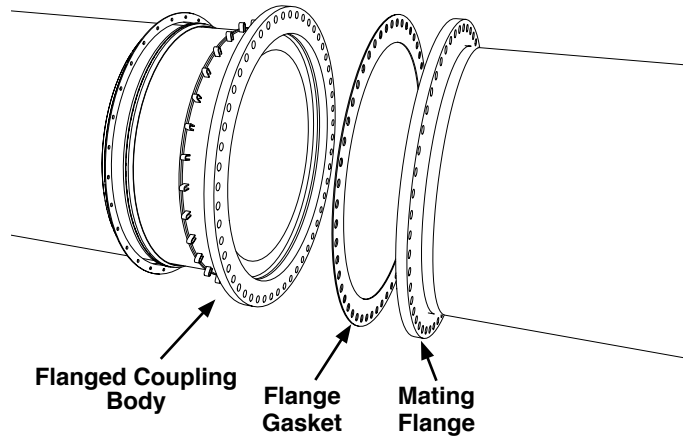
If using Anchor Pins, remove the anchor pins from the half couplings on the flanged coupling body.



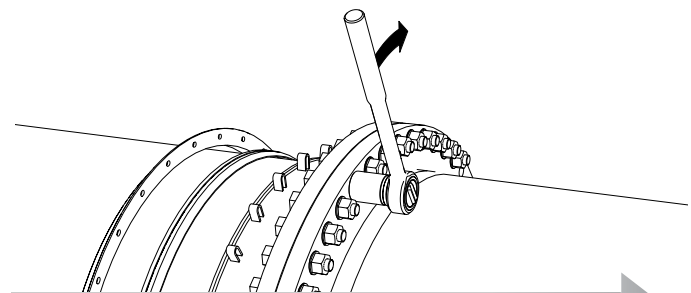
Step 3 • Slide the flanged coupling body into position over the pipe end.



Step 4 • Using a flange gasket, position the flanged coupling against the mating flange, making sure there is a minimum 3 1/2" of pipe insertion. If using Anchor Pins, the minimum pipe insertion is 4 1/2".



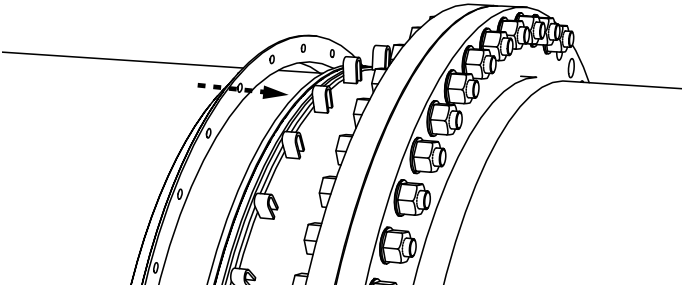
Step 5 • Assemble the flanged joint using flange bolts.



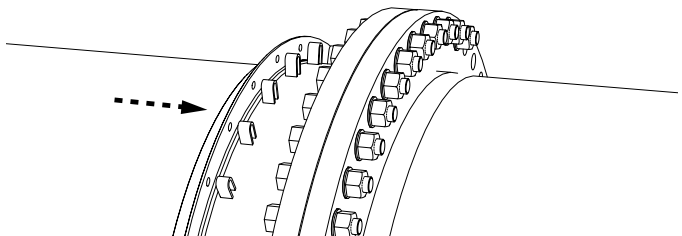
Installation Instructions continued on back

Style FC400 Flanged Steel Couplings with reinforced end rings (Continued from front)

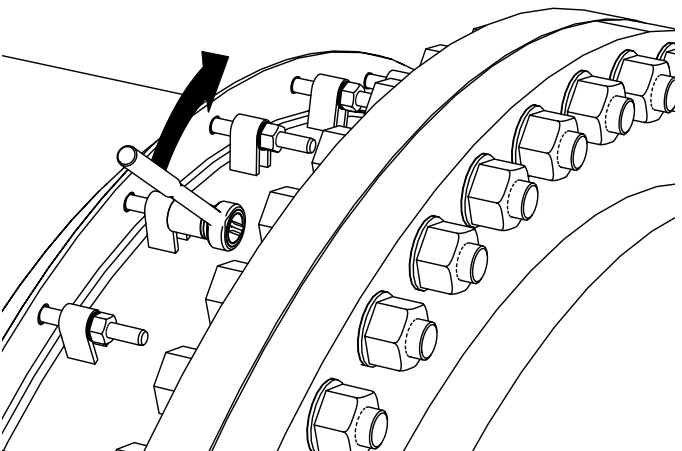
Step 6 • Slide the ring gasket into position with the beveled edge properly engaging the flared end of the flanged coupling body.



Step 7 • Slide the end ring into position against the gasket. Be sure to match weld in end ring with weld in body.



Step 8 • Insert the bolts through the end ring into the anchor loops and tighten to 30 - 35 ft-lbs. Bolt tightening should be done evenly, alternating to diametrically opposite positions to bring bolts to recommended tightness. Increase torque by 10-15 ft-lbs. to 60 - 70 ft-lbs. for $\frac{5}{8}$ " bolts or 85 - 95 ft-lbs. for $\frac{3}{4}$ " bolts.



STEP 9 • IF USING ANCHOR PINS

1. Remove Anchor Pins from flanged coupling body.
2. Slide the flanged coupling body onto the pipe end.
3. Position the flanged coupling against the mating flange. Assemble the flanged joint.
4. Thread a short pipe nipple into the threaded Anchor Pin hole. Using the largest drill bit that will fit into the pipe nipple, drill a center mark on the pipe. Do not drill through. Remove the pipe nipple.
5. Use a $\frac{5}{16}$ " diameter drill to drill through the center mark made in step 4.
6. Complete the hole by drilling through the pipe with drill size per the table below.
7. Install the Anchor Pins. Apply a suitable thread sealant and tighten to prevent leakage.

Pin Size	Thread Size	Drill Size for Pipe	Torque (ft-lbs.)
1"	1" NPT	1 $\frac{1}{32}$ "	100

Step 10 • After 24 hours, it may be necessary to retighten the bolts. $\frac{5}{8}$ " bolts re-tighten to 60 - 70 ft-lbs., $\frac{3}{4}$ " bolts to 85 - 95 ft-lbs.

Step 11 • Pressure test to 1.5 X working pressure. If leaks should develop during the testing procedure, tighten bolts as necessary to stop leaks. Check all bolts for torque.



CAUTION: When reinstalling parts with stainless steel hardware there may be a loss in pressure holding ability due to worn or damaged threads during the original installation.