

# 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 XR501 Extended Range Couplings

For pipe ODs smaller than standard steel,  
down to SDR 35 sewer, do not exceed 20 psi.

Coupling set up at factory for DI size pipe. It may be necessary to loosen coupling bolts for some A/C pipe sizes. Oversize A/C may require disassembly of coupling.

**Step 1** • Check the coupling parts to insure that no damage has occurred during transit and that no parts are missing.

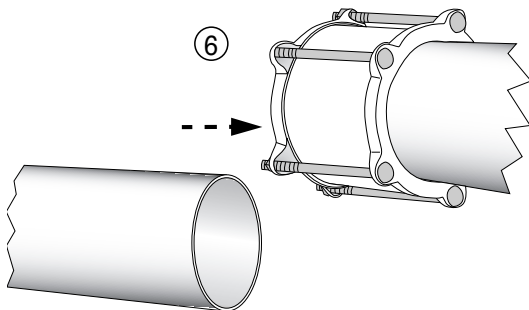
**Step 2** • Clean pipe ends for a distance of 2" greater than length of the coupling when centered over the joint.

**Step 3** • Check area where gaskets will seat to make sure there are no dents, projections, gouges, etc., that will interfere with the gasket seal. Welds must be ground flush.

**Step 4** • Place a reference mark on the pipe an equal distance from each pipe end for centering coupling over joint. There should be a minimum of 3 inches of pipe insertion per coupling end.

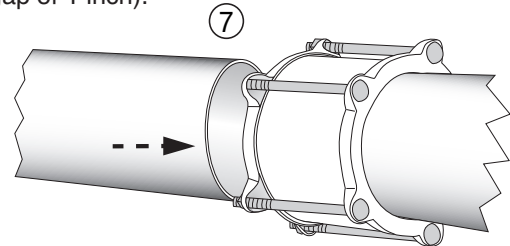
**Step 5** • Lubricate the gaskets and pipe surface with a suitable gasket lubricant.

**Step 6** • Slide assembled coupling completely onto one of the pipes.

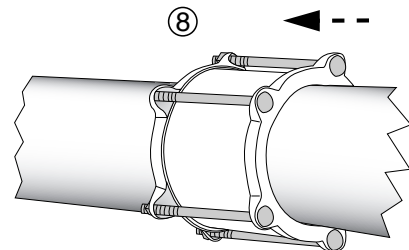


**Note: Flexible Couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.**

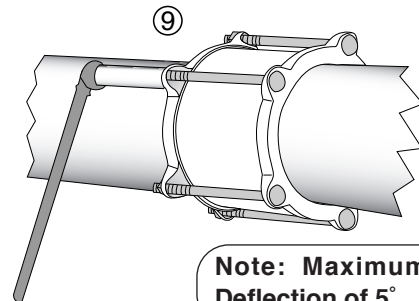
**Step 7** • Bring the other pipe into position (recommended pipe gap of 1 inch).



**Step 8** • Center coupling over pipe ends using the reference marks described in Step 4.



**Step 9** • Tighten bolts such that the end ring flanges remain parallel and the gaskets are evenly compressed. Bolt tightening should be done evenly, alternating to diametrically opposite positions at approximately 20 ft-lbs increments. Tighten to 75 - 90 ft-lbs.



**Note: Maximum Angular Deflection of 5°.**

**Wait 10 minutes and retighten to account for settling of the gasket.**



**Step 10** • Confirm proper installation by pressurizing the line and checking for leaks.



## Style XR501 Extended Range Couplings

### PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correct size coupling; also check gasket to make sure it is the size you think it is.
2. Clean pipe to remove dirt and corrosion from pipe surface. Lubrication and additional cleaning should be provided by brushing both the gasket and plain pipe end with soapy water or approved pipe lubricant per ANSI/AWWA C111/A21.11.
3. Make sure no foreign materials lodge between gasket and pipe.
4. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque.
5. Keep threads free of foreign material to allow proper tightening.
6. Take extra care to follow proper bolt tightening procedures and torque recommendations. Bolts are often not tightened enough when a torque wrench is not used.
7. Pressure test for leaks before backfilling.
8. Backfill and compact carefully around pipe and fittings.
9. Couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.
10. 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. Additional lubrication should be applied.

### COMMON INSTALLATION PROBLEMS

1. Bolts are not tightened to the proper torque.
2. Rocks or debris between pipe and gasket.
3. Dirt on threads of bolts or nuts.
4. Pipe not inserted into the coupling far enough.
5. Center ring not centered evenly around pipe.
6. Too much pipe deflection.
7. Using on pipe smaller than standard steel at pressures greater than 20 psi.