ROMAC INDUSTRIES, INC.

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 clamp to ensure you have the proper size.

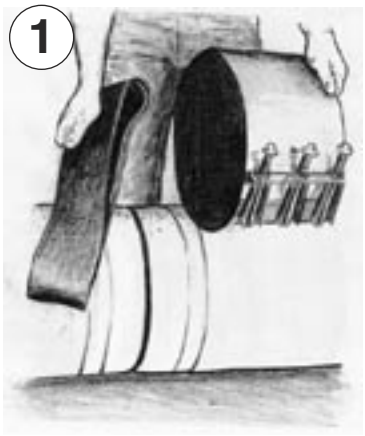
The A/CME Band with Stainless-Seal Repair Clamp

The A/CME Band is a sturdy, ribbed rubber strap, 4" wide and 1/4" thick, adding 1/2" to the diameter of the machined pipe end. It is made of SBR virgin rubber, compounded for water service. Normal 1/4" spacing between the two machined pipe ends is neces-

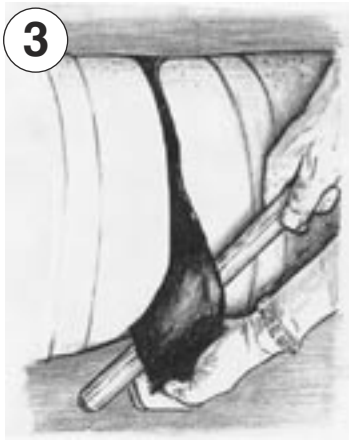
Step 1 • There are two components for the repair of leaking or broken A/C couplings:

- **The A/CME Band**
- **Stainless-Seal Repair Clamp**

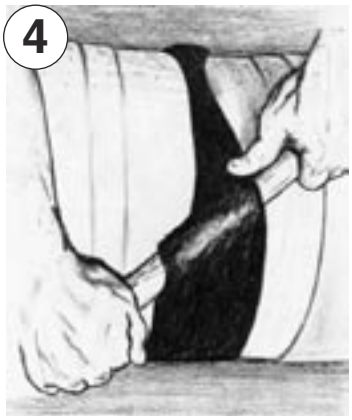
Insert the edge of the band between the ends of pipe. Insert from bottom so that finish will be on top.



Step 2 • Pull up band as far as possible on both sides. Position loose uncommitted portion of band directly under pipe ends.

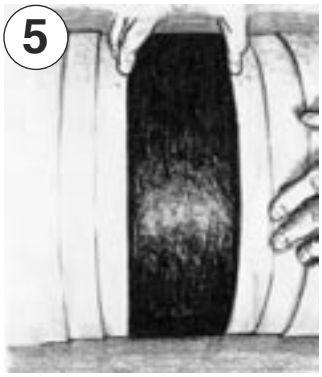


Step 3 • Insert rod, pipe or stick approximately 3/4" x 12" through loop on either side.

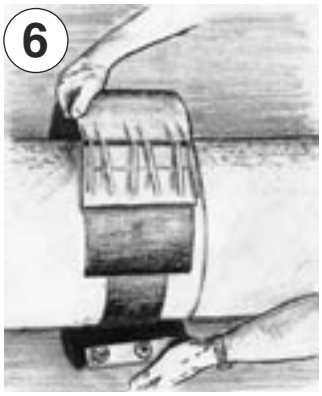


Step 4 • Rotate rod and at the same time pull, so as to help the gasket out of the crack onto the outside surface of pipe ends.

Step 5 • After completion, the band should be in the approximate center, bridging the two pipe ends.



Step 6 • The A/CME Band must be used with the proper size Stainless-Seal pipe restrainer clamp. Care should be used to select the proper size clamp (see chart on back).



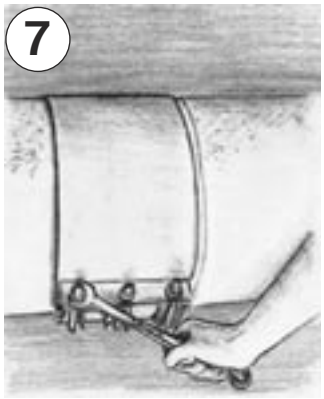
Step 7 • Tighten all nuts evenly in 20 ft-lb increments to the appropriate tightness. After the clamp is fully tightened, the stainless shell will show marks from the A/CME Band.

Nom. Pipe Diameter	Torque
4"	35-40 ft-lbs.
6" and above	75-80 ft-lbs.

Note:

50 ft-lbs. torque = 12" wrench w/50 lbs. force

70 ft-lbs. torque = 12" wrench w/70 lbs. force



For best results, wait 10 minutes and retighten to proper torque.

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ROMAC INDUSTRIES, INC.

INSTALLATION INSTRUCTIONS

The A/CME Band

with Stainless-Seal Repair Clamp

PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correctly sized clamp.
2. Clean pipe to remove as much dirt and corrosion as possible from the surface.
3. Be sure A/CME Band is centered and seated properly on the machined surfaces of the two pipes being joined.
4. Be sure clamp is centered over A/CME Band.
5. Make sure no foreign materials stick to the gasket as it is brought around the pipe, nor become lodged between gasket and pipe or A/CME Band as nuts are tightened.
6. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque.
7. Keep threads free of foreign material to facilitate tightening.
8. Bolts are often not tightened enough when a torque wrench is not used. Take extra care in this situation to make sure proper tightening occurs.
9. Pressure test for leaks before backfilling.
10. Backfill and compact carefully around clamp.
11. 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.

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. Repair clamp too small for the size of damage to pipe.
5. Repair clamp not centered over damaged portion of pipe.
6. Repair clamps should not be used as couplings.
7. Gaps between sections are not equal (SS2 and SS3).

PIPE SIZE	PIPE M.E.O.D	1st CHOICE CLAMP	2nd CHOICE CLAMP	3rd CHOICE CLAMP	BAND CAT. NO.
4"	4.64 4.81	SS1 - 5.14 x 8 SS1 - 5.35 x 8	— SS2-5.57 x 8	— SS1 - 5.14 x 8*	A/CME - 4.64 A/CME - 4.81
6"	6.91	SS1 - 7.46 x 8	SS2-9.79 x 8	SS1 - 7.24 x 8*	A/CME - 6.91
8"	9.11	SS1 - 9.70 x 8	SS2-9.79 x 8	SS1 - 9.40 x 8*	A/CME - 9.11
10"	11.24 11.66	SS1-11.80 x 8 SS1-12.25 x 8	SS2-11.84 x 8 SS2-12.20 x 8	SS1-11.44 x 8* SS1-12.00 x 8*	A/CME-11.24 A/CME-11.66
12"	13.44 13.92	SS1-14.00 x 8 SS1-14.50 x 8	SS2-13.95 x 8 SS2-14.51 x 8	SS1-13.55 x 8 —	A/CME-13.44 A/CME-13.92
14"	15.07 16.22	SS2-15.80 x 8 SS2-16.75 x 8	— —	— —	A/CME-15.07 A/CME-16.22
16"	17.15 18.46	SS3-18.30 x 8 SS3-19.46 x 8	— SS3-19.20 x 8*	— —	A/CME-17.15 A/CME-18.46

*** This choice requires removing the gaskets to span the A/CME Band and pipe. Remove gasket and position armors by hand to bridge shell ends.**

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