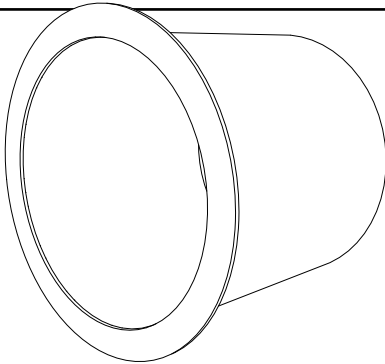


Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on all parts to ensure you have the proper size.

LIMITATIONS: For product limitations see reverse side. For more detailed information see the HDPE Products section of the Romac Product Catalog, or phone Romac Engineering Department at 1-800-426-9341.



HDPE Pipe End Stiffeners (14" and Larger)

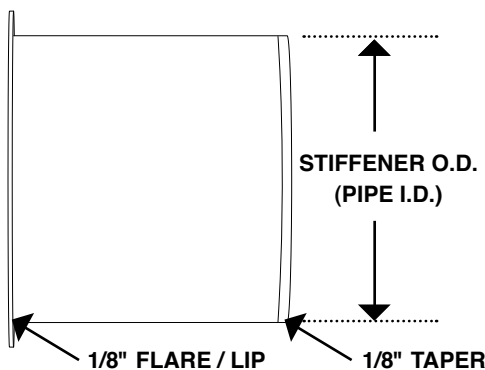
Step 1 • Clean pipe ends the distance equal to the length of the mechanical fitting to be installed.

*Prepare the HDPE pipe ends and measure I.D. of pipe to verify the correct size Stiffener. The outside diameter of the Stiffener will be equal to the HDPE Manufacturers published average inside diameter of the pipe.

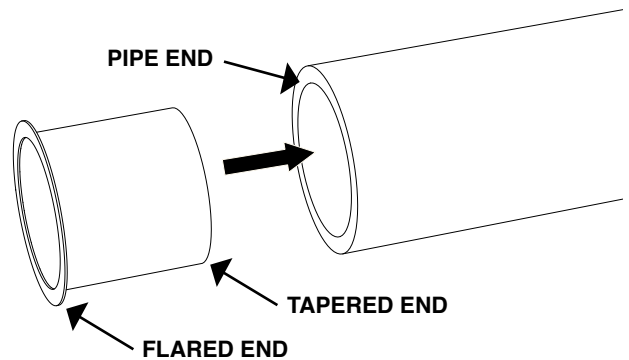
Step 2 • Inspect the pipe surface where the mechanical fitting will be installed. Make sure there are no gouges, bumps or areas that will interfere with the gasket seal.

Check for any special handling requirements or limitations of the fitting on HDPE pipe.

Romac HDPE Pipe End Stiffeners are designed for use with mechanical couplings, clamps and fittings where stiffening of the pipe is necessary for proper gasket seal. Caution needs to be taken to prevent (1) shear loading on the joint, (2) migration of the stiffener out of the end of the pipe from lack of a back load on stiffener rim or load on the stiffener.



Step 3 • Place the tapered end of the stiffener into pipe end.



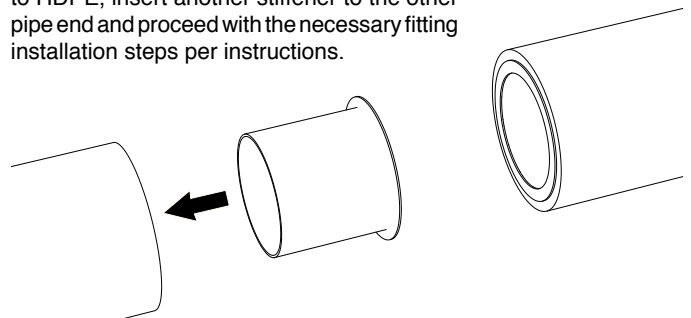
To ease installation, the stiffener can be lubricated with water or soapy-water. **DO NOT USE PIPE LUBRICANT.**

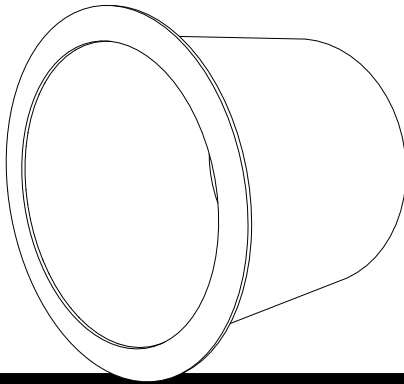
Insert stiffener into the pipe until the Flared End contacts the pipe end.

To properly seat the stiffener it may be necessary to gently tap the flare face with a rubber mallet or lay a flat piece of wood across the diameter of the stiffener and tap with a heavy object. Take care not to damage the stiffener.

In applications where the HDPE pipe end has been cut and the I.D. has "necked down", bevel the I.D. of the pipe to open the I.D. for ease of installation.

Step 4 • For applications joining HDPE to HDPE, insert another stiffener to the other pipe end and proceed with the necessary fitting installation steps per instructions.





HDPE Pipe End Stiffeners (14" and Larger)

PRECAUTIONS

1. Check inside and outside diameter of pipe to make sure you are using the correct size parts.
2. Clean pipe to remove as much dirt and corrosion as possible from the surface.
3. Always pressure test for leaks before backfilling.
4. Make sure gaskets do not extend past the edge of the stiffener after final assembly.

PRODUCT LIMITATIONS

High Density Polyethylene Pipe (HDPE) has a lower modulus of elasticity and higher coefficient of thermal expansion than other pipe materials. These properties cause HDPE pipe to expand and contract much more from changes in temperature and/or pressure than other piping materials. Because of these and other properties, great care must be taken when installing conventional fitting on HDPE.

HDPE LIMITATIONS:

- Pipe must be manufactured in accordance with AWWA Standard C906-90.
- Operating temperatures are limited to 85° F maximum and 32° F minimum.
- Operating pressure is limited to 150 psi or the rating of the pipe, whichever is less.
- Pipe systems must be designed to compensate for pipe movement so as to prevent fittings from migrating or rotating on the pipe.
- Products are intended for use in underground service only.
- Products are not to be used on pressurized HDPE pipe with an SDR greater than 32.5.



ROMAC CANNOT WARRANT PRODUCTS USED IN APPLICATIONS THAT ARE OUTSIDE ONE OR MORE OF THESE LIMITATIONS. CONTACT ROMAC'S ENGINEERING DEPARTMENT AT 1-800-426-9341 IF YOU HAVE QUESTIONS ABOUT THE USE OF OUR PRODUCTS ON HDPE PIPE.

HDPE PRECAUTIONS:

Try always to install fittings when pipe is at its coldest.

This product is designed for a 53° F temperature range maximum.