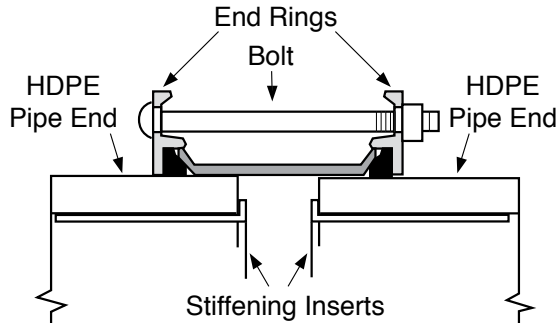




STIFFENING INSERTS

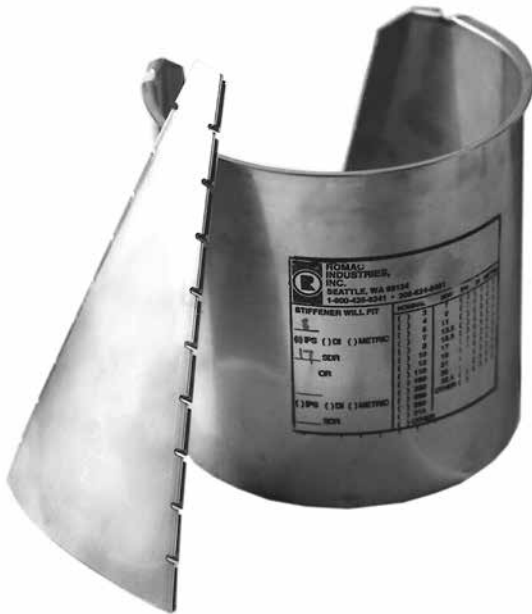
MATERIAL SPECIFICATIONS

Romac's specially designed Stiffening Inserts provide circumferential inside support of pipe ends to allow use of couplings on HDPE Pipe. The Stiffening Inserts are constructed of stainless steel per ASTM 240, type 304 (optional 316). The thin, yet strong wall reinforces the pipe without disturbing the flow characteristic of the medium.



SIZES 4" - 12" (PGS. 9-6 & 9-7)
FEATURE A WEDGE INSERT FOR INSTALLATION
 (SEE PHOTO ABOVE).

SIZES 14" - 36" (PG. 9-8)
ARE CUSTOM MOLDED TO THE ACTUAL PIPE I.D. AND HAVE A TAPERED EDGE FOR EASE OF INSTALLATION.



- Flexible couplings do not provide protection against possible pullout of pipe ends in unrestrained conditions.
- Romac couplings are not to be used on HDPE pipe with an SDR greater than 32.5.
- Romac only warrants the use of Romac stiffeners with Romac couplings.
- A Stiffener must be used in a coupling for SDR greater than 7.
- For above-ground HDPE applications, contact Romac's Engineering Department at 1-800-426-9341.
- For important technical information on HDPE pipe, see Page 9-1 & Page 9-2.

STIFFENING INSERTS

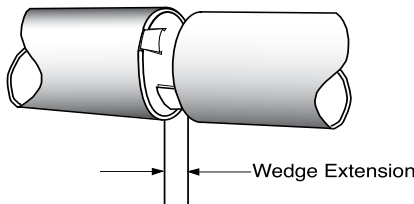


HDPE FOR HIGH DENSITY POLYETHYLENE PIPE

FOR IPS PIPE SIZE

NOM. PIPE SIZE	OUTSIDE DIAMETER	SDR	SUGGESTED CENTER RING LENGTH	AVERAGE PIPE ID	AVERAGE PIPE WALL	MAX. WEDGE EXTENSION*	CATALOG NUMBER	LIST PRICE	WEIGHT (lbs.)
4"	4.5	7	9	3.44	0.530	2.2	206-04020907	\$95.08	1.6#
			11	3.63	0.434	1.9	206-04021107		
			13.5	3.79	0.353	1.7	206-04021307		
			15.5	3.88	0.308	1.6	206-04021507		
			17	3.94	0.281	1.5	206-04021707		
			19	4.00	0.251	1.5	206-04021907		
			21	4.05	0.227	1.4	206-04022107		
			26	4.13	0.183	1.3	206-04022607		
			32.5	4.22	0.138	1.2	206-04023207		
			6"	6.625	7	9	5.06		
11	5.35	0.638				2.0	206-06021107		
13.5	5.58	0.520				1.8	206-06021307		
15.5	5.72	0.453				1.7	206-06021507		
17	5.80	0.413				1.6	206-06021707		
19	5.89	0.370				1.5	206-06021907		
21	5.96	0.334				1.5	206-06022107		
26	6.08	0.270				1.4	206-06022607		
32.5	6.22	0.204				1.3	206-06023207		
8"	8.625	7				9	6.59	1.016	2.2
			11	6.96	0.831	1.9	206-08021107		
			13.5	7.27	0.677	1.7	206-08021307		
			15.5	7.45	0.590	1.6	206-08021507		
			17	7.55	0.538	1.5	206-08021707		
			19	7.66	0.481	1.5	206-08021907		
			21	7.75	0.435	1.4	206-08022107		
			26	7.92	0.352	1.3	206-08022607		
			32.5	8.10	0.265	1.2	206-08023207		
			10"	10.75	7	9	8.22	1.266	2.7
11	8.68	1.036				2.4	206-10021107		
13.5	9.06	0.844				2.1	206-10021307		
15.5	9.28	0.735				2.0	206-10021507		
17	9.41	0.670				1.9	206-10021707		
19	9.55	0.600				1.8	206-10021907		
21	9.66	0.543				1.7	206-10022107		
26	9.87	0.438				1.6	206-10022607		
32.5	10.09	0.331				1.5	206-10023207		
12"	12.75	7				9	9.75	1.502	3.2
			11	10.29	1.229	2.8	206-12021107		
			13.5	10.75	1.001	2.5	206-12021307		
			15.5	11.01	0.872	2.4	206-12021507		
			17	11.16	0.795	2.3	206-12021707		
			19	11.33	0.711	2.2	206-12021907		
			21	11.46	0.644	2.1	206-12022107		
			26	11.71	0.520	1.9	206-12022607		
			32.5	11.97	0.392	1.8	206-12023207		
			14" & up	see page 9-8					

* **MAXIMUM WEDGE EXTENSION:** This would be the extension if the pipe was made to the smallest permissible inside diameter and the stiffener was installed at zero Fahrenheit. This extension also takes into account the slight collapsing of the pipe on the cut end "toe in" (1% of the outside diameter). The typical wedge extension, at room temperature and for the average pipe ID would be half the values listed above. For best results, install wedges so that they're not directly opposed



- Provide pipe SDR when ordering.
- HDPE Products are No Cancel, No Return Items.

TO ORDER: Determine Nominal Pipe Size and SDR Size.

HDPE

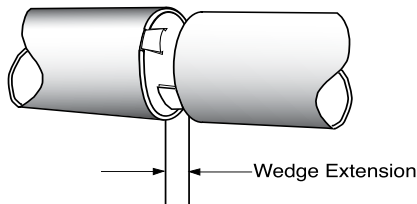


STIFFENING INSERTS

FOR DUCTILE IRON PIPE SIZE

NOM. PIPE SIZE	OUTSIDE DIAMETER	SDR	SUGGESTED CENTER RING LENGTH	AVERAGE PIPE ID	AVERAGE PIPE WALL	MAX. WEDGE EXTENTION*	CATALOG NUMBER	LIST PRICE	WEIGHT (lbs.)
4"	4.80	9	7	3.67	0.565	2.3	206-04010907	\$104.73	1.7#
		11		3.87	0.463	2.0	206-04011107		
		13.5		4.05	0.377	1.8	206-04011307		
		15.5		4.14	0.328	1.7	206-04011507		
		17		4.20	0.299	1.6	206-04011707		
		19		4.26	0.268	1.6	206-04011907		
		21		4.32	0.242	1.5	206-04012107		
		26		4.41	0.196	1.4	206-04012607		
		32.5		4.50	0.148	1.3	206-04013207		
		6"		6.90	9	7	5.27		
11	5.57		0.665		2.1		206-06011107		
13.5	5.82		0.542		1.9		206-06011307		
15.5	5.96		0.472		1.8		206-06011507		
17	6.04		0.430		1.7		206-06011707		
19	6.13		0.385		1.6		206-06011907		
21	6.20		0.348		1.5		206-06012107		
26	6.34		0.281		1.4		206-06012607		
32.5	6.48		0.212		1.3		206-06013207		
8"	9.05		9		7		6.92	1.066	2.3
		11	7.31	0.872		2.0	206-08011107		
		13.5	7.63	0.711		1.8	206-08011307		
		15.5	7.81	0.619		1.7	206-08011507		
		17	7.92	0.564		1.6	206-08011707		
		19	8.04	0.505		1.5	206-08011907		
		21	8.14	0.457		1.5	206-08012107		
		26	8.31	0.369		1.4	206-08012607		
		32.5	8.49	0.278		1.3	206-08013207		
		10"	11.10	9		7	8.49	1.307	2.8
11	8.96			1.070	2.5		206-10011107		
13.5	9.36			0.872	2.2		206-10011307		
15.5	9.58			0.759	2.1		206-10011507		
17	9.72			0.692	2.0		206-10011707		
19	9.86			0.619	1.9		206-10011907		
21	9.98			0.560	1.8		206-10012107		
26	10.20			0.453	1.7		206-10012607		
32.5	10.42			0.342	1.6		206-10013207		
12"	13.20			9	7		10.09	1.555	3.3
		11	10.66	1.272		2.9	206-12011107		
		13.5	11.13	1.036		2.6	206-12011307		
		15.5	11.39	0.903		2.5	206-12011507		
		17	11.55	0.823		2.4	206-12011707		
		19	11.73	0.736		2.2	206-12011907		
		21	11.87	0.666		2.1	206-12012107		
		26	12.12	0.538		2.0	206-12012607		
		32.5	12.39	0.406		1.9	206-12013207		
		14" & up	see page 9-8						

* **MAXIMUM WEDGE EXTENSION:** This would be the extension if the pipe was made to the smallest permissible inside diameter and the stiffener was installed at zero Fahrenheit. This extension also takes into account the slight collapsing of the pipe on the cut end "toe in" (1% of the outside diameter). The typical wedge extension, at room temperature and for the average pipe ID would be half the values listed above. For best results, install wedges so that they're not directly opposed



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TO ORDER: Determine Nominal Pipe Size and SDR Size.

STIFFENING INSERTS

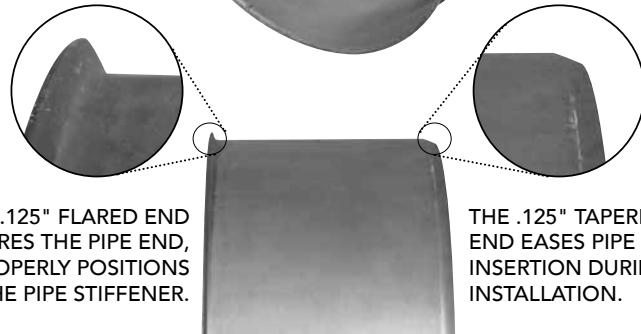
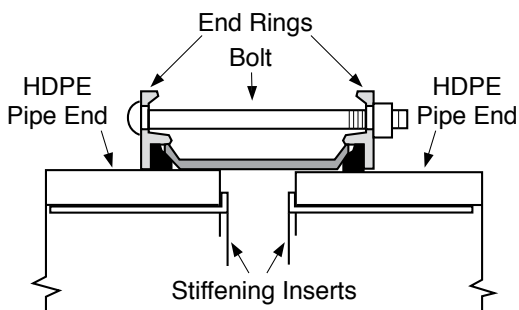


HDPE FOR HIGH DENSITY POLYETHYLENE PIPE

MATERIAL SPECIFICATIONS

Romac's specially designed Stiffening Inserts provide circumferential inside support of HDPE pipe ends. The Stiffening Inserts are constructed of stainless steel per ASTM 240, type 304 (optional 316). The thin, yet strong wall reinforces the pipe without disturbing the flow characteristic of the medium.

To ensure that pipe stiffeners are properly sized, we require the actual pipe I.D. at the time of order.



14" - 36" HDPE PIPE END STIFFENERS

NOM. PIPE SIZE	STIFFENER LENGTH		THICKNESS (GAUGE)	CATALOG NUMBER	LIST PRICE
	6"	12"			
14"	6"	12"	17	206-1-14- [PIPE ID] 06	POA
	12"	12"		206-1-14- [PIPE ID] 12	
16"	6"	12"	17	206-1-16- [PIPE ID] 06	POA
	12"	12"		206-1-16- [PIPE ID] 12	
18"	6"	12"	17	206-1-18- [PIPE ID] 06	POA
	12"	12"		206-1-18- [PIPE ID] 12	
20"	6"	12"	17	206-1-20- [PIPE ID] 06	POA
	12"	12"		206-1-20- [PIPE ID] 12	
22"	6"	12"	17	206-1-22- [PIPE ID] 06	POA
	12"	12"		206-1-22- [PIPE ID] 12	
24"	6"	12"	17	206-1-24- [PIPE ID] 06	POA
	12"	12"		206-1-24- [PIPE ID] 12	
30"	6"	12"	17	206-1-30- [PIPE ID] 06	POA
	12"	12"		206-1-30- [PIPE ID] 12	
36"	6"	12"	17	206-1-36- [PIPE ID] 06	POA
	12"	12"		206-1-36- [PIPE ID] 12	

For larger sizes, contact Romac Quotations Department.

- Provide pipe SDR when ordering.
- HDPE Products are No Cancel, No Return Items.

TO REQUEST PRICING: Indicate nominal pipe size. Select stiffener length and actual pipe ID.
EXAMPLE: For a 6" long stiffener for IPS size 24" nominal SDR 17 HDPE pipe, with an inside diameter of 21.18, the catalog number is: **206-01-2118 06**

