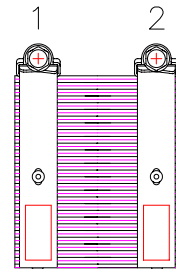


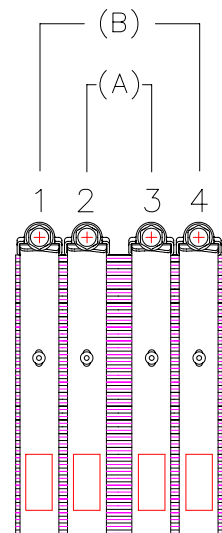
Recommended Practice for Installation of Classic Hubless Cast Iron Pipe Couplings Manufactured by Ideal Clamp Products, Inc.

A. Clamp and Gasket Installation

- 1) Pipe ends are to be cut as squarely and smoothly as possible.
- 2) Check coupling and gasket for foreign material, clean if necessary.
- 3) Insert gasket over pipe or fitting until end of the pipe or fitting butts against the gasket's integrally molded shoulder.
- 4) Slide the coupling assembly over the gasket in a fashion as indicated in one of the picture showing general schematic for installation of couplings of all sizes.
- 5) Insert the second pipe or fitting into the gasket until both ends of pipe or fittings butt against the integrally molded shoulder in the center of gasket.
- 6) Slide the coupling assembly into position centered over the gasket. At this point, it is recommended to hand tighten all the clamps in the coupling assembly with a nut runner or wrench. Final tightening is described below.
- 7) Use a preset, or preferably, a dial indicating type torque wrench and tighten clamps to 60 inch-pounds of torque using the procedure below.
- 8) Coupling sizes 1 1/2", 2", 3", and 4" have two clamps.
 **Tighten clamp 1 and then clamp 2 alternately in 20 lbf-in increments until the recommended 60 lbf-in is reached.
- 9) Coupling sizes 5", 6", 8" and 10" have four clamps.
 ** First the inner clamps "A" are to be tightened alternately in 20 lbf-in increments until the recommended 60 lbf-in load is reached. Next, the outside clamps "B" are to be tightened alternately in 20 lbf-in increments until the recommended 60 lbf-in is reached.
 ** When O.D. difference between pipe and fitting is visibly different the following torque pattern is recommended 1-3, 2-4. (This Assumes min. Ø pipe is under 1 & 2 as shown, if not reverse sequence).



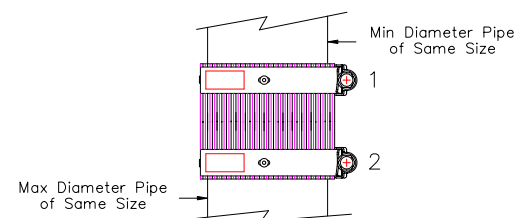
Sizes 1 1/2", 2", 3" & 4"



Sizes 5", 6", 8" & 10"

B. NOTES:

- 1) For installation details inside and outside building, see CISPI 310.



General Schematic for Installation of Couplings of All Sizes