Recommended practice for installation of Heavy Duty “HD” and Heavy Duty “MD” 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.

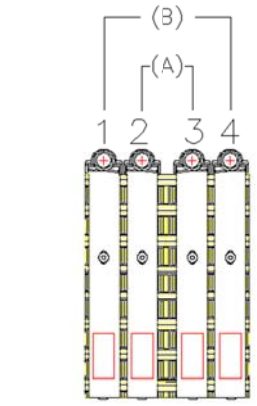
3) Insert gasket over pipe or fitting until end of pipe or fitting butts against the gasket’s integrally molded shoulder.

4) Slide the coupling assembly over the other pipe or fitting to be joined.

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 the clamp and shield assembly with a wrench.

   Final tightening is described below.

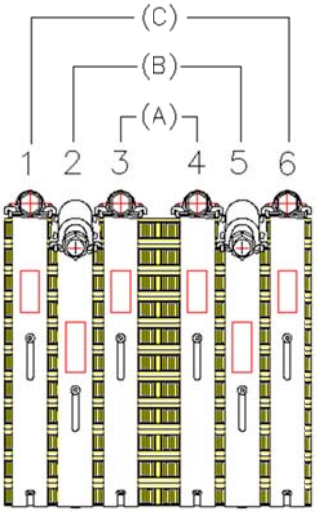


Sizes 1 1/2”, 2”, 3” & 4”

7) Use a preset, or preferably, a dial indicating type torque wrench and tighten clamps to 80 inch-pounds of torque using the procedure below.

8) Coupling sizes 1 ½", 2", 3", and 4" have four clamps.
   **First the inner clamps “A” are to be tightened alternately in 20 lbf-in increments until the recommended 80 lbf-in is reached. Then, the outer clamps “B” are tightened alternately in 20 lbf-in increments until the recommended 80 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. ∅ pipe is under 1 & 2 as shown, if not reverse sequence).



Sizes 5”, 6”, 8” & 10”

9) Coupling sizes 5", 6", 8" and 10" have six clamps.
   ** First the inner clamps “A” are to be tightened alternately in 20 lbf-in increments until the recommended 80 lbf-in is reached. Next, the middle clamps “B” are to be tightened alternately in 20 lbf-in increments until the recommended 80 lbf-in is reached. Finally, the outer clamps “C” are to be tightened alternately in 20 lbf-in increments until the recommended 80 lbf-in is reached.

   ** When O.D. difference between pipe and fitting is visibly different the following torque pattern is recommended 1-4, 2-5, 3-6. (This Assumes min. ∅ pipe is under 1, 2 & 3 as shown, if not reverse sequence).

B. NOTES:

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

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