

The instructions are based on pipe grooved in accordance with SPF™ grooving specifications. Check pipe ends for proper groove dimensions and to assure that the pipe ends are free of indentations and projections which would prevent proper sealing.

ALWAYS USE A GRUVLOK® SPF/ANVIL™ LUBRICANT FOR PROPER COUPLING ASSEMBLY. Thorough lubrication of the external surface of the gasket is essential to prevent pinching and possible damage to the gasket. For temperatures above 150°F (65°C) use Gruvlok® SPF/Anvil™ Xtreme Lubricant™ and lubricate all gasket surfaces, internal and external. See Gruvlok SPF/Anvil Lubricants in the Technical Data section of the AnvilStar SPF catalog for additional important information.



1 Check and lubricate gasket
 Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok SPF/Anvil Xtreme Lubricant to the outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.



2 Gasket installation
 Slip the gasket over the one pipe, making sure the gasket lip does not overhang the pipe end.



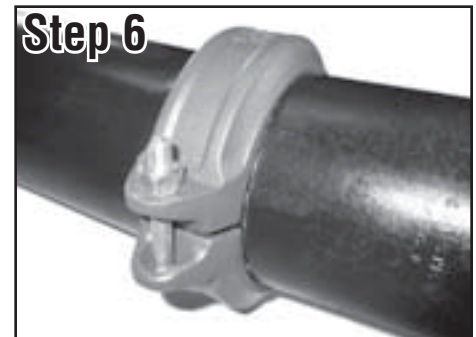
3 Alignment
 After aligning the two pipe ends together, pull the gasket into position, centering it between the grooves on each pipe. The gasket should not extend into the groove on either pipe.



4 Housings
 Remove one nut and bolt and loosen the other nut. Place one housing over the gasket, making sure the housing keys fit into the pipe grooves. Swing the other housing over the gasket and into the grooves on both pipes, making sure the tongue and recess of each housing is properly mated. Re-insert the bolt and run-up both nuts finger tight.



5 Tighten nuts
 Securely tighten nuts alternately and equally to the specified bolt torque, keeping the gaps at the bolt pads evenly spaced.
Caution: Uneven tightening may cause the gasket to pinch. Gasket should not be visible between segments after bolts are tightened.



6 Assembly is complete
 Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves. The bolt pads are to have equal gaps on each side of the coupling.

Specified Bolt Torque

Specified bolt torque is for the oval neck track bolts used on SPF™ couplings and flanges. The nuts must be tightened alternately and evenly until fully tightened.

Caution: Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

Caution: Proper torquing of coupling bolts is required to obtain specified performance. **Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation.** Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury.

| ANSI Specified Bolt Torque | | | Metric Specified Bolt Torque | | |
|----------------------------|-------------|------------------------|------------------------------|-------------|------------------------|
| Bolt Size | Wrench Size | Specified Bolt Torque* | Bolt Size | Wrench Size | Specified Bolt Torque* |
| In. | In. | Ft.-Lbs | mm | mm | N-M |
| 3/8 | 11/16 | 30-45 | M10 | 16 | 40-60 |
| 1/2 | 7/8 | 80-100 | M12 | 22 | 110-150 |
| 5/8 | 1 1/16 | 100-130 | M16 | 24 | 135-175 |
| 7/8 | 1 7/16 | 180-220 | M22 | 34 | 245-300 |

* Non-lubricated bolt torque * Non-lubricated bolt torque