

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
Place the smaller opening of the gasket over the smaller pipe. Angle the gasket over the pipe end and pull the gasket lip open around the circumference of the pipe. The center leg of the gasket should make flush contact with the pipe end and will prevent telescoping of the smaller pipe inside the larger.



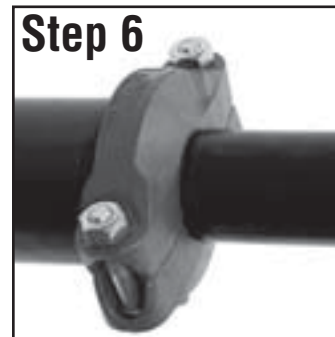
3 Alignment
Align the adjoining pipe center lines, and insert the larger pipe end into the gasket. Angle the pipe end slightly to the face of the gasket and tilt the pipe into the gasket to ease assembly.



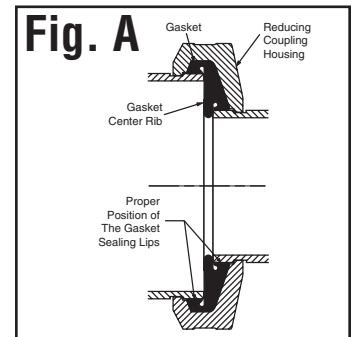
4 Housings
Place the coupling housing halves over the gasket, making sure the housing keys engage the grooves. Insert bolts and turn nuts finger tight.



5 Tighten nuts
Tighten the nuts alternately and equally to the specified bolt torque. The housing bolt pads must make metal-to-metal contact.
Caution: Uneven tightening may cause the gasket to pinch.



6 Assembly complete
Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.



Note: Fig. A illustrates the correct position of the Reducing Coupling gasket and housing properly assembled onto adjacent pipe ends.

Caution: In vertical installations the pipes must be supported to prevent telescoping during installation.

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		
Bolt Size	Wrench Size	Specified Bolt Torque*
In.	In.	Ft.-Lbs
1/2	7/8	80-100
5/8	1 1/16	100-130
3/4	1 1/4	130-180

* Non-lubricated bolt torque

Metric Specified Bolt Torque		
Bolt Size	Wrench Size	Specified Bolt Torque*
mm	mm	N-M
M12	22	110-150
M16	24	135-175
M20	30	175-245

* Non-lubricated bolt torque