



Flange Coupling Adapter

INSTALLATION GUIDE

PIPE ENDS

1. Measure pipe diameter at 4 locations 45 deg. apart. Difference between minimum and maximum measurement at the end of pipes should not exceed *(C). If the difference is greater than (C), make corrections by rounding the pipe with trench jacks, or suitable wooden post and wedges. Maintain this roundness until the joint is made up and all torqueing has been completed. *Refer to TABLE ON PIPE END TOLERANCES.

2. Pipe ends must be clean and free of all oil, dirt, loose scale & rust. A thorough cleaning with a wire brush is recommended. Any seam welds on pipe ends in the vicinity of the coupling must be ground smooth.

ASSEMBLY

3. Place end ring onto pipe end. If the end ring does not easily slip on pipe, correct pipe out-of-roundness with jacks or posts as noted above in 1.

4. The gasket should be cleaned and inspected for any damage in shipment. **Lubricate all the faces of the coupling gasket, center sleeve beveled end and the pipe with a certified potable lube.**

5. Slide the FCA center sleeve into position and have pipe inserted a minimum of 2.75" (recommend 4-4.5").

6. **IMPORTANT:** There should be no more than 1/8" gap or opening between the pipe OD and center sleeve ID. Wooden wedges or plastic shims may be used. These centering aids may be removed after the coupling is assembled. The wedges or shims must not project into the gasket pocket.

7. Be sure that the gasket pocket in the end ring is free from wood, dirt, metal or other field debris.

8. Push end ring against gasket and rotate the end ring until bolt holes line up.

BOLTING UP

9. **STAINLESS STEEL NUTS SHOULD BE FIELD LUBRICATED WITH A SUITABLE ANTI GALLING COMPOUND PRIOR TO BOLT TIGHTENING.** Insert all bolts, tighten nuts finger tight. It is convenient to tighten bolts by downward wrenching.

10. Be certain that the end ring fits over the center sleeve without any interference. If necessary, wedges may be used to free the end ring from the edge of the center sleeve.

11. On FCA's 60" and larger, 3 or 4 installers can best tighten. Have all installers advance in the same direction as they tighten each nut. A torque-limiting wrench must be used. Tighten to 30–35 ft/lbs all around, two or three times. Increase the wrench setting to 40–50 ft/lbs and continue the procedure to 75 ft/lbs for 5/8" bolts and 90 ft/lbs for 3/4" and larger bolts. At the maximum tightness, go around the FCA several times to assure uniform gasket pressure.

12. Before final tightening, it is good technique to strike each head with a hammer to seat all parts.

13. **AFTER FINAL TIGHTENING HAS BEEN COMPLETED,** remove all pipe roundup material.

TABLE ON PIPE END TOLERANCES

Pipe OD	(A) (+) TOL	(B) (-) TOL	(C) MIN MAX
12-42" follow AWWA C219-17, table 4			
44-72"	1/8"	1/16"	1/8"
73-96"	3/16"	1/16"	1/8"
97" & UP	1/4"	1/16"	1/4"

FLANGE COUPLING ADAPTERS DO NOT PROVIDE PROTECTION AGAINST PULLOUT OF PIPE.

ROBAR INDUSTRIES LTD.

www.robarindustries.com
waterworks@robarindustries.com

Surrey, British Columbia
Phone: 1-800-663-6553

Saint-Bruno, Quebec
Phone: 1-800-315-9525