



INSTALLATION INSTRUCTIONS

HYMAX® LARGE AND X-LARGE

COUPLING AND LONG BODY 14"- 60" (2-LAYER GASKET)

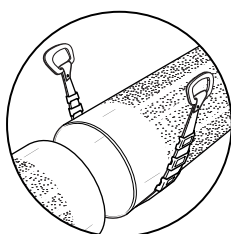


DO NOT DISASSEMBLE THE COUPLING. DO NOT LUBRICATE THE BOLTS

GENERAL INSTRUCTIONS:

THE LARGE AND X-LARGE DIAMETER HYMAX COUPLING IS A STAB-ON TYPE COUPLING.

STEP 1

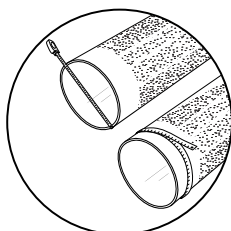


Prepare the pipe ends. Clean and de-scale each pipe end. Remove any debris or build up on the pipe ends. Clean the outer pipe surface with water. Clean each pipe end to a length of the coupling body.

For the HYMAX LONG BODY, follow the same instructions, cleaning the pipe ends to a length of the coupling body. Make sure there is no corrosion on the outer pipe ends that could affect the gasket seal. Again, clean each pipe end with water.

A suitable water-based gasket lubricant must be used on rough surfaced pipe (uncoated ductile iron, cast iron and A/C) to ensure proper tight seal. From size 24" and up, all pipes must be lubricated.

STEP 2



Measure the pipe's outer diameter and make sure the coupling being used has the proper OD range. Always use an OD tape to ensure that you are using the proper size coupling

NOTE: Each coupling's size range is shown on the product's label. Ensure the pipe is not out-of-round, and that it is free of scratches, dents, flats or other defects which may interfere with the coupling's proper seal. The coupling may not fit well or function properly on a pipe which is not round or is damaged.

STEP 3

Carefully remove the coupling from its packaging. Inspect the coupling and end rings for shipping damage and assure that there are no missing parts.

NOTE: The Hymax Coupling is a stab-on type coupling. Do not remove the end ring bolts.

NOTE: Bolts are pre-lubricated with a dry coating. Do not lubricate the bolts and nuts. Greasing or lubricating bolts or nuts voids manufacturer's warranty.

Inspect the coupling, if the end rings are not centered on the coupling, DO NOT USE. Contact your distributor for return and replacement!

DO NOT attempt to hammer the end ring into place! This will damage the end ring and void the Warranty!

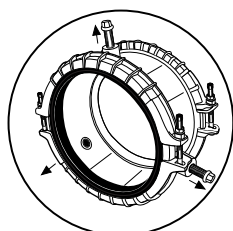
STEP 4



Mark the pipe ends according to the following stab depths, with two lines on each pipe end (minimum and maximum):

Coupling Size	Minimum stab depth	Maximum stab depth
14"-48"	4"	5.3"
14"-24" long body	5.5"	8.5"
26"-60" long body	5.9"	9.5"

STEP 5



Unscrew the centering pins. Use an open-ended wrench or socket wrench to retract the centering pins. This allows the coupling to be stabbed over the pipe end without interference, and also allows for proper positioning.

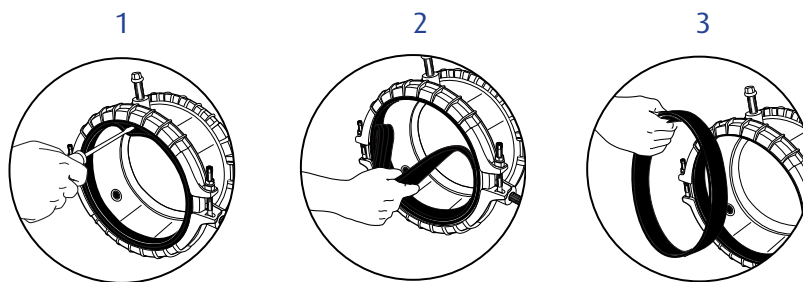
The centering pin has a CIRCLIP which stops it and prevents it from being pulled out.

STEP 6

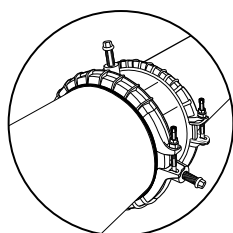
The coupling's gasket system has two layers, a removable inner gasket layer and a hydraulically assisted "outer gasket" layer. The "inner gasket" layer can be removed to accommodate larger OD pipes.

DO NOT remove the inner gasket unless the OD falls within the upper range of the coupling. The proper range sizes are shown on the product label. If the inner layer of the gasket must be removed, separate the two layers and break the parting line by inserting a screwdriver (1) between the two layers, peel the gasket layer (2) and pull it out of the coupling (3).

NOTE: Measure the OD of the pipe TWICE using an OD tape! Once the inner gasket is removed it can NOT be re-installed!



STEP 7

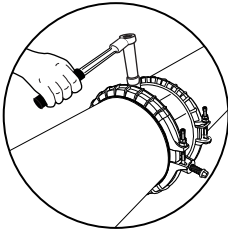


Positioning the Coupling for installation. If possible, place the coupling(s) on the replacement pipe (on both ends) and lower the pipe and couplings into the ditch. Slide the couplings outward so that they cover the minimum marks made in Step (4).

Make sure there is sufficient space between the pipe ends inside the coupling so the centering pins do not touch the pipe and continuous dynamic deflection (CDD) can take place.

NOTE: All pipes OD 24" and above must be lubricated.

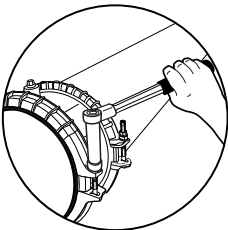
STEP 8



Set the centering pins. Secure the centering pins using an open- ended wrench or a socket wrench. Make sure the "o" ring on each centering pin seats properly beneath the pin head. Fully tighten the centering pins into the coupling body. The pins prevent the coupling from drifting along the pipe. They are not "set screws".

NOTE: Make sure the centering pins are between the two pipes.

STEP 9



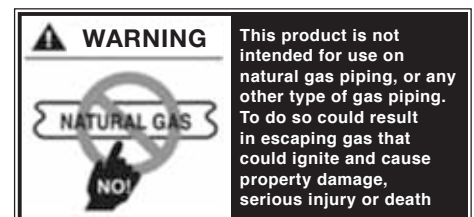
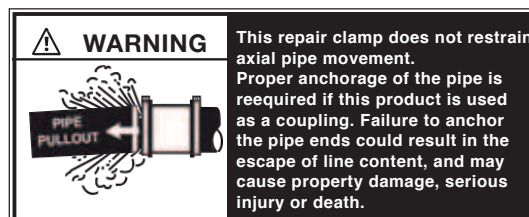
Tightening the end rings. Tighten the coupling bolts using a 15/16" socket wrench for 14"-24" couplings, and a 1.5" socket wrench for 26"-60" couplings. Tighten the bolts evenly on each end ring in an alternating pattern to the torque mentioned on the label. Cross-tightening ensures that the gasket is evenly seated. When you finish, re-check the torque again.

DO NOT LUBRICATE BOLTS!

NOTE: Use of a torque wrench is required! The torque wrench will verify that the proper torque has been achieved. Refer to the product label for the proper torque settings.

STEP 10

Recharge the line and check for leaks. If any leakage across the seal end is evident, reduce the pressure in the line and increase the labeled torque of the end ring bolts by up to 50%.



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