

Steel Pipe Couplings Fig. 336 Merchant Couplings

Figure 336 Standard, Full & Half



			Outside		Length					Unit Weight							
Size		Diameter (Coupling)		Full		Half		Threads		Full				Half			
										Straight Tapped		Taper Tapped		Straight Tapped		Taper Tapped	
NPS	DN	in	mm	in	mm	in	mm	in	mm	lbs	kg	lbs	kg	lbs	kg	lbs	kg
1/8	6	0.563	14	13/16	22	11/32	9	27	686	0.03	0.01	0.03	0.01	0.01	0.00	0.01	0.00
1/4	8	0.719	18	13/16	30	17/32	13	18	457	0.07	0.03	0.07	0.03	0.03	0.01	0.03	0.01
3/8	10	0.875	22	13/16	30	17/32	13	18	457	0.10	0.05	0.10	0.05	0.05	0.02	0.05	0.02
1/2	15	1.063	27	19/16	40	23/32	18	14	356	0.18	0.08	0.18	0.08	0.08	0.04	0.08	0.04
3/4	20	1.313	33	15/8	41	3/4	19	14	356	0.26	0.12	0.26	0.12	0.12	0.05	0.12	0.05
1	25	1.576	40	2	51	¹⁵ / ₁₆	24	111/2	292	0.42	0.19	0.42	0.19	0.18	0.08	0.18	0.08
11/4	32	1.900	48	21/16	52	31/32	25	111/2	292	0.50	0.23	0.50	0.23	0.23	0.10	0.23	0.10
11/2	40	2.200	56	21/16	52	31/32	25	111/2	292	0.67	0.30	0.67	0.30	0.32	0.15	0.32	0.15
2	50	2.750	70	21/8	54	1	25	111/2	292	1.03	0.47	1.03	0.47	0.47	0.21	0.47	0.21
21/2	65	3.250	83	31/8	79	1 ¹ / ₂	38	8	203	2.09	0.95	2.15	0.98	0.96	0.44	0.96	0.44
3	80	4.000	102	31/4	83	19/16	40	8	203	3.36	1.52	3.46	1.57	1.60	0.73	1.60	0.73
31/2	90	4.625	117	33/8	86	15/8	41	8	203	4.82	2.19	5.18	2.35	2.22	1.01	2.22	1.01
4	100	5.000	127	31/2	89	111/16	43	8	203	4.80	2.18	4.87	2.21	2.11	0.96	2.11	0.96
5	125	6.296	160	33/4	95	113/16	46	8	203	8.31	3.77	8.75	3.97	3.80	1.72	3.80	1.72
6	150	7.390	188	4	102	113/16	46	8	203	11.18	5.07	11.88	5.39	5.28	2.39	5.28	2.39

Manufactured in accordance with ASTM specification A865 and A589 threading in accordance with ASME B1.20.1.

Merchant couplings in sizes 1/8" NPS (6 DN) through 2" NPS (50 DN) are normally supplied straight tapped. Sizes 21/2" NPS (65 DN) and larger are taper tapped.

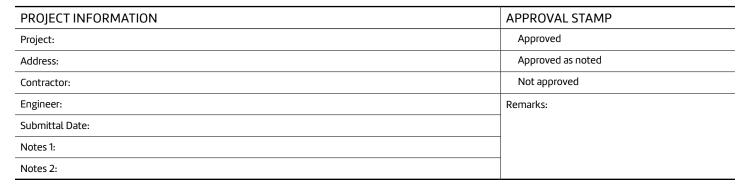
• Taper tapped standard merchant couplings in sizes 1/8" NPS (6 DN) through 2" NPS (50 DN) are available upon request.

• Couplings from 1/8" NPS (6 DN) through 6" NPS (150 DN) are dipped in rust preventative.

• Electroplated full couplings are also available.

• Working Pressure: 150 PSI.

Note: Half couplings are chamfered on one end and squared on the other.



An ASC Engineered Solution



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General Assembly of Threaded Fittings

1 Inspect both male and female components prior to assembly

- Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
- Clean or replace components as necessary.

2 Application of thread sealant

- Use a thread sealant that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
- Thoroughly mix the thread sealant prior to application.
- Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.

3 Joint Makeup

- For sizes up to and including 2" pipe, wrench tight makeup is considered three full turns past handtight. Handtight engagement for 1/2" through 2" thread varies from 41/2 turns to 5 turns.
- For 21/2" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 21/2" through 4" thread varies from 51/2 turns to 63/4 turns.

