

Steel Pipe Couplings Fig. 337 Merchant Couplings

Figure 337

Extra Strong (XS), Full & Half



Size		Outside Diameter (Coupling)		Length				Unit Weight			
NPS	DN	in	mm	Full		Half		Full		Half	
				in	mm	in	mm	lbs	kg	lbs	kg
1/8	6	0.563	14	1 ¹ / ₁₆	27	1 ¹⁵ / ₃₂	12	0.04	0.02	0.02	0.01
1/4	8	0.719	18	1 ⁵ / ₈	41	3/4	19	0.09	0.04	0.04	0.02
3/8	10	0.875	22	1 ⁵ / ₈	41	3/4	19	0.14	0.06	0.06	0.03
1/2	15	1.063	27	2 ¹ / ₈	54	1	25	0.25	0.11	0.11	0.05
3/4	20	1.313	33	2 ¹ / ₈	54	1	25	0.36	0.16	0.17	0.08
1	25	1.576	40	2 ⁵ / ₈	67	1 ¹ / ₄	32	0.56	0.25	0.26	0.12
1 ¹ / ₄	32	2.054	52	2 ³ / ₄	70	1 ⁵ / ₁₆	33	1.08	0.49	0.51	0.23
1 ¹ / ₂	40	2.200	56	2 ³ / ₄	70	1 ⁵ / ₁₆	33	0.98	0.44	0.61	0.28
2	50	2.875	73	2 ⁷ / ₈	73	1 ³ / ₈	35	2.01	0.91	0.92	0.42
2 ¹ / ₂	65	3.375	86	4 ¹ / ₈	105	2	51	3.53	1.60	1.72	0.78
3	80	4.000	102	4 ¹ / ₄	108	2 ¹ / ₁₆	52	4.61	2.09	2.12	0.96
3 ¹ / ₂	90	4.625	117	4 ³ / ₈	111	2 ¹ / ₈	54	6.25	2.84	2.97	1.35
4	100	5.200	127	4 ¹ / ₂	114	2 ³ / ₁₆	56	7.88	3.57	3.84	1.74
5	125	6.296	160	4 ⁵ / ₈	117	2 ³ / ₁₆	56	10.50	4.76	4.85	2.20
6	150	7.390	188	4 ⁷ / ₈	124	2 ³ / ₁₆	56	14.51	6.58	6.85	3.11

- Manufactured in accordance with ASTM Specification A865.
- All sizes are taper tapped, threading in accordance with ASME B1.20.1.
- Non-recessed couplings will be supplied for sizes under 6" NPS unless otherwise specified.
- Extra strong half couplings can be supplied in sizes under 6" NPS (150 DN).
- Couplings 1/8" – 6" NPS (6 – 150 DN) are dipped in rust preventative.
- Electroplated full couplings are also available.
- Working Pressure: 300 PSI.

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



PROJECT INFORMATION	APPROVAL STAMP
Project:	Approved
Address:	Approved as noted
Contractor:	Not approved
Engineer:	Remarks:
Submittal Date:	
Notes 1:	
Notes 2:	

Steel Pipe Couplings **Fig. 337** Merchant Couplings

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 ½" through 2" thread varies from 4½ turns to 5 turns.
- For 2½" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2½" through 4" thread varies from 5½ turns to 6¾ turns.