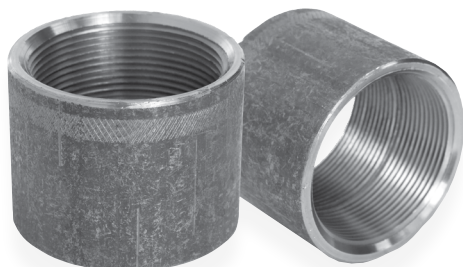


Steel Pipe Couplings Merchant Couplings

Figure 346

Standard, Right & Left



Size		Outside Diameter (Coupling)		Length		Unit Weight	
NPS	DN	in	mm	in	mm	lbs	kg
1/2	15	1.063	27	1 9/16	40	0.17	0.08
3/4	20	1.313	33	1 5/8	41	0.28	0.13
1	25	1.576	40	2	51	0.43	0.20
1 1/4	32	1.900	48	2 1/16	52	0.54	0.24
1 1/2	40	2.200	56	2 1/16	52	0.73	0.33
2	50	2.750	70	2 1/8	54	1.11	0.50

Note:

- The left hand threaded end of all right and left couplings is knurled for identification. All sizes of right and left couplings are taper tapped 3/4" per foot (62.5mm per meter) on the diameter and all are dipped in rust preventative.
- Threading in accordance with ASME B1.20.1.
- Working Pressure 150 PSI.

Figure 347

Extra Strong (XS), Right & Left



Size		Outside Diameter (Coupling)		Length		Unit Weight	
NPS	DN	in	mm	in	mm	lbs	kg
1/2	15	1.063	27	2 1/8	54	0.25	0.11
3/4	20	1.313	33	2 1/8	54	0.36	0.16
1	25	1.576	40	2 5/8	67	0.74	0.34
1 1/4	32	2.054	52	2 3/4	70	1.08	0.49
1 1/2	40	2.200	56	2 3/4	70	0.95	0.43
2	50	2.875	73	2 7/8	73	2.01	0.91

- The left hand threaded end of all right and left couplings is knurled for identification, and all are dipped in rust preventative.
- Extra strong right and left couplings are available on request.
- Threading in accordance with ASME B1.20.1.
- Working Pressure 300 PSI.



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

Steel Pipe Couplings 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.