



# INSTALLATION PROCEDURE

Recommended practice for installation of 12" and 15" Hubless Cast Iron Pipe Couplings manufactured by Ideal Clamp Products, Inc.

## A. Clamp & Gasket Installation:

- 1) Pipe ends are to be cut as squarely and smoothly as possible.
- 2) Check coupling and gasket for foreign material, clean if necessary.
- 3) Insert gasket over pipe or fitting until end of pipe or fitting butts against the gasket's integrally molded shoulder.
- 4) Slide the coupling assembly over the other pipe or fitting to be joined.
- 5) Insert the second pipe or fitting into the gasket until both ends of pipe or fittings butt against the integrally molded shoulder in the center of gasket.
- 6) Slide the coupling assembly into position centered over the gasket. At this point, it is recommended to hand tighten the clamp and shield assembly with a wrench.

Final tightening is described below.

- 7) Use a preset, or preferably, a dial indicating type torque wrench and tighten clamps to 120 inch-pounds of torque using the procedure below.
- 8) Coupling sizes 12" and 15" have six clamps.

\*\*First the inner clamps "A" are to be tightened alternately in 20 lbf-in increments until the recommended 120 lbf-in is reached. Next, the middle clamps "B" are tightened alternately in 20 lbf-in increments until the recommended 120 lbf-in is reached. Finally, the outer clamps "C" are to be tightened alternately in 20 lbf-in increments until the recommended 120 lbf-in is reached.

\*\*When O.D. difference between pipe and fitting is visibly different the torque pattern is recommended 1-4, 2-5, 3-6. (This assumes min.  $\emptyset$  pipe is under 1, 2, and 3 as shown, if not, reverse sequence.)

## B. Notes:

- 1) For installation details inside and outside building, see CISPI 310.

