Installation & Assembly - Fig. 7001 Standard Coupling

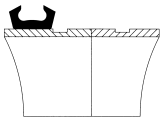
The instructions are based on pipe grooved in accordance with Gruvlok® grooving specifications. Check pipe ends for proper groove dimensions and to assure that the pipe ends are free of indentations and projections which would prevent proper sealing.

ALWAYS USE A GRUVLOK® LUBRICANT FOR PROPER COUPLING ASSEMBLY. Thorough lubrication of the external surface of the gasket is essential to prevent pinching and possible damage to the gasket. For temperatures above 150°F use Gruvlok Xtreme™ Lubricant and lubricate all gasket surfaces, internal and external. See Gruvlok Lubricants in the Technical Data section of the Gruvlok catalog for additional important information.

1 Check & lubricate gasket
Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

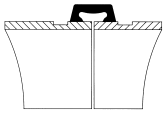
2 Gasket Installation
Slip the gasket over the pipe end making sure the gasket lip does not overhang the pipe end.

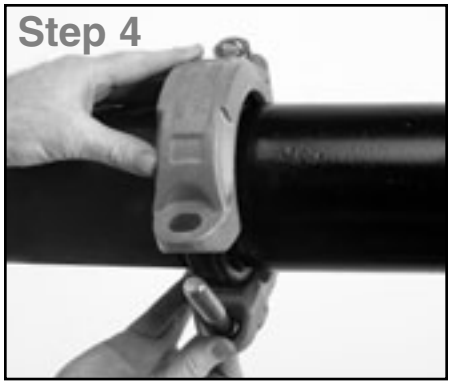
On couplings 10" and larger it may be easier to turn the gasket inside out-then lubricate and slide the gasket over the pipe end as shown.



3 Alignment
After aligning the two pipe ends, pull the gasket into position centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

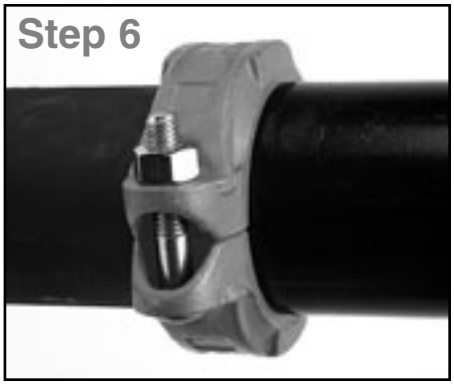
On couplings 10" and larger, flip or roll the gasket into centered position.





4 Housings
Place the coupling housing halves over the gasket making sure the housing keys engage the grooves. Insert bolts and turn nuts finger tight.

5 Tighten Nuts
Tighten the nuts alternately and equally to the specified bolt torque. The housing bolt pads must make metal-to-metal contact. CAUTION: Uneven tightening may cause the gasket to pinch.



6 Assembly is completed
Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.

Note: The housings for sizes 16" and larger are cast in four or more segments.
To install: loosely pre-assemble the segments into two “Housing Halves” making sure that the alignment tang(s) and slot(s) on the bolt pad(s) are properly mated. Install the “Housing Halves” as shown in steps 4 & 5. The coupling is properly installed when all bolt pads are firmly together - **Metal-to-Metal.**

Specified Bolt Torque

Specified bolt torque is for the oval neck track bolts used on Gruvlok® couplings and flanges. The nuts must be tightened alternately and evenly until fully tightened. **Caution:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

Caution: Proper torquing of coupling bolts is required to obtain specified performance. **Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation.** Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury.

ANSI Specified Bolt Torque

Bolt Size	Wrench Size	Specified Bolt Torque *
In.	*In.*	*Ft.-Lbs*
3/8	11/16	30-45
1/2	7/8	80-100
5/8	1 1/16	100-130
3/4	1 1/4	130-180
7/8	1 7/16	180-220
1	1 5/8	200-250
1 1/8	1 13/16	225-275
1 1/4	2	250-300

* Non-lubricated bolt torques

Metric Specified Bolt Torque

Bolt Size	Wrench Size	Specified Bolt Torque*
mm	*mm*	*N-M*
M10	16	40-60
M12	22	110-150
M16	24	135-175
M20	30	175-245
M22	34	245-300
M24	36	270-340

* Non-lubricated bolt torques