

# Installation Guide — AB&I Foundry No-Hub Couplings

## Bracing

To prevent movement, horizontal pipe and fittings 5 inches and larger should be suitably braced by the use of blocks, rodding or other suitable methods at every branch or change of direction.

## Test

For best results, testing of one floor (ten feet) at a time is recommended. If more than one floor at a time is tested, the system should be properly restrained; all bends, changes of direction and ends of runs should be restrained.

## Coupling Material

No-hub sealing sleeves (gaskets) are made of Neoprene conforming to ASTM C564. Chemical characteristics of Neoprene assure that the gasket will not decay or deteriorate from contact with effluents in the pipe, or chemicals in the soil or air around the pipe.

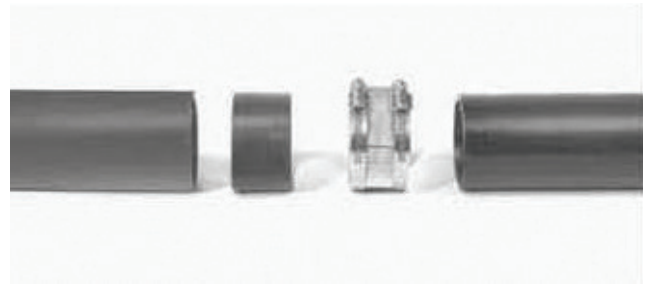
## Material Specifications

Bands: Type 301 AISI Stainless Steel — Minimum tensile strength 165,000 psi.

Screw Housing: Type 301 Stainless Steel, 5/16" hex head slant shoulder.

Shield: Type 301 AISI Stainless Steel — Bright annealed; Rockwell B-100 (Vickers 240) minimum.

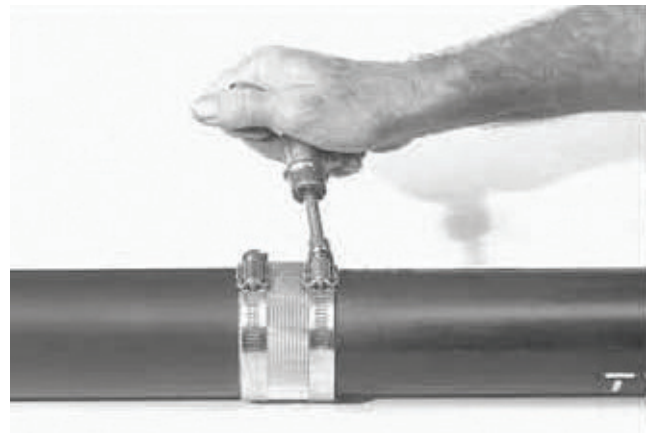
Sealing Sleeve (Gasket): The sealing sleeve shall be tested in accordance with ASTM D3677 and be manufactured from a properly vulcanized virgin compound where the primary elastomer is polychloroprene (neoprene).



1. Loosen screws, separate shield and sleeve. Slip shield over one spigot.



2. Insert spigots into sleeve. Be sure that both spigots butt on center retainer inside sleeve.



3. Position shield over sleeve, tighten screws alternately to proper torque.



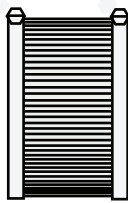
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## Before Joining

1. Couplings should be installed with a calibrated torque wrench set at 60 inch pounds (1½" – 10") or 80 inch pounds (12" & 15").
2. When using field-cut pipe, the ends should be cut square.

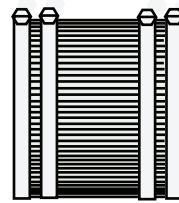
## Joining Procedure

1. Install the Neoprene sealing sleeve on one end of the pipe or fitting to be joined.
2. Place the stainless steel shield over the other end to be joined.
3. Insert both ends into the sealing sleeve until they butt against the molded center stop, inside the sealing sleeve.
4. Center the shield over the sealing sleeve and tighten as directed below.



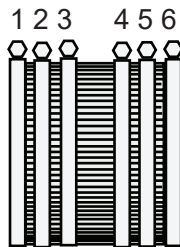
**1½", 2", 3", 4" sizes**

- A. Tighten bands alternately to 60 inch pounds torque



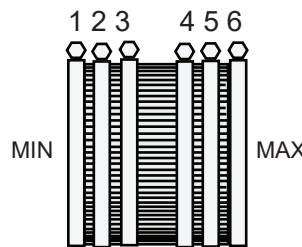
**5", 6", 8", 10" sizes**

- A. Tighten bands 2" – 3" alternately to 60 inch pounds torque
- B. Then bands #1 and #4 alternately to 60 inch pounds torque



**12" & 15" sizes**

- A. Tighten bands 3 and 4 alternately to 80 pounds torque
- B. Tighten bands 2 and 5 alternately to 80 inch pounds of torque
- C. Tighten bands 1 and 6 alternately to 80 inch pounds of torque



**Min-Max sizes**

- A. First torque the minimum side 3–2–1 and 3–2–1 again
- B. Then torque the maximum side 4–5–6 and 4–5–6 again
- C. Finally, torque 3–2 and 4–5 to 80 inch pounds

**ALL HORIZONTAL PIPE AND FITTINGS, 5 INCHES AND LARGER, SHOULD BE BRACED TO PREVENT MOVEMENT AT EVERY BRANCH OR CHANGE OF DIRECTION**

