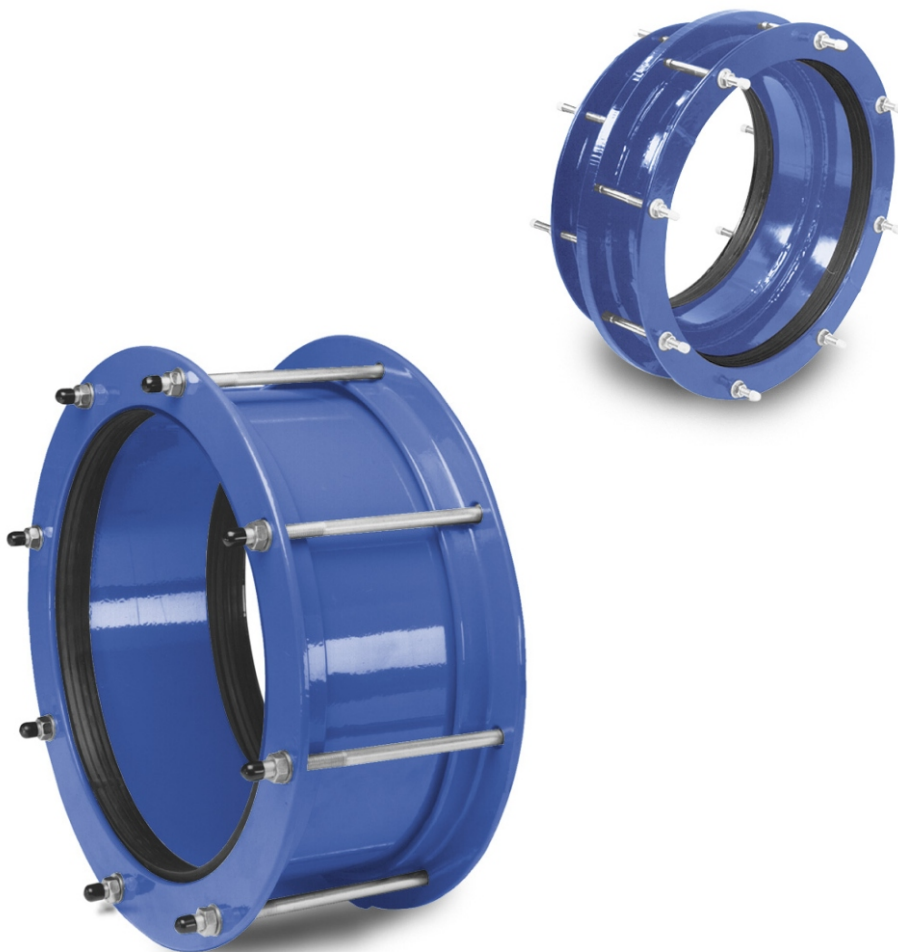


# AVK FABRICATED COUPLINGS

258  
259

## OPERATION & MAINTENANCE MANUAL



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The designs, materials and specifications shown are subject to change without notice due to our continuing programme of product development.

## FITTING INSTRUCTIONS:

*All of the following procedures must be carried out with due regard to relevant Road Traffic Act Guidelines, Health and Safety and COSHH directives.*

### Checks to be made prior to installation:

- 1) Confirm the actual outside Diameter of pipe ends to which the fitting is to be assembled.
- 2) Check that the pipe ends are smooth (free from dents, weld seams and score marks etc....)
- 3) Ensure that the sealing areas on the pipe ends are cleaned by wire brushing removing all scale, rust, protective coating and general debris etc...
- 4) Confirm that fitting to be assembled is fit for purpose with regard to type, pressure rating, sealing range, flange ratings and medium conveyed etc...
- 5) Ensure that working area is sufficient to allow comfortable access and installation.
- 6) Check that all necessary tooling is readily available, including torque wrench, box spanners, WRc approved lubricant etc...
- 7) Check that it has not been damaged during transit / storage.

### Installation:

- 1) Position pipe ends to be coupled, checking the level and concentricity to each other, adjust trench bed or pipe supports as required. In the event of a spool piece being assembled it is important that independent permanent support is provided to ensure that no external forces are imposed onto the coupling assemblies.

NOTE : In the event of backfilling the trench, adequate permanent support must be provided to the spool piece inline with standard working practices, taking into account nature of subsoil etc...

- 2) To assist centering of coupling over pipe gap, mark pipe an equal distance from each end, approx. half the fitting length plus 25mm.
- 3) Dismantle the fitting, ensuring that all the components are kept clean throughout installation.
- 4) Slide gland ring over each pipe end, with seal housing facing pipe end.
- 5) Lubricate sealing area on each pipe end thoroughly with an approved lubricant, then slide the sealing ring over each pipe end, ensuring that the thick end is housed in the gland ring.
- 6) Position centre sleeve over pipe ends, adjusting free pipe to provide correct setting gap as listed below :

#### S258 Straight Coupling

DN 350 - DN 900 SETTING GAP = 25mm  
DN1000 - DN1630 SETTING GAP = 36mm

**NOTE: AVK couplings must be restrained properly before any end loads are applied either longitudinally or laterally. Failure to do so will result in "pipe pull-out".**

#### S259 Stepped Coupling

DN 350 - DN 900 SETTING GAP = 25mm  
DN1000 - DN1200 SETTING GAP = 36mm

- 7) Line up bolt holes in each gland ring, fit all bolts from same end, ensuring that the D-neck of the bolt locates in the elongated holes of gland ring, fit nuts and washers and tighten to finger tight.
- 8) Check that assembly is correctly positioned over pipe ends, then tighten diametrically opposed bolts one or two turns at a time, to ensure that seal compression is evenly applied within the fitting. Work around the coupling until the recommended bolt torque setting of 40NM is achieved.
- 9) On completion of bolt tightening, check that the coupling is still centrally positioned over pipe ends and that the gap between the pipe and inside Dia of gland ring is even all around.
- 10) It is advisable to recheck the torque settings overnight of initial assembly, in case of relaxation of the sealing element.
- 11) Should the product be used in an aggressive (e.g. Salt laden) environment please ensure that there is sufficient secondary corrosion protection applied before backfilling.