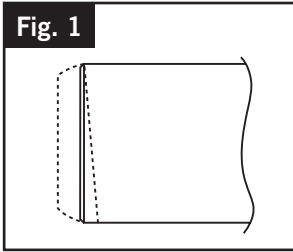


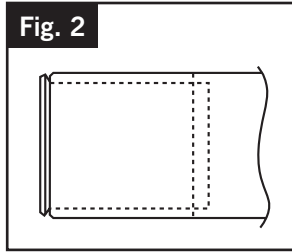
AquaGrip Coupling



1) Pipe End Preparation

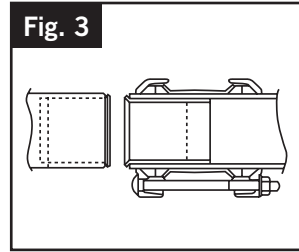
Cut pipe end square, remove any reversion. If required chamfer outside edge of pipe to aide assembly. Ensure pipe is free from any longitudinal score marks.

NOTE: Pipes should be expanded to original size after RollDown or Swage-Line Operations. If pipe has been coiled, it may be necessary to re-round prior to assembly.



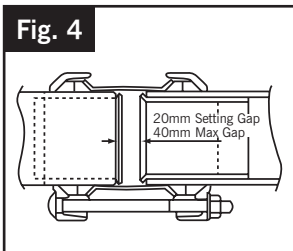
2) Liner Installation

Check that that the SDR rating of the liner is compatible with that of the PE pipe – in the event they are not Viking Johnson supply support liners as spares. Insert the liner fully into pipe ends until shoulders butt against pipe ends. Mark each of the two pipes 100mm back from the ends to assist step 4.



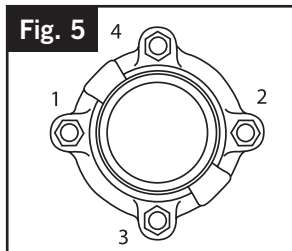
3) Pipe Alignment

Do not dismantle the Coupling. Back all nuts off one or two turns and slide the Coupling completely over one pipe end. Bring the two pipe ends into alignment.



4) Centralise

Slide coupling over both pipe ends and centralise using the marks made in step (2). Using marks from (2) ensure there is sufficient pipe entry on both sides, adjusting as necessary to achieve the setting gap as noted above.



5) Final Assembly

Working round the fitting evenly tighten diametrically opposed nuts (i.e. 1&2, 3&4), turning each one or two turns at a time. Continue working round until correct bolt torque as noted below is achieved on ALL nuts, verifying this with a calibrated torque wrench, which must “break” without turning the nut.

Bolts Details	
Bolt Size	M12
Spanner size	19mm A/F
Bolt torque	55 to 65Nm.