

MegaFit Couplings & Flange Adaptor

- 1) Examine the pipe ends and ensure they are round, smooth, free from bulges, dents and score marks and within the outside diameter range given on the coupling label. Weld beads must be ground flush, maintaining correct surface profile. Ensure that pipe ends are free from scale, rust, or any loose debris or other surface defect that may affect coupling performance.
- 2) Check grade of gasket is suitable for the conveyed medium.
- 3) Align pipe to be laid with pipe already in position, taking care that pipe ends are concentric, adjusting support or trench bed as necessary.
- 4) Please mark the insertion depth T on the pipes.
- 5) Couplings and flange adaptors are pre-assembled and should not be disassembled before use.
Do not lubricate or apply grease.

6a) Couplings

Align the pipes and centralise the MegaFit Coupling over both pipe end, ensuring that both pipes are inserted to a depth between T(min) and T(max) as shown in Table 1.

6b) Flange Adaptors

Slide the MegaDaptors onto the pipe end. Align the pipe and MegaDaptor with mating flange, fit flange connecting gasket (Viking Johnson recommend using an IBC Gasket for optimum sealing) and flange connecting bolts. Ensure pipe is inserted to a depth between T(min) and T(max) as shown in Table 2, adjust if necessary. Tighten flange connecting bolts using standard procedures.

- 7) Tighten diametrically opposed bolts on the coupling / flange adaptor giving the nuts one or two turns at a time to draw up the end rings evenly. The bolts must be thoroughly tightened to the figures given on the right, working around the coupling or flange adaptor as many times as necessary. On completion, the radial gap between pipe and coupling or flange adaptor ends should be even all the way round. Rubber may be seen to extrude into the gap. See Table 3 for bolt torques.

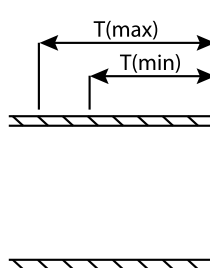


Table 1 - Couplings

DN	OD Tolerance Range (mm)		Insertion Depth (mm)	
	min	max	T (min)	T (max)
50	43.5	63.5	80	95
65	63.0	83.7	80	95
80	85.7	107.0	75	110
100	107.2	133.2	75	120
125	132.2	160.2	75	120
150	158.2	192.2	90	145
175	192.2	226.9	90	145
200	218.1	252.1	90	145
250	266.2	300.2	90	185
300	315.0	349.0	90	185

Table 2 - Flange Adaptors

DN	OD Tolerance Range (mm)		Insertion Depth (mm)	
	min	max	T (min)	T (max)
50	43.5	63.5	80	90
65	63.0	83.7	80	90
80	85.7	107.0	80	110
100	107.2	133.2	85	110
125	132.2	160.2	90	120
150	158.2	192.2	100	125
175	192.2	226.9	100	150
200	218.1	252.1	100	150
250	266.2	300.2	100	180
300	315.0	349.0	100	180

Table 3 - Bolt Torque

Stud / Bolt Size	Torque	
	lbf.ft	Nm
M12	40-50	55-65
M16	70-90	95-110



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