Style 440 Joint Harness

One Harness Assembly Set will have the following components:

- Insulating Joint Harness with Deflection Ring (Fig. 1) – one stud; two lugs; one insulated deflection ring assembly, and one lug adapter.
- Conductive Joint Harness with Deflection Ring (Fig. 2) – one stud; two lugs; one conductive deflection ring assembly, and one lug adapter.
- Conductive Joint Harness (Fig. 3) – one stud; two lugs; two lug adapters.

(Note: This Joint Harness does not meet requirements of D.O.T. Regulation Part II, Section 192.273, since it does not have a deflection ring. Deflection ring will accommodate 1/8" longitudinal movement per deflection.

1. Determine lug location from the following chart:

<table>
<thead>
<tr>
<th>Coupling Middle Dimensions From Pipe End</th>
<th>Ring Length</th>
<th>Stud Length</th>
<th>To First Point of Lug</th>
</tr>
</thead>
<tbody>
<tr>
<td>5&quot; Long</td>
<td>26&quot; Long</td>
<td>6-3/8&quot;</td>
<td></td>
</tr>
<tr>
<td>7&quot; Long</td>
<td>32&quot; Long</td>
<td>8-1/2&quot;</td>
<td></td>
</tr>
<tr>
<td>12&quot; Long</td>
<td>44&quot; Long</td>
<td>14-1/2&quot;</td>
<td></td>
</tr>
<tr>
<td>16&quot; Long</td>
<td>44&quot; Long</td>
<td>14-1/2&quot;</td>
<td></td>
</tr>
</tbody>
</table>

Lugs must be equally spaced around circumference of pipe and directly opposite each other on opposite pipe ends. Not on applications where coupling is already installed, locate lugs an equal distance from each end of coupling. The overall distance between the face of lugs to be determined by the length of the studs used.

2. Prepare pipe surface for lug welding. Remove deflection ring assemblies from lugs. Weld lug to pipe using 1/4" fillet weld for .250" lug (5/8" diameter stud) and 3/8" fillet weld for .375" lug (3/4" diameter stud) – see sketch. Lugs must be welded at all inside and outside edges.

3. For Insulating Joint Harness: Insert insulating deflection ring assembly into lug located on pipe to be insulated and lug adaptor into opposite lug. Insert stud and run nuts up finger tight.

4. For Conductive Joint Harness: Insert conductive deflection ring assembly in one lug and lug adaptor in the other lug. Insert stud and run nuts up finger tight. When harness assembly does not require deflection ring assembly, use two lug adaptors and install as noted above.

CAUTION: It shall be end-user responsibility for determining that standards of good welding practice are followed and that all requirements of D.O.T. Minimum Safety Standards have been completely satisfied.

5. Conversion: To convert a conductive harness to insulating, on the pipe to be insulated, remove the conductive deflection ring assembly and insert an insulating deflection ring assembly and follow the procedure under Step 3 above.

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