Style 711 Insulating Couplings
For PE* to Steel and Steel to Steel Pipe

1. Clean steel pipe end(s) removing oil, dirt, loose scale, and rust; gasket should seat on bare metal. Pipe ends must be cut square. Polyethylene pipe must be free of dirt, longitudinal scratches, grooves and burrs.

2. On all P.E. pipe ends, the recommended insert stiffener must be installed. Before inserting in pipe end, each insert should be checked to ensure that the SDR indicated on the insert branding corresponds to the SDR of the pipe being used.

3. Install proper insert in the P.E. pipe end.

4. For the purpose of proper pipe insertion in coupling, mark pipe end as shown in chart.

5. Remove plastic spacer ring from inside coupling.

6. Check inside of coupling to assure gaskets and grip rings are free of dirt or foreign matter.

7. After gaskets are clean, apply soap water to gaskets and pipe ends (anti-freeze should be added in freezing weather).

8. Without disassembling, stab coupling completely onto one pipe.

9. While holding plastic spacer ring between pipes, slide the coupling back over other pipe end and align with marks on pipes. Pipe end gap shall be approximately 2".

10. Tighten nuts uniformly and evenly in a crisscross pattern until all bolts are tightened to 35 ft. lbs. minimum on the 1-1/4" size, and 80 ft. lbs. torque minimum for all other sizes.

11. Should field coating be desired, do not box coat with hot enamel coating.

CAUTION!

Note 1 - For wall thickness greater than SDR listed, contact Dresser for recommendation.
Note 2 - Pullout resistance is based on using reinforcing pipe inserts that conform to Dresser specifications.
Note 3 - Unless noted on body.
Note 4 - For reducing sizes, the rating for the smallest diameter end applies. All sizes of reducing couplings are rated to 150 psig max.

*Polyethylene Pipe as listed in ASTM-D2513

NOTES:
1. The pipe joint using this coupling must be considered rigid, non-flexible connection.
2. Always assemble the insulating end of the coupling onto the steel pipe end.

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