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 couplings, mark each pipe 6" from pipe end.

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

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

7. Without disassembling, stab coupling to mark on pipe.

8. Stab other pipe to mark located on pipe end.

9. Tighten nuts uniformly and evenly in a crisscross pattern. Apply only one or two turns at a time, up to a final torque of 90 ft. lbs. minimum on all sizes.

Style 711 10" and 12" IPS Couplings

For Steel to PE*, PE to PE 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 couplings, mark each pipe 6" from pipe end.

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

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

7. Without disassembling, stab coupling to mark on pipe.

8. Stab other pipe to mark located on pipe end.

9. Tighten nuts uniformly and evenly in a crisscross pattern. Apply only one or two turns at a time, up to a final torque of 90 ft. lbs. minimum on all sizes.

NOTES: The pipe joint using this coupling must be considered a rigid, non-flexible connection.

*Polyethylene Pipe as listed in ASTM-D2513