Style 711 Long Body Couplings
For PE* to PE, PE to Steel and Steel to Steel Connections

1. Clean the steel pipe ends removing oil, dirt, loose scale, and rust; the gasket should seat on bare metal. Polyethylene pipe must be free of dirt, longitudinal scratches, grooves and burs.

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 branding corresponds to the SDR of pipe being used.

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

4. For insertion: Polyethylene pipe 6" and smaller should be marked 4" from pipe end; 8" polyethylene pipe should be marked 5" from pipe end. Steel pipe 6" and smaller, mark pipe for a minimum pipe entrance of 3-1/2"; for 8" steel pipe, mark pipe for a minimum pipe entrance of 4-1/2"; for 12" steel and polyethylene pipe, mark pipe for a minimum pipe entrance of 6".

5. Check the inside of the coupling to assure that 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, applying one or two turns to a nut at a time, up to a final torque of 35 ft. lbs. minimum on the 1-1/4" size, and 80 ft. lbs. minimum on sizes 2" thru 12".

10. If field coating is desired, do not box coat with hot enamel coating.

*Polyethylene Pipe as listed in ASTM-D2513