

BIBBY-STE-CROIX

Method of Assembly

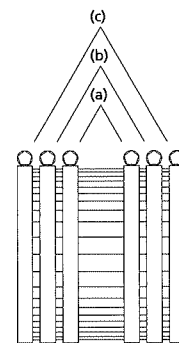
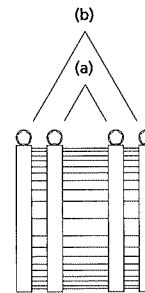
Husky® SD 4000 Heavy Duty Couplings

The HUSKY® SD 4000 is designed to be installed by using a properly calibrated torque wrench preset at 80 inch pounds. The special $\frac{3}{8}$ " hex screw head will accommodate only the proper tightening tool.

Assembly

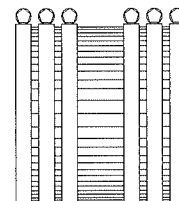
1. In order to provide a sound joint with field cut lengths of pipe, the ends should be cut square. Place the Neoprene gasket on the end of one pipe and the stainless steel clamp assembly on the end of the other pipe or fitting to be joined.
2. Firmly seat both ends of the pipe/fittings against the integrally molded shoulder in the centre of the gasket.
3. Slide the clamp assembly into position centred over the gasket. At this point, it is recommended to take the "slack" out of each sealing band by pre-tightening the clamps with the wrench to "hand tight". Final tightening is described below.
4. HUSKY® coupling sizes 1 1/2", 2", 3" and 4" are three inches wide and have four sealing bands.
 - A. First, tighten the inner bands (a) alternately and firmly to 80 inch pounds.
 - B. Next, tighten the outer bands (b) alternately and firmly to 80 inch pounds.
5. HUSKY® coupling sizes 5", 6", 8" and 10" are four inches wide and have six sealing bands.**
 - A. Start by tightening the innermost bands (a) alternately and firmly to 80 inch pounds.
 - B. When this is completed, move outward to the next set of bands (b) and tighten alternately and firmly to 80 inch pounds.
 - C. Finally, tighten the outermost bands (c) alternately and firmly to 80 inch pounds.

**Note: With maximum/minimum pipe and fittings condition (when O.D. difference exceeds 0.15 inch). Follow step 1, 2 and 3 then follow torque pattern at right.



VARIABLE O.D.'S

MIN.	MAX.
1 2 3	4 5 6



SIZES 5,6,8 AND 10
Torque as follows:
3,2,1 3,2,1 Then
4,5,6 4,5,6 Then
2,1 4,5,6

