

Fig. 7305 HDPE Coupling



Read and understand all instructions before use.

WARNING

Ensure system is drained and depressurized before installation or service.

Use appropriate personal protective equipment.



Failure to follow these instructions could result in serious personal injury and/or property damage.

1 Pipe Preparation

Ensure the HDPE pipe ends are square cut to $\frac{1}{8}$ " maximum for 2" to 4" sizes and $\frac{5}{32}$ " maximum for 6" sizes and larger. Ensure the gasket seating surface on each pipe end is clean and smooth for proper gasket sealing. Mark each pipe at a distance from the end as follows:

Size Inches	Distance to Mark
In./mm	In./mm
2-4 (51-102)	2 (25.4)
5-12 (127-305)	1½ (38.1)
14-18 (355-457)	1¾ (44.5)

CAUTION: For proper coupling performance, the gasket seating surface of each pipe end must be free of scratches, indentations, projections, or other imperfections that could prevent proper sealing of the gasket.

2 Check & Lubricate Gasket

Check to assure the gasket material is acceptable for the intended service. The Gasket color code is green for EPDM and orange for Nitrile (Buna-N).

CAUTION: Use only Guvlok Xtreme™ Lubricant. Guvlok Xtreme Lubricant contains silicone. If silicone is unacceptable for the application contact Guvlok for the lubrication recommendation. Apply a thin coating of Guvlok Xtreme Lubricant to the gasket lip and the exterior surface of the gasket.

3 Gasket Installation

Slip the gasket over one of the pipe ends. Make sure the gasket does not overhang the pipe end. Align the second pipe and while keeping the pipes in the butted position slide the gasket back over the second pipe end. The gasket must be positioned centrally between the lines on the pipe ends.

4 Housings

Place the Figure 7305 housing casting over the gasket, making sure the tongue on one casting is aligned with the recess of the other casting.

5 Tighten Nuts

Insert the bolts and secure the nuts alternately and uniformly until the bolt pads make contact. Torque all bolts to the required bolt torque levels shown in the Specified Bolt Torque Table. Alternate and even tightening of the bolts will significantly reduce the torque needed to close the coupling.

CAUTION: To ensure proper performance, the Figure 7305 HDPE coupling should always be installed with the bolt pads making metal to metal contact.



Specified Bolt Torque

Specified bolt torque is for the oval neck track bolts used on Guvlok couplings. The nuts must be tightened alternately and evenly until fully tightened.

CAUTION: Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

CAUTION: Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury.

Specified Bolt Torque

Coupling Bolts	Minimum	Maximum
In./DN(mm)	In./mm	Lbs./kg
½ x 2⅜	80 110	100 150
½ x 3	80 110	100 150
⅝ x 3½	100 135	130 175
⅝ x 3¾	100 135	130 175
¾ x 4¾	130 175	180 245
1 x 5½	200 270	250 340



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