



Submittal No-Hub Couplings



Anaco No-Hub couplings meet CISPI 310 and ASTM C 1277. Couplings consist of a stainless steel shield, clamp assembly and a gasket manufactured from a properly vulcanized virgin compound in which the primary elastomer is polychloroprene (neoprene) conforming to ASTM C 564.

Compliant to BAA,TAA,ARRA & NAFTA.

The coupling is used to join hubless cast iron pipe and fittings made to CISPI 301 and/or ASTM A 888. Coupling sizes range from 1½” through 15” diameters. The stainless steel shield and clamp assemblies are corrosion resistant.

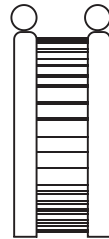
Material Specifications

- Clamp:** Type 301 AISI stainless steel
- Screw:** Type 305 AISI stainless steel 5/16 hex head for 1 ½”-10”, 3/8 for 12” &15”
- Shield:** Type 301 AISI stainless steel corrugated. Shield thickness 0.0075
- Housing:** Type 301 AISI stainless steel

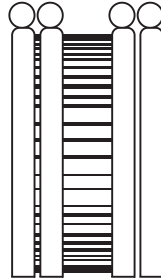
Gasket Test

Test	Physical Tests Min. or Max Requirements	ASTM Method
Tensile Strength	1500 psi min.	D412
Elongation	250 min.	D412
Durometer [Shore A]	70 ± 5 @ 76° F ± 5°F	D2240
Accelerated Aging	15% maximum tensile and 20% maximum elongation deterioration, 10 points maximum increase in hardness, all determinations after oven aging for 96 hours at 158°F	D573
Compression Set	25% maximum after 22 hours at 158°F	D395 Method B
Oil Immersion	80% maximum volume change after immersion in IRM 903 for 70 hours at 212°F	D471
Ozone Cracking	No visible cracking at 2 times magnification of the gasket after 100 hours exposure in 1.5ppm ozone concentration at 100°F. Testing and inspection to be on gasket which is loop mounted to give approximately 20% elongation of outer surface.	D1149
Tear Resistance	150 lbs. minimum per inch of thickness	D624
Water Absorption	20% maximum by weight after 7 days at 158°F	D471

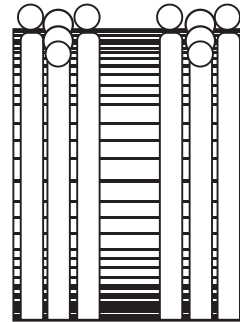
No Hub Couplings			
Size	Width	No. of Straps	Torque
1 ½" – 4"	2.125	2	60
5 & 6	3.0	4	60
8 & 10	4.0	4	60
12 & 15	5.50	6	80



Size 1-1/2"
thru 4"
TWO BANDS
Figure 1



Size 5", 6"
8" thru 10"
FOUR BANDS
Figure 2



Size 12"
AND 15"
SIX BANDS
Figure 3

Installation Instructions

1. After making the field cuts square and placing the ends of the pipes against the center-stop of the gasket, slide the clamp assembly into position centered over the gasket.
2. Using a torque wrench, tighten stainless steel screws alternately to 60-inch pounds torque for 1½" to 10" and 80-inch pounds torque for 12" & 15".
3. For 5" to 10" couplings, tighten inner bands first, then tighten outer bands.
4. For 12" & 15" couplings, tighten inner bands, center bands and outer bands. When min-max conditions exist, tighten each band starting on the smaller side: 3,2,1 and 3,2,1 again. Then torque the maximum side: 4, 5, 6 and 4, 5, 6 again. Finally, torque 2,1 on the minimum side and 4, 5, 6 on the maximum side. (See Figure 3 above)

Bracing

Horizontal pipe and fittings five inches and larger must be suitably braced to prevent horizontal movement. This must be done at every branch opening or change of direction by the use of braces, blocks, rodding or other suitable method, to prevent movement or joint separation. *(Chapter IV, Handbook Cast Iron Soil Pipe Institute)*