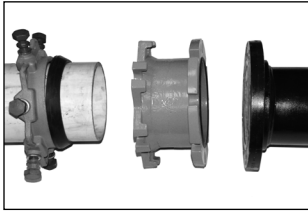




PVC StarFlange™ series 4200

Restrained Adapter Flange Coupling
for PVC Pipe
Sizes 3" - 36"

INSTALLATION INSTRUCTIONS - SIZES 3" - 36"

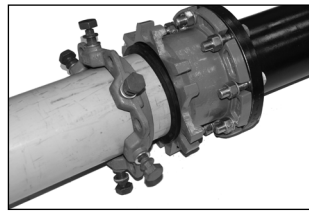


STEP 1

Check the StarFlange™ ensuring that no damage has occurred or parts are missing. Make sure that the ring gasket on the flange face of the StarFlange™ is securely in place.

The pipe end must be thoroughly cleaned for a distance of 2" greater than the length of the StarFlange™ body.

Slide the PVC Stargrip gland on the plain end of the pipe making sure that the lip extension is towards the mechanical joint bell of the StarFlange™.

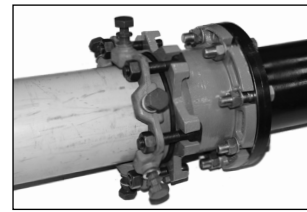


STEP 2

Brush both the gasket & the plain end of the pipe with soapy water or approved pipe lubricant, which meets ANSI/AWWA C111/A21.11. Slide the MJ gasket over the pipe with the beveled edge towards the MJ bell of StarFlange™.

Slide the StarFlange™ on to the pipe with the MJ bell towards the PVC Stargrip gland. Pipe must be inserted into the StarFlange™ a minimum length as indicated in the table to attain maximum deflection.

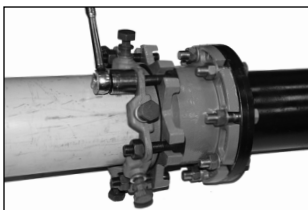
Position the pipe and flanged end of the StarFlange™ against the mating flange, making sure that the flange bolt holes line-up. Assemble the flanged joint using flange bolts. **Note: Flange bolts not supplied with StarFlange™. Refer TABLE B below for recommended Flange bolt torque values.**



STEP 3

Center the pipe so that the space between the OD of the pipe and the ID of the StarFlange™ is even all around the pipe.

Slide the MJ gasket into the MJ bell recess of the StarFlange™. Slide the PVC Stargrip towards the StarFlange™ with the gland lip against the gasket. Insert T-bolts and hand-tighten nuts.



STEP 4

In order to keep the spigot fully homed in the MJ bell, the joint will need to be kept in compression until the completion of step 6. Tighten the T-bolts to the normal range of bolt torque (see table).

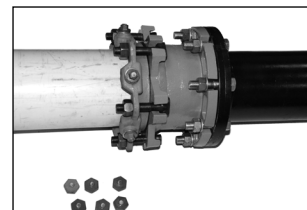
This may require multiple rounds. It is necessary that the gland be brought up toward the bell flange evenly, maintaining approximately the same distance between the gland and the face of the flange at all points around the socket. It is recommended to follow alternating star pattern while tightening T-bolts.



STEP 5

Tighten the torque limiting twist off bolts in a clockwise direction until all the wedges are in firm contact with the pipe surface.

Note: When installing sizes 4"-12" on IPS PVC pipe, the spacer washers must be removed from the torque limiting bolts.



STEP 6

Continue tightening in an alternating manner until all of the Torque-limiting twist-off bolt heads have been twisted off.

If removal is necessary, utilize the 5/8" hex head provided. If reassembly is required, assemble the joint in the same manner as above and tighten the wedge bolt to 90 ft-lbs.

PIPE SIZE (IN)	BOLT SIZE (IN)	RANGE ¹ OF TORQUE (FT-LBS)
3	5/8	45-60
4-24	3/4	75-90
30-36	1	100-120

¹These torque ranges are requirements of AWWA C600

SIZE (IN)	RANGE ¹ OF TORQUE (FT-LBS)
3	45 - 60
4	75 - 90
6	75 - 90
8	90 - 110
10 - 12	90 - 110
14 - 16	90 - 110
18 - 20	90 - 110
24	90 - 110
30 - 36	110 - 130

Notes:

- If effective sealing is not attained at the maximum torque indicated, then the joint should be disassembled, thoroughly cleaned, and reassembled. **Overstressing the bolts to compensate for poor installation practice is not acceptable.**
- For use on IPS PVC pipe, Transition MJ gasket must be used & removal of spacer washers from the torque limiting bolts must be ensured.
- Not to be used on DI or steel pipe.

JRCAT23.01



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