



JCM 306 Flange Coupling Adapter

INSTALLATION INSTRUCTIONS

1. Clean pipe surface of all dirt, rust, mud or loose scale from pipe ends. Inspect the pipe ends where gaskets will contact the pipe for any gouges, grooves, irregularities or imperfections that will interfere with the gasket seal. Measure the cleaned pipe diameter to confirm proper size of coupling for application. Inspection of the pipe's integrity for product application is the responsibility of the end user. ***TIP*** *Difficult to reach or cramped areas on the backside or underside of the pipe can be visually checked by using a mirror.*
2. Install follower ring, gasket and flanged adapter/coupling body onto the plain end of pipe. **NOTE:** Flat side of the gasket face meets the follower ring, the tapered side inserts into the adapter body. ***TIP*** *To ease installation of the gaskets, pipe should be lubricated with water or soapy-water mixture. Alcohol may be added to water in freezing weather. **DO NOT** use pipe lubricant or grease based products to lubricate.* Install the flanged plate with gasket and second follower ring onto pipe end. Make certain the tapered gasket is evenly inserted into the coupling middle ring.
3. Insert coupling bolts into followers and loosely make up the coupling on the pipe end making certain the pipe is fully inserted into the coupling. Mark pipe to make certain FCA does not slide during tightening.
4. Insert the valve bolts into the flanged adapter body facing toward the valve or flanged fitting end.
5. Align bolt holes of the FCA flange and the new equipment flange and loosely make up flange connection. Tighten flange bolts and nuts, alternating bolts in a star pattern.

Recommended Torque:

5/8" Bolts

75 Foot Pounds

6. **Lift the middle ring to insure that the gasket is evenly centered in the end.** Tighten FCA bolts to make up the coupling, alternating from side to side drawing the follower flange in evenly until all bolts have been tightened to 60 - 75 Foot Pounds. Check torque of bolts prior to completion.

Optional 306 Restrained Flange Coupling Adapter Set Screws are NOT RECOMMENDED for Asbestos Cement, PVC, HDPE, Fiberglass or any other types of non-rigid or brittle pipe materials. Inspection of pipe integrity is the responsibility of the end user. Use of restraining torque head set screws eliminates flexibility. The fitting is a rigid joint that will not accommodate deflection or movement after fitting installation.

7. Using a 12 point 7/16" socket wrench, evenly tighten all set screws until they are in contact with the pipe. Then alternately tighten them in a star pattern to approximately 50 Foot Pounds of torque. To complete installation, tighten all set screws in a star pattern until the special break away head shears off. This indicates that the pre-set optimum torque value of the set screw (80 -90 ft/lbs) has been reached. The 5/8" square head remaining of the set screw is for the convenience of removing the set screw should removal be necessary.

INT306-0207