

## ANGUS WELLMASTER 150 and 250 For sizes 38mm (1 1/2") to 152mm (6")

### Procedure for Coupling Assembly

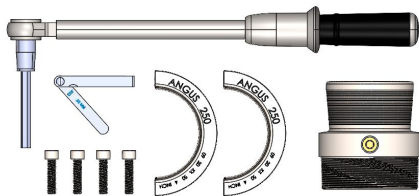
#### 1. Introduction

This sheet covers the assembly procedure for couplings fitted to WELLMASTER 150 and WELLMASTER 250 products regardless of the coupling material used.

*Please also refer to the latest edition of the Wellmaster Installation Manual for more details.*

#### 2. Assembly procedure

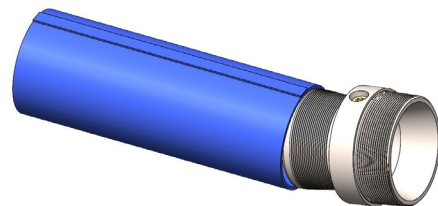
1.



Coupling components and required tools:

- Coupling body
- Coupling clamp segments
- Cap head screws
- Torque wrench
- Long range hex bit
- Feeler gauges

2.



- Cut end of riser square using either a knife, hacksaw or cutting disk.
- Clean the bore with a dry cloth.
- Push the riser onto the coupling body up to the shoulder.

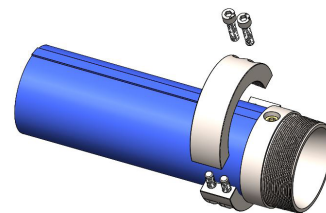
**DO NOT LUBRICATE**

3.



- For full length of coupling body taper carefully file/grind away the cable carrying strap until flush with the riser.
- Reinforcing yarns within the strap will be removed but caution should be taken not to file too much of the cover and expose the riser jacket.

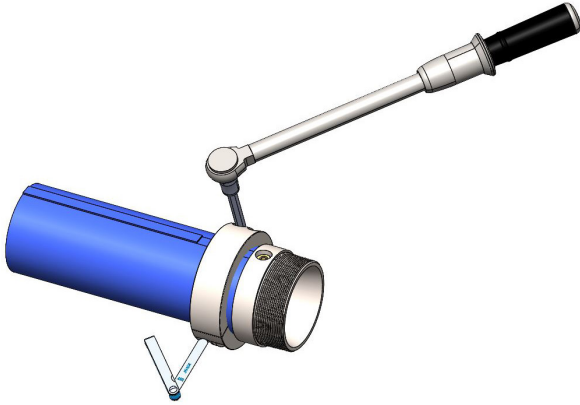
4.



- Centrally locate the coupling clamp segments over the tapered section of the coupling body. This is likely to fall between 5-20mm from the coupling body shoulder.
- The segments should be positioned such that the cable strap location or the hose lay-flat edge do not fall in the gap between the segments.

**NOTE:** The grooved portion on the inside of the clamps should be located towards the coupling body shoulder.

5.



- Tighten the cap head screws evenly to the recommended torque setting. See table in 6.
- Ensure an even gap of 0.1-1mm between clamps. If the incorrect gap results, remove clamps and relocate nearer or further away from the coupling body shoulder.

**IT IS IMPERATIVE THAT BOTH GAP AND TORQUE VALUES ARE CORRECT.**

6. SCREW TORQUE SETTINGS

Diameter	Nm	Ft-lb
32mm (1.1/4") - 4mm Allen Key	5.0	3.7
38mm (1.1/2") - 4mm Allen Key	5.0	3.7
51mm (2") - 5mm Allen Key *	6.0	4.4
76mm (3") - 6mm Allen Key *	14.0	10.0
102mm (4") - 8mm Allen Key	28.0	21.0
127mm (5") - 10mm Allen Key	46.0	34.0
127mm (5") HP - 14mm Allen Key	100.0	73.8
152mm (6") - 10mm Allen Key	46.0	34.0
152mm (6") HP - 14mm Allen Key	100.0	73.8
Blanking Plug/Break-off Plug - 8mm/10mm Allen Key	20.0	14.6