

ANGUS WELLMASTER 400 For sizes 76mm (3") to 152mm (6")

Procedure for Coupling Assembly

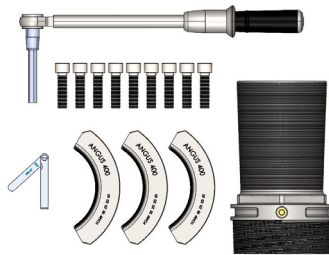
1. Introduction

This sheet covers the assembly procedure for couplings fitted to WELLMASTER 400 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

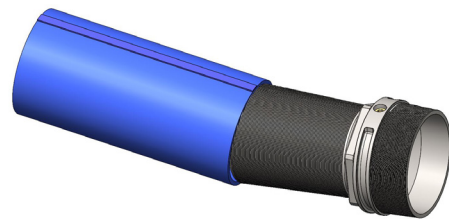
1.



Coupling components and required tools:

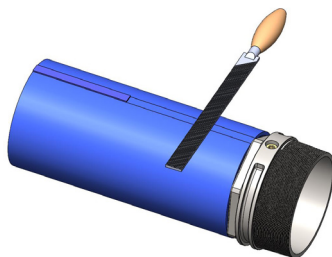
- Coupling body with blanking plug pre-installed
- Coupling clamp segments
- Cap head screws
- Torque wrench
- Long range hex bit
- Feeler gauges

2.



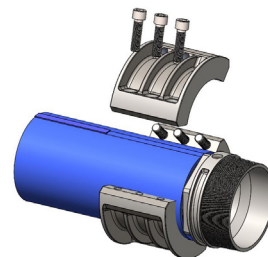
- Cut end of riser square using either a knife, hacksaw or cutting disk.
- Clean the bore with a dry cloth.
- Push the riser onto the coupling body up to the shoulder.
DO NOT LUBRICATE

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.

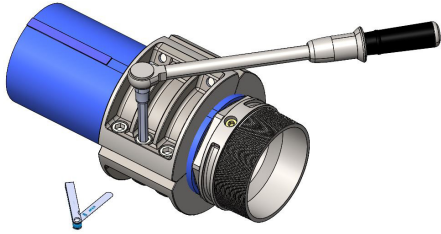
4.



- 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.

5.



6. SCREW TORQUE SETTINGS

Diameter	Nm	Ft-lb
76mm (3") – 6mm Allen key	14.0	10.0
102mm (4") – 8mm Allen key	28.0	21.0
152mm (6") – 14mm Allen key	100.0	73.8
Blanking Plug/Break-off Plug - 8mm/10mm Allen Key	20.0	14.6

- Tighten the cap head screws evenly to the recommended torque setting. See table in 6.
- Ensure an even gap of 0.1-1.0mm between clamps for 76mm (3") /102mm (4") and a gap of 1.0-2.0mm between clamps for 152mm (6"). 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.