

## ANGUS WELLMASTER 150 For sizes 200mm (8")

### Procedure for Coupling Assembly

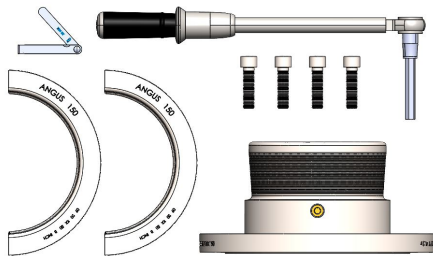
#### 1. Introduction

This sheet covers the assembly procedure for couplings fitted to 200mm (8") WELLMASTER 150 regardless of the coupling material used. Due to the very high weight involved when full of water, Angus suggests that a flanged coupling is used to connect to the pump and head works; however threaded versions are available.

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

#### 2. Assembly procedure

1.



2.



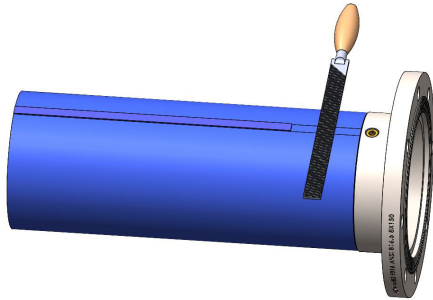
Coupling components and required tools:

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

- Cut end of riser square using either a knife, hacksaw or cutting disk.
- Due to the large diameter riser being cut in the lay-flat condition it may be necessary to cut the end of the riser into a convex arc, this will reduce any gaps between the end of the riser and the coupling shoulder. Starting the arc 10mm back from the end of the riser on the lay-flat edge should result in the correct shape.
- Clean the bore with a dry cloth.
- Push the riser onto the coupling body up to the shoulder.

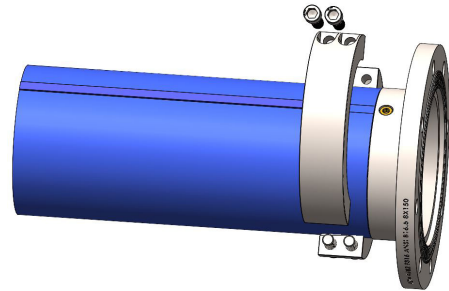
**DO NOT LUBRICATE**

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.

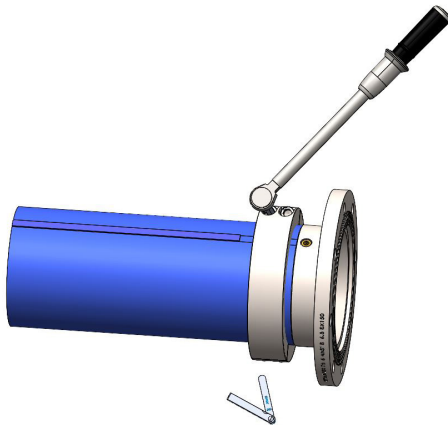
4.



- 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 0.1-1.0mm 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
200mm (8") Threaded – 10mm Allen key	46.0	34.0
200mm (8") Flanged – 14mm Allen key	100.0	73.8
Blanking Plug/Break-off Plug – 8mm/10mm Allen key	20.0	14.6