

## Steel Pipe Couplings - Merchant Couplings

**FIGURE 337**  
Extra Strong (XS),  Full &  Half



Size		Outside Diameter (Coupling)		Length				Unit Weight			
				Full		Half		Full		Half	
NPS	DN	in	mm	in	mm	in	mm	lbs	kg	lbs	kg
1/8	6	0.563	14	1 1/16	27	15/32	12	0.04	0.02	0.02	0.01
1/4	8	0.719	18	1 5/8	41	3/4	19	0.09	0.04	0.04	0.02
3/8	10	0.875	22	1 5/8	41	3/4	19	0.14	0.06	0.06	0.03
1/2	15	1.063	27	2 1/8	54	1	25	0.25	0.11	0.11	0.05
3/4	20	1.313	33	2 1/8	54	1	25	0.36	0.16	0.17	0.08
1	25	1.576	40	2 5/8	67	1 1/4	32	0.56	0.25	0.26	0.12
1 1/4	32	2.054	52	2 3/4	70	1 5/16	33	1.08	0.49	0.51	0.23
1 1/2	40	2.200	56	2 3/4	70	1 5/16	33	0.98	0.44	0.61	0.28
2	50	2.875	73	2 7/8	73	1 3/8	35	2.01	0.91	0.92	0.42
2 1/2	65	3.375	86	4 1/8	105	2	51	3.53	1.60	1.72	0.78
3	80	4.000	102	4 1/4	108	2 1/16	52	4.61	2.09	2.12	0.96
3 1/2	90	4.625	117	4 3/8	111	2 1/8	54	6.25	2.84	2.97	1.35
4	100	5.200	127	4 1/2	114	2 3/16	56	7.88	3.57	3.84	1.74
5	125	6.296	160	4 5/8	117	2 3/16	56	10.50	4.76	4.85	2.20
6	150	7.390	188	4 7/8	124	2 3/16	56	14.51	6.58	6.85	3.11

- Manufactured in accordance with ASTM Specification A865.
- All sizes are taper tapped.
- Non-recessed couplings will be supplied for sizes under 6" NPS unless otherwise specified.
- Extra strong half couplings can be supplied in sizes under 6" NPS (150 DN).
- Couplings 1/8" – 6" NPS (6 – 150 DN) are dipped in rust preventative.
- Electroplated full couplings are also available.

**Note**

- Half couplings are chamfered on one end and squared on the other.

PROJECT INFORMATION		APPROVAL STAMP	
Project:		<input type="checkbox"/> Approved	
Address:		<input type="checkbox"/> Approved as noted	
Contractor:		<input type="checkbox"/> Not approved	
Engineer:		Remarks:	
Submittal Date:			
Notes 1:			
Notes 2:			

## General Assembly of Threaded Fittings

- 1) Inspect both male and female components prior to assembly.
  - Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
  - Clean or replace components as necessary.
- 2) Application of thread sealant
  - Use a thread sealant that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
  - Thoroughly mix the thread sealant prior to application.
  - Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.
- 3) Joint Makeup
  - For sizes up to and including 2" pipe, wrench tight makeup is considered three full turns past handtight. Handtight engagement for 1/2" through 2" thread varies from 4 1/2 turns to 5 turns.
  - For 2 1/2" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2 1/2" through 4" thread varies from 5 1/2 turns to 6 3/4 turns.