

Fitting Instructions MaxiFit Couplings



**MaxiFit couplings are supplied ready assembled and should not be dismantled.
Size range: DN40 to DN600.**

- 1 Examine the pipe ends and ensure they are round, smooth, free from bulges, dents and score marks and within the outside diameter range given on the coupling label. Weld beads must be ground flush, maintaining correct surface profile. Ensure that pipe ends are free from scale, rust, or any loose debris or other surface defect that may affect coupling performance.
- 2 Check grade of gasket is suitable for the conveyed medium.
- 3 Align pipe to be laid with pipe already in position, taking care that pipe ends are concentric, adjusting support or trench bed as necessary.
- 4 To aid installation, mark both pipe ends at a distance equal to or greater than half the overall assembled width of the coupling. Place coupling wholly on one pipe end.
- 5 Adjust setting gap between pipe ends as necessary (see setting gap table). If in doubt contact Viking Johnson Technical Support.
- 6 Using marks made at step 4, slide the coupling to a central position over the pipe ends and commence bolt-up.
- 7 Tighten diametrically opposed bolts giving the nuts one or two turns at a time to draw up the end rings evenly. The bolts must be thoroughly tightened to the figures given below, working around the coupling as many times as necessary. On completion, the radial gap between pipe and coupling should be even all the way round. Rubber may be seen to extrude into the gap.

NOTES

- A Viking Johnson MaxiFit couplings **do not prevent pipe pull out**. Adequate external restraint to pipework is essential.
- B When installing Viking Johnson MaxiFit Couplings on GRP pipe and certain AC pipes a reduced bolt torque may be required – consult Technical Support for further advice.

Stud / Bolt Torque Table.		
Stud / Bolt Size	Torque	
	lbf.ft	Nm
M12	40 – 50	55 – 65
M16	70 – 90	95 – 120

Setting Gap Table.	
Typical Pipe Diameter Range.	Setting Gap
	mm
Sizes less than DN150	20
Sizes DN150 to DN300	25
Sizes greater than DN300	45

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