

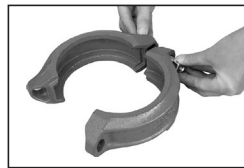
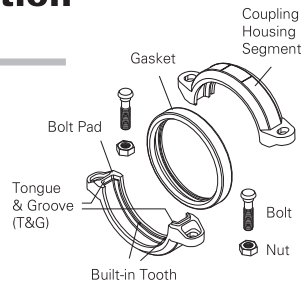
## Models K-9, K-9H & 7771 Rigid Couplings Model 7771-T\* Transition Coupling



**GROOVED COUPLINGS**

Please read these instructions carefully before installation.

1. Refer to page 50 for preliminary steps 1,2,3,4 & 5.

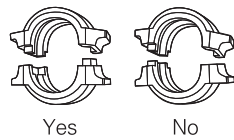


**2. ASSEMBLE COUPLING:** For a “swing-over” assembly loosely install one bolt and nut on one side of the coupling. For a standard assembly start with the two housings separated.



**3. INSTALL COUPLING HALVES:** For a “swing-over” installation, place one of the coupling halves around the bottom side of the gasket and swing over the other coupling half into position over the top side of the gasket. In tight areas where a swing-over is not possible, install the coupling halves one at a time. In both cases make sure the coupling keys are engaged in the grooves.

### **⚠ WARNING**



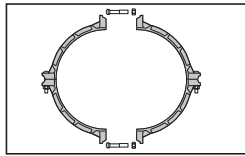
The *Shurjoint* Models K-9, K-9H, 7771 & 7771-T couplings feature a tongue and groove design and mechanism. Thus the couplings must always be installed so that tongue and groove mate properly. Attempting to install these couplings tongue to tongue or groove to groove will result in joint failure, property damage or serious injury.



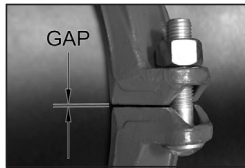
**4. INSERT BOLT & NUT:** Insert the remaining bolt and apply the nuts hand tight. Make sure that the oval neck of the bolt engages into the bolt hole of the housing.



**5. TIGHTEN NUTS (For 1 1/4" to 12" Models K9 and 7771 Couplings):** Tighten nuts alternately and equally until the bolt pads meet and make metal-to-metal contact. Tighten nuts by another one quarter to one half turn to make sure the bolts and nuts are snug and secure. The use of a torque wrench is not required.



**6. LARGE DIAMETER COUPLING:** Large diameter couplings over 14" consist of three to four housing segments. To prepare installation, preassemble the segments loosely into two or three equal assemblies depending on sizes. Install those assemblies over the gasket in the same manner as described above.



**7. TIGHTEN NUTS (For 14" to 24" Model 7771 Couplings):** Tighten nuts alternately and equally using a torque wrench until the required torque value is achieved. Full metal-to-metal contact is not always required but bolt pad gaps, if any, shall be equal on both sides.

Coupling Size Pipe O.D. in / mm	Required Torque Lbs-Ft / Nm
14" ~ 18"	320 ~ 400
355.6 ~ 457.2	434 ~ 542
20" ~ 24"	360 ~ 520
508.0 ~ 609.6	488 ~ 705

## Grooved Couplings

If the bolt pad gaps are greater than  $\frac{1}{8}$ " (3.2 mm) at any, or each of the bolt pads, disassemble and reinstall the coupling after checking the following.

- The coupling, pipe and/or fitting being connected are the correct size.
- The coupling keys are fully engaged in the pipe and/or component grooves.
- The gasket is not being pinched.
- The grooves conform to the applicable groove dimension specifications.
- The pipe end flare is within the specification tolerance.

GROOVED COUPLINGS

### CAUTION

1. Uneven tightening of bolts and nuts may cause the gasket to be pinched, resulting in an immediate or delayed leak.
2. Never exceed torque stated in the table on page 34. Excessive tightening of nuts may cause a bolt or joint failure.