



PIPE & COUPLING

# NO-HUB JOINT INSTALLATION & TESTING

Tyler Pipe/Soil Pipe Division • 11910 CR 492 • Tyler, TX 75706 • (800) 527-8478

**WARNING! Testing with Compressed air or gas in Cast Iron Pipe and fittings may result in explosive failure and could cause severe injury or death. Tyler Pipe recommends hydrostatic testing as described in the CISPI Handbook. Never test Cast Iron pipe or fittings with compressed air or gas!**



U.S. Patent 4,358,839  
Canada Patent 1,233,910

## Bracing:

To prevent movement, horizontal pipe and fittings 5" and larger should be suitably braced by the use of blocks, rodding or other suitable methods at every branch or change of direction.

## Test:

For best results, testing of one floor (ten feet) at a time is recommended. If more than one floor at a time is tested, the system should be properly restrained; all bends; changes of direction and ends of runs should be restrained.

## Coupling Material:

TYLER NO-HUB sealing sleeves are made of Neoprene conforming to ASTM C564. Chemical characteristics of Neoprene assure that the gasket will not decay or deteriorate from contact with effluents in the pipe or chemicals in the soil or air around the pipe.

## MATERIAL SPECIFICATIONS:

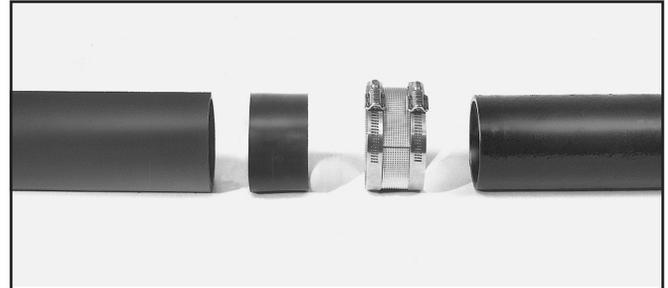
BANDS - Type 301 AISI Stainless Steel-Minimum tensile 165,000 psi.

SCREW HOUSING - Type 301 AISI Stainless Steel

SCREW - Type 305 AISI Stainless Steel; 5/16 hex head slant shoulder

SHIELD - Type 301 AISI Stainless Steel - Bright annealed; Rockwell B-85 minimum.

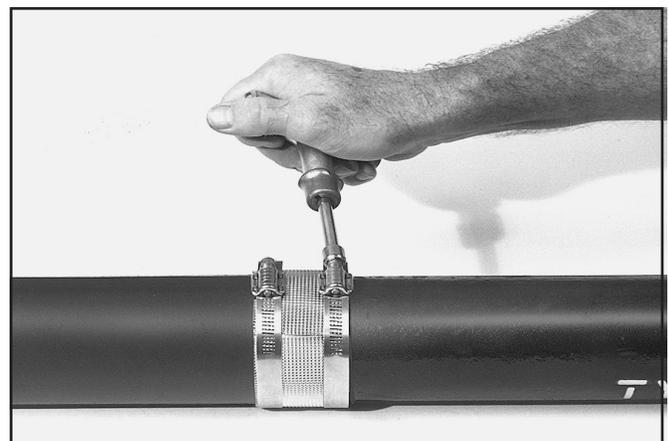
SEALING SLEEVE - High quality neoprene elastomer compound, durometer 70 ± 5 per ASTM D 2240.



1. Loosen screws, separate shield and sleeve. Slip shield over one spigot.



2. Insert spigots into sleeve. Be sure that both spigots butt on center retainer inside sleeve.



3. Position shield over sleeve, tighten screws alternately to proper torque.

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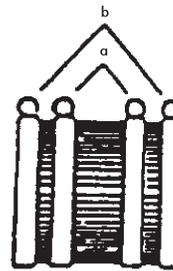
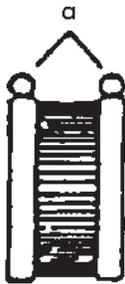


## STANDARD COUPLING JOINING SUGGESTIONS:

This is a guideline for connecting hubless pipe and fittings with TYLER  $\text{C}$  NO-HUB® couplings. These suggestions are based upon accepted industry standards and practices. More detailed information about coupling dimensions, installation practices and restraints may be found in the cast iron soil pipe industry publication CISPI-310.

### BEFORE JOINING:

1. TYLER couplings should be installed with a calibrated torque wrench set at 60 inch pounds (1½"-10" or 80 inch pounds (12" & 15")).
2. When using field-cut pipe, the ends should be cut square.
3. With all sizes, the pre-joining procedure is:
  - a. Install the neoprene sealing sleeve on one end of the pipe or fitting to be joined, then
  - b. Place the stainless steel shield on the other end, and
  - c. Insert both ends into the sealing sleeve until they butt against the molded center stop.
  - d. Center the shield over the sealing sleeve and tighten all clamps to snug fit. For final tightening, see below:

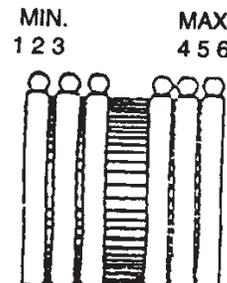
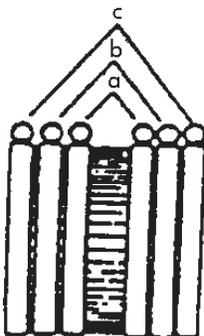


### 1½", 2", 3", 4" SIZES:

A. Tighten bands alternately and firmly.

### 5", 6", 8", 10" SIZES:

- A. First, tighten inner bands (a)
- B. Then, tighten the outer bands (b).



### 12" & 15" SIZES:

NOTE: (Torque to 80 inch pounds)

- A. First, tighten inner bands (a)
- B. Next, tighten the center set of bands (b)
- C. Finally, tighten the outer bands (c)

### MIN-MAX NOTE:

When working with min/max conditions on the OD of pipe and fittings, follow this tightening sequence:  
 First torque the minimum side, 3-2-1 and 3-2-1 again.  
 Then torque the maximum side, 4-5-6 and 4-5-6 again.  
 Finally torque 2-1 on the minimum side, and 4-5-6 on the maximum side.