



JCM 303 and 304 Fabricated Flanged Coupling Adapter INSTALLATION INSTRUCTIONS

1. Clean pipe surface of all dirt, rust, mud or loose scale from pipe ends. Inspect the pipe ends where gaskets will contact the pipe for any gouges, grooves, irregularities or imperfections that will interfere with the gasket seal. Measure the cleaned pipe diameter to confirm proper size of coupling for application. Inspection of the pipe's integrity for product application is the responsibility of the end user. ***TIP*** *Difficult to reach or cramped areas on the backside or underside of the pipe can be visually checked by using a mirror.*
2. Install follower ring, gasket and flanged adapter body onto the plain end of pipe. **NOTE:** Flat side of the gasket face meets the follower ring, the tapered side inserts into the adapter body. ***TIP*** *To ease installation of the gaskets, pipe should be lubricated with water or soapy-water mixture. Alcohol may be added to water in freezing weather. **DO NOT** use pipe lubricant or grease based products to lubricate.*
3. Insert the valve bolts into the flanged adapter body facing toward the valve or flanged fitting end.
4. Insert the flanged coupling adapter bolts to make up the coupling side. Loosely make up the FCA on the pipe end making certain the pipe extends past the gasket a minimum of one inch after deflection has occurred. Mark the pipe with a reference point to make certain FCA does not slide during tightening.
5. Align bolt holes of the adapter and flange and loosely make up flange connection. Tighten flange bolts and nuts, alternating bolts in a star pattern.

Recommended Torque:

5/8" Bolts

75 Foot Pounds

3/4" Bolts

90 Foot Pounds

6. **Lift the middle ring to insure that the gasket is evenly centered in the end.** Tighten flange coupling adapter bolts to make up the coupling side, alternating from side to side drawing the follower flange in evenly until all bolts have been tightened to 50 - 75 Foot Pounds. Check torque of bolts prior to completion.

INTFFCA-0700