Steel Pipe Couplings - Merchant Couplings

FIGURE 336
Standard, ☐ Full & ☐ Half

Size		Outside Diameter (Coupling)		Length				Threads		Unit Weight							
				Full		Half				Full				Half			
										Straight Tapped		Taper Tapped		Straight Tapped		Taper Tapped	
NPS	*DN*	in	*mm*	in	*mm*	in	*mm*	in	*mm*	lbs	*kg*	lbs	*kg*	lbs	*kg*	lbs	*kg*
⅛	*6*	0.563	*14*	13⁄16	*22*	11⁄32	*9*	27	*686*	0.03	*0.01*	0.03	*0.01*	0.01	*0.00*	0.01	*0.00*
¼	*8*	0.719	*18*	1 3⁄16	*30*	17⁄32	*13*	18	*457*	0.07	*0.03*	0.07	*0.03*	0.03	*0.01*	0.03	*0.01*
⅜	*10*	0.875	*22*	1 3⁄16	*30*	17⁄32	*13*	18	*457*	0.10	*0.05*	0.10	*0.05*	0.05	*0.02*	0.05	*0.02*
½	*15*	1.063	*27*	1 9⁄16	*40*	23⁄32	*18*	14	*356*	0.18	*0.08*	0.18	*0.08*	0.08	*0.04*	0.08	*0.04*
¾	*20*	1.313	*33*	1 5⁄8	*41*	¾	*19*	14	*356*	0.26	*0.12*	0.26	*0.12*	0.12	*0.05*	0.12	*0.05*
1	*25*	1.576	*40*	2	*51*	15⁄16	*24*	11½	*292*	0.42	*0.19*	0.42	*0.19*	0.18	*0.08*	0.18	*0.08*
1¼	*32*	1.900	*48*	2 1⁄16	*52*	31⁄32	*25*	11½	*292*	0.50	*0.23*	0.50	*0.23*	0.23	*0.10*	0.23	*0.10*
1½	*40*	2.200	*56*	2 1⁄16	*52*	31⁄32	*25*	11½	*292*	0.67	*0.30*	0.67	*0.30*	0.32	*0.15*	0.32	*0.15*
2	*50*	2.750	*70*	2 1⁄8	*54*	1	*25*	11½	*292*	1.03	*0.47*	1.03	*0.47*	0.47	*0.21*	0.47	*0.21*
2½	*65*	3.250	*83*	3 1⁄8	*79*	1½	*38*	8	*203*	2.09	*0.95*	2.15	*0.98*	0.96	*0.44*	0.96	*0.44*
3	*80*	4.000	*102*	3¼	*83*	1 9⁄16	*40*	8	*203*	3.36	*1.52*	3.46	*1.57*	1.60	*0.73*	1.60	*0.73*
3½	*90*	4.625	*117*	3⅜	*86*	1 5⁄8	*41*	8	*203*	4.82	*2.19*	5.18	*2.35*	2.22	*1.01*	2.22	*1.01*
4	*100*	5.000	*127*	3½	*89*	1 11⁄16	*43*	8	*203*	4.80	*2.18*	4.87	*2.21*	2.11	*0.96*	2.11	*0.96*
5	*125*	6.296	*160*	3¾	*95*	1 13⁄16	*46*	8	*203*	8.31	*3.77*	8.75	*3.97*	3.80	*1.72*	3.80	*1.72*
6	*150*	7.390	*188*	4	*102*	1 13⁄16	*46*	8	*203*	11.18	*5.07*	11.88	*5.39*	5.28	*2.39*	5.28	*2.39*

- Manufactured in accordance with ASTM specification A865 and A589.
- Merchant couplings in sizes 1⁄8" NPS *(6 DN)* through 2" NPS *(50 DN)* are normally supplied straight tapped. Sizes 2 1⁄2" NPS *(65 DN)* and larger are taper tapped.
- Taper tapped standard merchant couplings in sizes 1⁄8" NPS *(6 DN)* through 2" NPS *(50 DN)* are available upon request.
- API line pipe couplings are used in all sizes over 6" NPS *(150 DN)*.
- Couplings from 1⁄8" NPS *(6 DN)* through 6" NPS *(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:	☐ **Approved**
Address:	☐ **Approved as noted**
Contractor:	☐ **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.