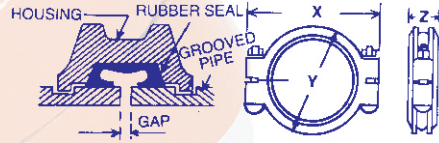




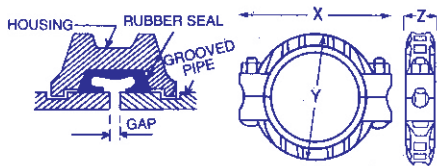
GROOVED END COUPLING

Style 75 is available where moderate pressures are expected or weight considerations are a factor. Up to 50% lighter in weight than the Style 77, the Style 75 coupling is recommended for lower working pressure.



Dimensions for Grooved Coupling Style 75

Pipe Size		Overall dimensions			Joint particulars				
Nominal Bore	OD	X	Y	Z	Bolts		Approx Weight Kg.	Test Pressure Mpa	
Inch	mm	mm	mm	mm	Dia mm & Inch	Length mm			
1"	33.4	105	61	45.0	10	50	0.6	3.5	
1 1/4"	42.2	114	68	45.0	10	50	0.6	3.5	
1 1/2"	48.3	117	78	46.0	10	50	0.7	3.5	
2"	60.3	128	89	47.0	10	50	0.8	3.5	
2 1/2"	73.0	150	104	47.0	10	50	1.0	3.5	
2 1/2"	76.1	150	104	49.0	10	50	1.0	3.5	
3"	88.9	166	118	49.0	1/2"	62	1.10	3.5	
4"	114.3	202	144	53.0	1/2"	62	1.60	3.5	
5"	141.3	255	178	53.0	5/8"	83	2.80	3.1	
6"	168.3	276	204	53.0	5/8"	83	3.0	3.1	
8"	219.1	355	263	57.0	5/8"	108	5.4	3.1	
10"	273.0	406	330	63.0	3/4"	127	8.3	3.1	
12"	323.9	449	385	64.0	1"	152	11.0	3.1	



The standard of the line, style 77 is available in a broad range of IPS sizes for varied services. The housing has ribbed construction to provide maximum strength without unnecessary weight. The coupling is capable of withstanding high pressure



Dimensions for Grooved Coupling Style 77

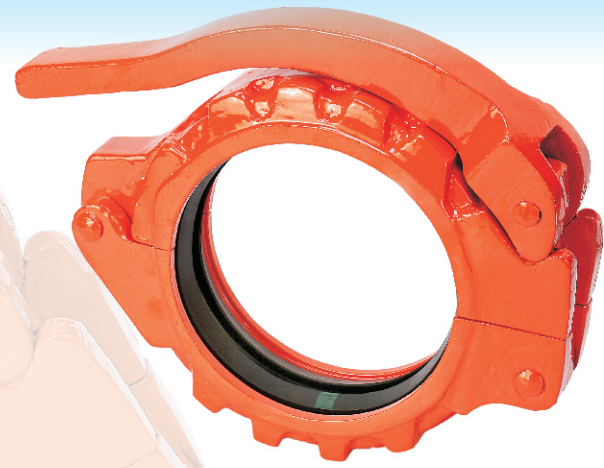
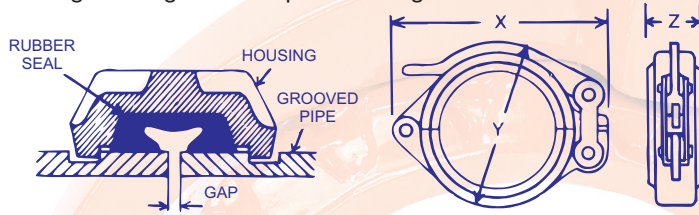
Pipe Size		Overall dimensions			Joint particulars				
Nominal Bore	OD	X	Y	Z	Bolts		Approx Weight Kg.	Test Pressure Mpa	
Inch	mm	mm	mm	mm	Dia mm & Inch	Length mm			
1/2"	21.7	89	50	45	10	50	0.4	6.8	
3/4"	26.7	96	55	45	10	50	0.5	6.8	
1"	33.4	98	63	46	10	50	0.65	6.8	
1 1/4"	42.2	112	72	47	1/2"	62	0.8	6.8	
1 1/2"	48.3	120	80	47	1/2"	62	0.9	6.8	
2"	60.3	143	95	47	1/2"	62	1.3	6.8	
2 1/2"	73.0	149	109	47	1/2"	62	1.5	6.8	
2 1/2"	76.1	164	113	48	1/2"	62	1.5	6.8	
3"	88.9	170	131	48	1/2"	62	1.7	6.8	
4"	114.3	214	156	52	5/8"	83	2.8	6.8	
5"	141.3	255	195	52	5/8"	83	3.6	6.8	
6"	168.3	290	219	52	5/8"	108	4.0	6.8	
8"	219.1	370	276	62	3/4"	127	8.8	5.4	
10"	273.0	432	340	65	1"	152	11.8	5.4	
12"	323.9	490	390	65	1"	152	14.0	5.4	
14"	355.6	530	420	76	1"	165	16.0	2.0	
16" **	406.4	570	485	76	1"	95	22.0	2.0	
18" **	457.0	602	540	79	1"	95	29.0	2.0	
20" **	508.0	688	597	79	27	108	30.0	2.0	
22" **	559.0	740	650	79	27	108	35.0	2.0	
24" **	610.0	795	700	79	27	108	38.0	2.0	

* Couplings are in 4 Section



TOGGLE JOINTS FOR GROOVED STEEL PIPES

Toggle Joint couplings are designed to provide a quick make-and-break joint. Housings are hinged for one-piece handling.

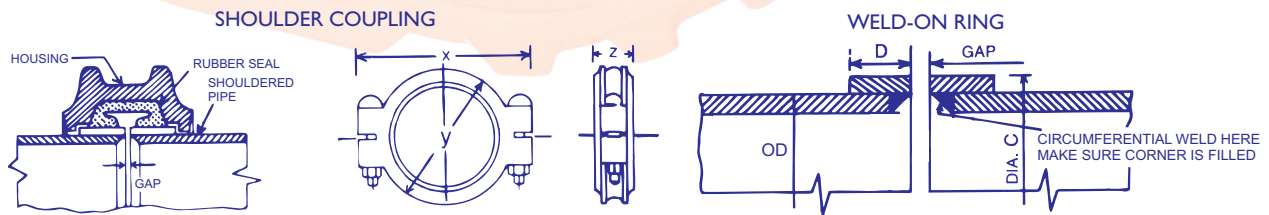


Dimensions for Toggle Joints for Grooved Steel Pipes

PIPE SIZE		OVERALL DIMENSIONS IN mm (APPROX).			Approximate Weight Kg.	Working Pressure MPa
Nominal Bore	O.D.	X ± 5	Y ± 5	Z ± 2		
50	60.3	129	94	46.0	1.0	1.0
80	88.9	160	121	46.0	1.5	1.0
100	114.3	201	156	52.5	2.5	1.0
150	168.3	256	214	52.5	3.5	1.0

'NMC' SHOULDER TYPE STANDARD BOLTED JOINTS

'NMC' Shouldered Joints are advocated where there is substantial abrasion in the piping system and reduction in the pipe thickness is not desirable. Rings, welded on the pipe ends, enable the use of this versatile pipe jointing methods.



Dimensions for Shoulder type Standard Bolted Joints

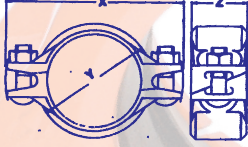
PIPE SIZE		JOINT PARTICULARS					WELD-ON RING			
Normal Bore	O.D.	Overall Dimensions			Bolts		approx. Weight Kg.	Test Pressure Mpa	Dia of Shoulder 'C' mm	Length of Shoulder 'D' mm
		X	Y	Z	Diameter	Length				
mm	mm	mm	mm	mm	in	mm	Kg.	Mpa	'C' mm	'D' mm
40	48.3	122	87	44	1/2	62	1.2	4.1	54.0	16.0
50	60.3	144	100	46	1/2	62	1.5	4.1	66.5	16.0
65	76.1	162	119	46	1/2	70	2.0	4.1	82.5	16.0
80	88.9	184	137	48	5/8	83	2.5	4.1	97.0	16.0
100	114.3	129	167	51	5/8	90	3.5	4.1	122.0	17.5
125	139.7	254	204	52	5/8	90	6.0	3.4	147.5	17.5
150	165.1	290	236	52	5/8	90	7.4	2.7	174.5	17.5
150	168.3	293	239	52	5/8	90	7.7	2.7	178.0	17.5
200	219.1	366	300	64	3/4	140	13.0	2.7	232.0	20.5
250	273.0	425	356	64	3/4	140	17.0	2.7	286.0	20.5
300	323.9	482	406	64	3/4	140	20.0	2.7	336.5	20.5
350	355.6	506	436	76	1	180	24.0	1.7	368.5	24.0
400	406.4	564	496	76	1	180	30.0	1.5	419.0	25.5
450	457.0	614	552	76	1	180	35.0	1.3	470.0	25.5
500	508.0	692	608	76	1	180	40.0	1.2	520.5	25.5
550	559.0	752	662	76	1	180	42.0	1.0	571.5	25.5
600	609.6	786	714	76	1	180	44.0	1.0	622.5	25.5



GE RIGID COUPLING STYLE 07

NMC Style - 07 Couplings provide rigidity, and can be incorporated in any system rolled groove or cut groove to take Full advantage of this Feature. Wider key sections fill up more of groove areas.

NMC coupling with its unique angle pad design adjusts to positive clamping of the pipe for rigidity. Available in Sizes DN 25-DN 600.



Dimensions for Grooved Coupling Style 07

Pipe Size		Overall dimensions				Bolt/Nut		Joint Particulars	
Nominal Bore		O.D.	x	y	z	No.	Size Dia x Length	Approx Weight	Working Pressure
in	mm	mm	mm	mm	mm		In x mm	kg	Bar
1	25	33.7	102	62	47	2	3/8 x 50	0.7	52
1.25	32	42.4	105	66	47	2	3/8 x 50	0.7	52
1.5	40	48.3	122	75	47	2	3/8 x 50	0.7	52
2	50	60.3	141	81	47	2	1/2 x 62	1	52
2.5	65	73.0	144	98	47	2	1/2 x 70	1.2	52
2.5	80	76.1	146	108	47	2	1/2 x 70	1.4	52
3	100	88.9	173	116	47	2	1/2 x 70	1.4	52
4	125	114.3	210	148	52	2	1/2 x 70	2.2	52
5	125	139.7	239	176	52	2	5/8 x 83	3.4	52
5	150	141.3	248	179	52	2	5/8 x 83	3.4	52
6	150	165.1	273	203	52	2	5/8 x 83	3.4	48
6	150	168.3	273	203	52	2	5/8 x 83	4	48
8	200	219.1	343	260	64	2	3/4 x 108	6.8	42
10	250	273.0	426	327	65	2	7/8 x 165	12	35
12	300	323.9	470	378	65	2	7/8 x 165	12	28
14	350	355.6	502	411	75	3	7/8 x 127	15	21
16	400	406.4	553	467	75	3	7/8 x 127	19	21
18	450	457.0	606	526	78	3	7/8 x 127	25	21
20	500	508.0	695	584	78	4	1 x 127	30.5	21
24	600	610.0	800	689	79	4	1 x 127	35	17

MATERIAL SPECIFICATION

FOR GE COUPLING STYLE 75, 77, 07 SHOULDER & TOGGLE

Housing

SG Ductile Iron
or Malleable Cast Iron

B.S. Specification
BS EN 1563:1997
BS EN 1562

B.I.S. Specification
IS 1865:2000
IS 14329:2000

Gaskets:

EPDM Compound Grade 'E' to BS EN 681-1:1996 suitable for water, sewage, many strong oxidizing chemicals & food applications
or Nitrile compound Grade 'G' to BS:2494:1990 Grade G suitable for natural gas, petroleum products. Low aromatic fuels, compressed air, sewage & drainage.

Bolts & Nuts

Steel fastener to Grade 6.8 (SS available on request)

Finish

Orange primer as standard other finish like Fusion bonded Epoxy powder coating, RILSAN Coating and galvanized on request.



PIPE WEIGHT AND CUT GROOVING DIMENSIONS

Tolerance on Pipe O.D. At land :

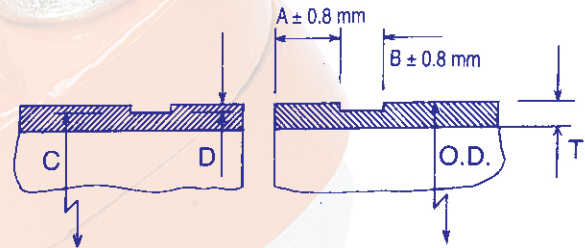
Upto 250 mm nom. Size : + 0.8 mm -0.4 mm
Over 250 mm nom. Size : + 1.2 mm - 0.8 mm

Squareness of pipe ends

Up to 90 mm nom. Size 0.8 mm
100 to 150 mm nom. Size 1.2 mm
Over 150 mm nom. Size 1.6 mm

Max deviation from
Square, cut ends

'D' is nominal depth of groove.



PIPE WEIGHT					CUT GROOVING DIMENSIONS					Maximum Angle each Joint	Maximum Deflection mm per 5 m
NOM SIZE	O.D. mm	THICK NESS mm	WT Kg/m.	MINIMUM T mm	Land A mm	Groove Width B mm	Groove Diameter C mm	Tolerance on C mm	Nom D mm		
20	26.7	3.25	1.90	2.6	16.0	8.0	23.8	+0-0.4	1.6	6°05'	590
25	33.4	4.05	3.00	3.4	16.0	8.0	30.2	+0-0.4	1.6	5°26'	462
32	42.2	4.05	3.80	3.6	16.0	8.0	39.0	+0-0.4	1.6	4°19'	377
40	48.3	4.05	4.40	3.7	16.0	8.0	45.1	+0-0.4	1.6	3°46'	329
50	60.3	4.47	6.10	3.9	16.0	8.0	57.2	+0-0.4	1.6	3°01'	262
65	73.0	4.47	7.80	4.5	16.0	8.0	69.1	+0-0.5	2.0	2°29'	217
65	76.0	4.47	7.90	4.5	16.0	8.0	72.3	+0-0.5	2.0	2°23'	208
80	88.9	4.85	10.10	4.8	16.0	8.0	84.9	+0-0.5	2.0	2°03'	179
90	101.6	4.85	11.50	4.8	16.0	8.0	97.4	+0-0.5	2.1	1°48'	157
100	114.3	5.40	14.40	5.4	16.0	9.5	110.1	+0-0.5	2.1	3°11'	277
125	139.3	5.40	17.80	5.4	16.0	9.5	135.5	+0-0.6	2.1	2°36'	227
125	141.3	5.40	18.00	5.4	16.0	9.5	137.0	+0-0.6	2.1	2°35'	225
150	165.1	5.40	21.20	5.4	16.0	9.5	160.9	+0-0.6	2.1	2°12'	192
150	168.3	5.40	21.60	5.4	16.0	9.5	164.0	+0-0.6	2.1	2°10'	190
200	219.1	5.60	29.30	5.4	19.0	11.0	214.4	+0-0.6	2.3	1°40'	146
225	244.5	6.00	35.00	5.9	19.0	11.0	240.3	+0-0.6	2.4	1°29'	128
250	273.0	7.01	41.70	6.4	19.0	12.7	268.3	+0-0.7	2.4	1°20'	117
300	323.9	7.94	55.50	7.1	19.0	12.7	318.3	+0-0.8	2.8	1°07'	98
350	355.6	7.94	68.00	7.1	23.8	12.7	350.0	+0-0.8	2.8	1°01'	90
400	406.4	9.53	93.00	8.0	23.8	12.7	400.8	+0-0.8	2.8	0°54'	77
450	457.0	9.53	105.00	8.0	25.4	12.7	451.6	+0-0.8	2.8	0°48'	69
500	508.0	9.53	117.00	8.0	25.4	12.7	502.4	+0-0.8	2.8	0°43'	62
550	559.0	9.53	129.00	9.5	25.4	14.3	551.6	+0-0.8	4.4	0°39'	57
600	610.0	12.70	187.00	11.1	25.4	14.3	600.9	+0-0.8	4.4	0°36'	52

13/40/08