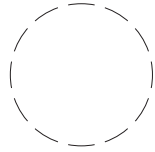


# INSTALLATION INSTRUCTION 0001-0279-999



## Style 440 Joint Harness

One Harness Assembly Set will have the following components:

- Insulating Joint Harness with Deflection Ring (Fig. 1) – one stud; two lugs; one insulated deflection ring assembly, and one lug adapter.
  - Conductive Joint Harness with Deflection Ring (Fig. 2) – one stud; two lugs; one conductive deflection ring assembly, and one lug adapter.
  - Conductive Joint Harness (Fig. 3) – one stud; two lugs; two lug adapters.
- (Note: This Joint Harness does not meet requirements of D.O.T. Regulation Part II, Section 192.273, since it does not have a deflection ring. Deflection ring will accommodate 1/8" longitudinal movement per deflection

1. Determine lug location from the following chart:

Coupling Middle Ring Length	Stud Length	Dimensions From Pipe End To First Point of Lug
5" Long	26" Long	6-3/8"
7" Long	32" Long	8-1/2"
12" Long	44" Long	14-1/2"
16" Long	44" Long	14-1/2"

Lugs must be equally spaced around circumference of pipe and directly opposite each other on opposite pipe ends. Note: On applications where coupling is already installed, locate lugs an equal distance from each end of coupling. The overall distance between the face of lugs to be determined by the length of the studs used.

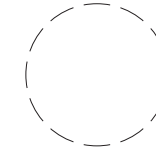
2. Prepare pipe surface for lug welding. Remove deflection ring assemblies from lugs. Weld lug to pipe using 1/4" fillet weld for .250" lug (5/8" diameter stud) and 3/8" fillet weld for .375" lug (3/4" diameter stud) – see sketch. Lugs must be welded at all inside and outside edges.
3. For Insulating Joint Harness: Insert insulating deflection ring assembly into lug located on pipe to be insulated and lug adaptor into opposite lug. Insert stud and run nuts up finger tight.
4. For Conductive Joint Harness: Insert conductive deflection ring assembly in one lug and lug adaptor in the other lug. Insert stud and run nuts up finger tight. When harness assembly does not require deflection ring assembly, use two lug adaptors and install as noted above.

**CAUTION:** It shall be end-user responsibility for determining that standards of good welding practice are followed and that all requirements of D.O.T. Minimum Safety Standards have been completely satisfied.

5. Conversion: To convert a conductive harness to insulating, on the pipe to be insulated, remove the conductive deflection ring assembly and insert an insulating deflection ring assembly and follow the procedure under Step 3 above.

**Part No. 0001-0279-999  
12.2018**

# INSTALLATION INSTRUCTION 0001-0279-999

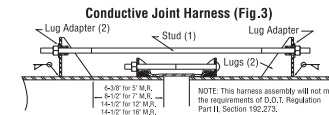
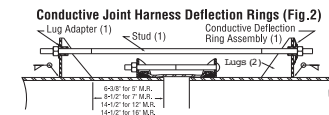
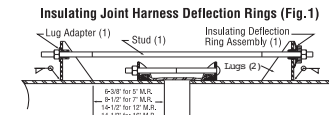


## Style 440 Joint Harness

**SELECTOR CHART GUIDELINE** - Number of Harnesses required by pipe diameter, bolt size and working line pressure

Pipe Diam.	Bolt Size	Line Working Pressure (PSI)											
		25	50	75	100	125	150	175	200	225	250	275	300
2" - 6"	5/8"	2	2	2	2	2	2	2	2	2	2	2	2
	5/8"	2	2	2	2	2	2	2	2	2	2	2	2
	3/4"	2	2	2	2	2	2	2	2	2	2	2	2
8"	5/8"	2	2	2	2	2	2	2	2	2	2	2	2
	5/8"	2	2	2	2	2	2	2	2	2	2	2	2
	3/4"	2	2	2	2	2	2	2	2	2	2	2	2
10"	5/8"	2	2	2	2	2	2	3	3	3	3	4	4
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
12"	5/8"	2	2	2	2	3	3	3	4	4	5	5	6
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
14"	5/8"	2	2	2	3	3	4	4	5	5	6	6	7
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
16"	5/8"	2	2	2	3	4	4	5	6	6	7	8	8
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
18"	5/8"	2	2	3	4	5	5	6	7	8	9	10	10
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
20"	5/8"	2	3	4	5	6	7	8	9	10	11	12	13
	5/8"	2	2	2	3	4	4	5	6	6	7	8	8
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3
24"	5/8"	2	3	5	6	8	9	11	12	14	15	15	15
	5/8"	2	2	2	2	2	2	2	2	2	2	2	3
	3/4"	2	2	2	2	2	2	2	2	2	2	2	3

Consult factory for larger Pipe OD sizes and bolt diameter availability



**Dresser™ Pipeline Solutions**  
41 Fisher Avenue  
Bradford, PA 16701  
P: 814.362.9200  
F: 814.362.9344  
www.dresserng.com

© 2018 Natural Gas Solutions North America, LLC. The Dresser Logo and all Trademarks containing the term "Dresser" are the property of Dresser, LLC, a subsidiary of Baker Hughes, a GE Company.

**Part No. 0001-0279-999  
12.2018**