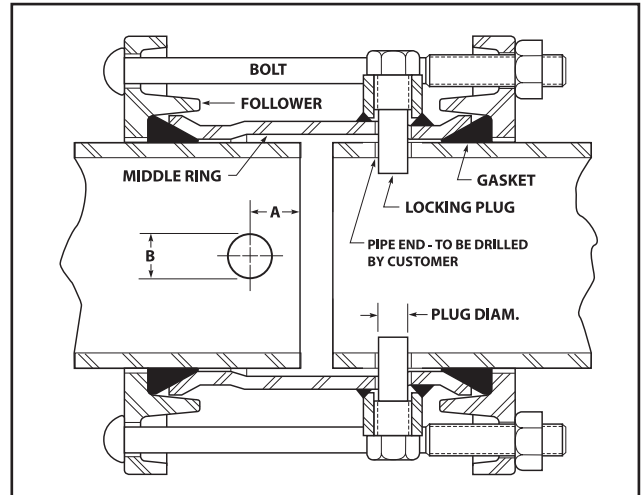


Style 167 Lock Couplings

For Drilled-end Pipe

1. Clean pipe ends, removing oil, dirt, loose scale, and rust; gasket should seat on bare metal.
2. Slip one follower over each pipe end.
3. Wipe gasket clean, immerse in soap-water (anti-freeze should be added in freezing weather) and slide gasket over each pipe end with tapered (thin) edge toward pipe end.
4. Make sure middle ring is clean, especially flares where gasket will seat. Slip middle ring without plugs over one pipe end.
5. Stab other pipe end into middle ring. Holes in the middle ring must be centered over the corresponding holes in the pipe to permit the insertion of the threaded plugs. The holes in the pipe ends should be drilled prior to assembly. Drilling should be accurately done, at right angles to the axis of the pipe.
6. Lubricate pipe ends and flare of middle ring with soap-water (anti-freeze should be added in freezing weather); slide gaskets and followers into place.
7. Insert bolts (bolts may be inserted in opposite directions from right to left to facilitate downward wrenching). Assemble nuts and tighten uniformly until all bolts have a minimum torque of 75 foot pounds.



STYLE 167 - PIPE DRILLING TABLE

Locking Plug		Drilling Dimensions	
Nominal Size	Plug Diameter	Distance from End of Pipe	Drill Size
1/2"	11/16"	15/16"	13/16"
3/4"	29/32"	1-1/4"	1-1/16"
1"	1-1/8"	1-7/16"	1-1/4"

MAXIMUM LAYING DEFLECTION

3" I.D. to 14" O.D. Inclusive 2° for all M.R. Lengths

	Middle Ring Length		
	5"	7"	10" & Longer
Above 14" O.D. to 20" O.D. Inclusive:	1-1/4°	2°	2°
Above 20" O.D. to 30" O.D. Inclusive:	1°	2°	2°

WARNING!

Do not remove Locking Plugs while line is under pressure. To do so could allow the locking plugs to blow out of coupling and cause serious injury or death. Also, escaping gas could ignite and cause property damage, serious injury or death.

WARNING

You **MUST** mark and stab the pipe into the coupling to the proper stab depth. Failure to do so could result in escaping gas that could ignite and cause property damage, serious injury or death.

WARNING

When pipe pullout could occur, pipe joint **MUST** be anchored. Failure to anchor pipe joint could result in escaping line content and cause property damage, serious injury or death.

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