



# HYMAX<sup>®</sup> REDUCER (14"-60")

**HYMAX<sup>®</sup>**  
Repair the past. Connect the future.

## INSTALLATION INSTRUCTIONS

**DO NOT DISASSEMBLE THE COUPLING. DO NOT LUBRICATE THE BOLTS.**

### GENERAL INSTRUCTIONS:

THE LARGE AND X-LARGE DIAMETER HYMAX COUPLING ARE STAB-ON TYPE COUPLINGS.  
14"-24" HAVE A 2-LAYER GASKET.  
26"-60" HAVE A 1-LAYER GASKET.

#### STEP 1



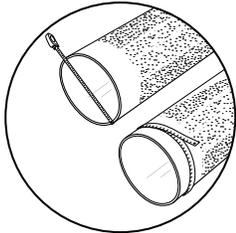
Prepare the pipe ends. Clean and de-scale each pipe end. Remove any debris or build up on the pipe ends. Clean the outer pipe surface with water. Clean each pipe end to a length of the coupling body.

Make sure there is no corrosion on the outer pipe ends that could affect the gasket seal. Again, clean each pipe end with water.

**NOTE:** Sizes 14"-24": Except steel, PVC, and PE pipes, all rough-surfaced pipes must be lubricated with a water-based gasket lubricant in order to achieve a proper seal.

Sizes 26"-60": All pipes must be lubricated with a water-based gasket lubricant in order to achieve a proper seal.

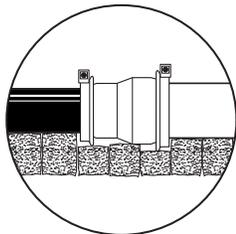
#### STEP 2



Measure the pipes' outer diameters and make sure the coupling being used has the proper OD range. Always use an OD tape to ensure that you are using the proper size coupling on both sides.

**NOTE:** Each coupling's size range is shown on the product's label. Ensure the pipe is not out-of-round, and that it is free of scratches, dents, flats or other defects which may interfere with the coupling's proper seal. The coupling may not fit well or function properly on a pipe which is not round or is damaged.

#### STEP 3



Carefully remove the HYMAX Reducer from its packaging. Inspect the coupling and end rings for shipping damage and assure that there are no missing parts.

**NOTE:** The HYMAX Reducer is a stab-on type coupling. Do not remove the end ring bolts.

**NOTE:** Bolts are pre-lubricated with a dry coating. Do not lubricate the bolts and nuts. Greasing or lubricating bolts or nuts voids manufacturer's warranty.

Inspect the Reducer, if the end rings are not centered on the coupling, **DO NOT USE.** Contact your distributor for return and replacement!

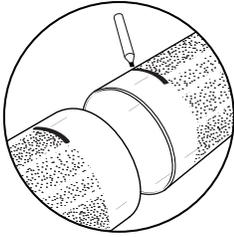
**DO NOT** attempt to hammer the end ring into place! This will damage the end ring and void the Warranty!

Make sure that the pipe is properly supported.

**NOTE:** The HYMAX Reducer is not designed to carry the weight of the pipe by itself.

**STEP 4**

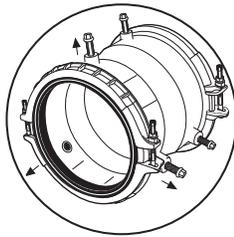
Mark the pipe ends according to the minimum stab depths, as indicated on the product label.



**STEP 5**

Unscrew the centering pins. Use an open-ended wrench or socket wrench to retract the centering pins. This allows the Reducer to be stabbed over the pipe end without interference, and also allows for proper positioning.

The centering pin has a CIRCLIP which stops it and prevents it from being pulled out.

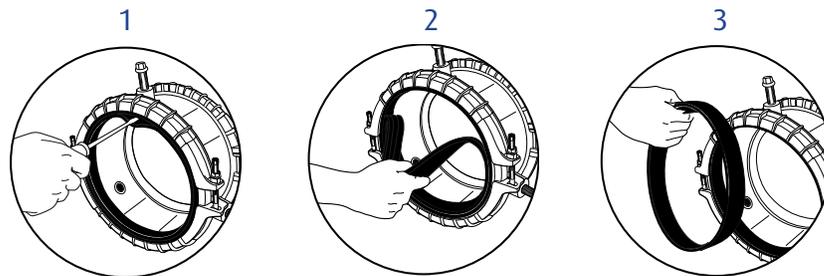


**STEP 6**  
**ONLY FOR 14"-24"**

For sizes 14"-24", the educer gasket system has two layers, a removable inner gasket layer and a hydraulically assisted "outer gasket" layer. The "inner gasket" layer can be removed to accommodate larger OD pipes.

DO NOT remove the inner gasket unless the OD falls within the upper range of the coupling. The proper range sizes are shown on the product label. If the inner layer of the gasket must be removed, separate the two layers and break the parting line by inserting a screwdriver (1) between the two layers, peel the gasket layer (2) and pull it out of the coupling (3).

**NOTE:** Measure the OD of the pipe TWICE using an OD tape! Once the inner gasket is removed it can NOT be re-installed!

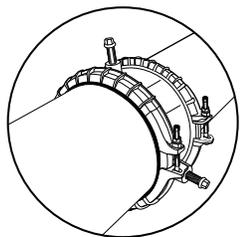


**STEP 7**

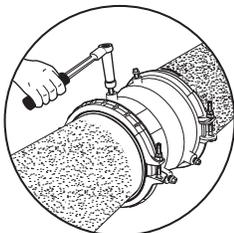
Positioning the Reducer for installation. If possible, place the Reducer(s) on the replacement pipe (on both ends) and lower the pipe and couplings into the ditch. Slide the couplings outward so that they cover the minimum marks made in Step (4).

Make sure there is sufficient space between the pipe ends inside the coupling so the centering pins do not touch the pipe and continuous dynamic deflection (CDD) can take place.

**NOTE:** All pipes above OD 24" must be lubricated with a water-based gasket lubricant in order to achieve a proper seal.



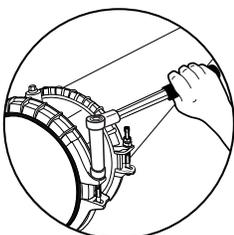
**STEP 8**



Set the centering pins. Secure the centering pins using an open-ended wrench or a socket wrench. Make sure the "o" ring on each centering pin seats properly beneath the pin head. Fully tighten the centering pins into the coupling body. The pins prevent the coupling from drifting along the pipe. They are not "set screws".

**NOTE:** Make sure the centering pins are between the two pipes.

**STEP 9**



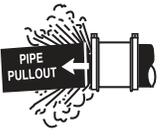
Tightening the end rings. Tighten the Reducer's bolts using a 15/16" socket wrench for 14"-24" couplings, and a 1.5" socket wrench for 26"-60" couplings. Tighten the bolts evenly on each end ring in an alternating pattern to the torque mentioned on the label. Cross-tightening ensures that the gasket is evenly seated. When you finish, re-check the torque again.

**DO NOT LUBRICATE BOLTS!**

**NOTE:** Use of a torque wrench is required! The torque wrench will verify that the proper torque has been achieved. Refer to the product label for the proper torque settings.

**STEP 10**

Recharge the line and check for leaks. If any leakage across the seal end is evident, reduce the pressure in the line and increase the labeled torque of the end ring bolts by up to 50%.

 <b>WARNING</b>	This product does not restrain axial pipe movement. Proper anchorage of the pipe is required if this product is used as a coupling. Failure to anchor the pipe ends could result in the escape of line content, and may cause property damage, serious injury or death.
	

 <b>WARNING</b>	<b>Caution:</b> This product is not intended for use on natural gas piping, or any other type of gas piping. To do so could result in escaping gas that could ignite and cause property damage, serious injury or death.
	

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