

ANGUS WELLMASTER 400

For sizes 76mm (3") and 102mm (4")

Procedure for Coupling Assembly

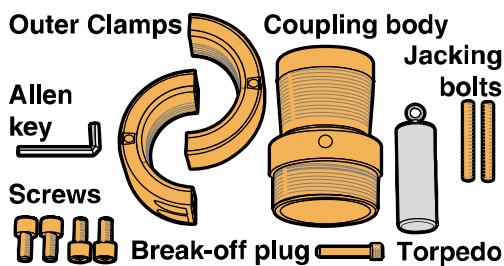
1. Introduction

This sheet covers the assembly procedure for couplings fitted to WELLMASTER 400 products regardless of the coupling material used. Angus recommends that a break-off plug (BOP) is used but this may not suit every customer or installation.

Please also refer to the latest edition of the Wellmaster Installation Manual for more details

2. Assembly Procedure

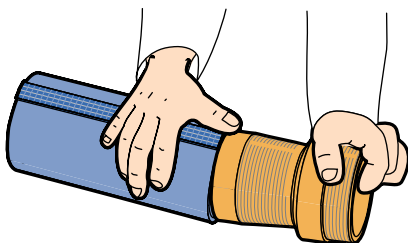
1.



Coupling Components

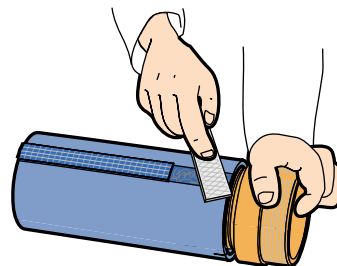
- Coupling Body with blanking plug.
- **Correct Type outer half clamps** with cap head screws.
- Jacking bolts (4" only, if required).
- Break-off plug (8mm Allen key) and torpedo.

2.



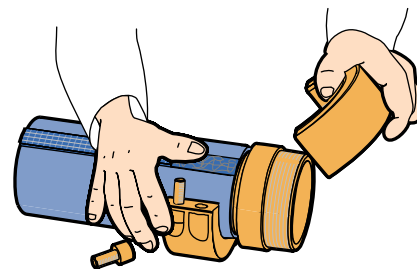
- Cut the end of the riser square with a knife or hacksaw.
- Push the riser onto the coupling body.
DO NOT LUBRICATE

3.



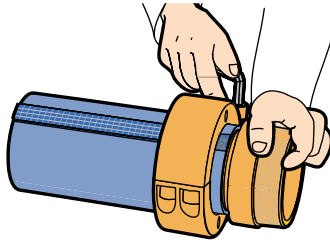
- Carefully file away the cable carrying strips until flush with the riser.

4.



- Centrally locate the outer half clamps over the tapered section of the coupling body. This is likely to fall between 10mm and 20mm from the coupling body shoulder depending on riser diameter.
- **NOTE:** The grooved portion on the inside of the clamps should be located nearest to the coupling body shoulder end of the riser.

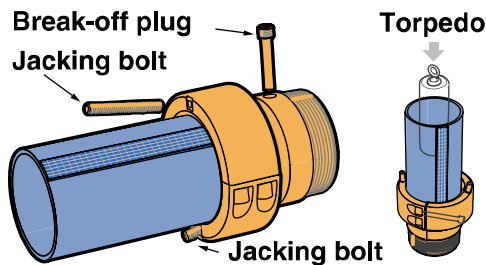
5.



- Tighten the screws evenly to the recommended Torque setting. See 8.
- Ensure an even gap of 0.5 - 1.5mm between clamps for 3" (76mm) size and 1.0 to 2.0mm between clamps for 4" (102mm) size.

If the incorrect gap results, remove clamps and relocate nearer or further away from the coupling shoulder.

6.



- If jacking bolts are used, screw them through the outer clamps until they firmly locate against the shoulder.
- Remove the blanking plug and replace with the break-off plug. Tighten correctly.

7.

SCREW TORQUE SETTINGS		
Diameter	Nm	Lb-ft
3" (76mm) - 8mm Allen key	30.0	22.0
4" (102mm) - 10mm Allen key	50.0	37.0
Blanking Plug/Break-off Plug	20.0	14.6

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