

## Steel Pipe Couplings - Merchant Couplings

**FIGURE 336**  
Standard,  Full &  Half



Size	Outside Diameter (Coupling)		Length				Threads		Unit Weight								
			Full		Half				Full				Half				
			in	mm	in	mm			Straight Tapped	Taper Tapped	lbs	kg	Straight Tapped	Taper Tapped	lbs	kg	
1/8	6	0.563	14	13/16	22	11/32	9	27	686	0.03	0.01	0.03	0.01	0.01	0.00	0.01	0.00
1/4	8	0.719	18	13/16	30	17/32	13	18	457	0.07	0.03	0.07	0.03	0.03	0.01	0.03	0.01
3/8	10	0.875	22	13/16	30	17/32	13	18	457	0.10	0.05	0.10	0.05	0.05	0.02	0.05	0.02
1/2	15	1.063	27	13/16	40	23/32	18	14	356	0.18	0.08	0.18	0.08	0.08	0.04	0.08	0.04
3/4	20	1.313	33	15/8	41	3/4	19	14	356	0.26	0.12	0.26	0.12	0.12	0.05	0.12	0.05
1	25	1.576	40	2	51	15/16	24	11 1/2	292	0.42	0.19	0.42	0.19	0.18	0.08	0.18	0.08
1 1/4	32	1.900	48	2 1/16	52	3 1/32	25	11 1/2	292	0.50	0.23	0.50	0.23	0.23	0.10	0.23	0.10
1 1/2	40	2.200	56	2 1/16	52	3 1/32	25	11 1/2	292	0.67	0.30	0.67	0.30	0.32	0.15	0.32	0.15
2	50	2.750	70	2 1/8	54	1	25	11 1/2	292	1.03	0.47	1.03	0.47	0.47	0.21	0.47	0.21
2 1/2	65	3.250	83	3 1/8	79	1 1/2	38	8	203	2.09	0.95	2.15	0.98	0.96	0.44	0.96	0.44
3	80	4.000	102	3 1/4	83	1 1/16	40	8	203	3.36	1.52	3.46	1.57	1.60	0.73	1.60	0.73
3 1/2	90	4.625	117	3 3/8	86	1 5/8	41	8	203	4.82	2.19	5.18	2.35	2.22	1.01	2.22	1.01
4	100	5.000	127	3 1/2	89	1 11/16	43	8	203	4.80	2.18	4.87	2.21	2.11	0.96	2.11	0.96
5	125	6.296	160	3 3/4	95	1 13/16	46	8	203	8.31	3.77	8.75	3.97	3.80	1.72	3.80	1.72
6	150	7.390	188	4	102	1 13/16	46	8	203	11.18	5.07	11.88	5.39	5.28	2.39	5.28	2.39

- Manufactured in accordance with ASTM specification A865 and A589.
- Merchant couplings in sizes 1/8" NPS (6 DN) through 2" NPS (50 DN) are normally supplied straight tapped. Sizes 2 1/2" NPS (65 DN) and larger are taper tapped.
- Taper tapped standard merchant couplings in sizes 1/8" NPS (6 DN) through 2" NPS (50 DN) are available upon request.
- API line pipe couplings are used in all sizes over 6" NPS (150 DN).
- Couplings from 1/8" NPS (6 DN) through 6" NPS (150 DN) are dipped in rust preventative.
- Electroplated full couplings are also available.

**Note**

- Half couplings are chamfered on one end and squared on the other.

PROJECT INFORMATION		APPROVAL STAMP	
Project:		<input type="checkbox"/> Approved	
Address:		<input type="checkbox"/> Approved as noted	
Contractor:		<input type="checkbox"/> Not approved	
Engineer:		Remarks:	
Submittal Date:			
Notes 1:			
Notes 2:			

## General Assembly of Threaded Fittings

- 1) Inspect both male and female components prior to assembly.
  - Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
  - Clean or replace components as necessary.
- 2) Application of thread sealant
  - Use a thread sealant that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
  - Thoroughly mix the thread sealant prior to application.
  - Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.
- 3) Joint Makeup
  - For sizes up to and including 2" pipe, wrench tight makeup is considered three full turns past handtight. Handtight engagement for 1/2" through 2" thread varies from 4 1/2 turns to 5 turns.
  - For 2 1/2" through 4" sizes, wrench tight makeup is considered two full turns past handtight. Handtight engagement for 2 1/2" through 4" thread varies from 5 1/2 turns to 6 3/4 turns.