## **MALLEABLE IRON & CAST IRON FITTINGS**



## **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 41/2 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.