

The following is a summary of some of the key steps that must be followed when installing Flexpipe 5" FP301HT & 5" FP601HT crimp fittings. For additional details, reference the Flexpipe Installation Guide.

Safety

- Use required personal protective equipment - PPE
- Inspect equipment for damage prior to use
- Always follow proper lifting techniques; track hoe, picker truck, forklift, and other types of lifting equipment should be used to lift materials & rental equipment
- Keep fingers out of pinch points at all times

6 Step Pipe Preparation

- 1 - Clean outside surface of pipe
- 2 - Cut pipe to length
- 3 - Check for moisture in fibers (moisture meter)
- 4 - Ensure pipe is round, then bevel the inside liner. If pipe is oval, use a pipe clamp to re-round the pipe.
(Note: If fibers become exposed you will have to repeat steps 1 to 3)
- 5 - Mark length of pipe to be inserted into fitting mandrel (**See dimension A in below table**)
- 6 - Apply Denso paste to exposed fibers/cords

Fitting Preparation

- Confirm fitting sleeve O.D. and length
- Inspect o-rings for cuts, missing, or damage
- Check sleeve: no dents, centered, vent hole clear
- Check internal mandrel coating for chips
- Record fitting serial number
- Measure and mark crimp lines
- Apply grease over mandrel nose and o-rings

5" FP301HT & 5" FP601HT Pipe and Fitting Weights

301 HT	601 HT	Flange	Coupling	SS Weldneck	Weldneck
8.3 kg/m	11.8 kg/m	60 kg	57 kg	42 kg	39 kg
5.6 lb./ft	7.9 lb./ft	132 lbs.	125 lbs.	92 lbs.	85 lbs.

Note: Weights are approximate for fittings

Mandrel Insertion

- 1 - Fitting adaptor and integrated pipe clamps for coupling, weldneck, and flange fittings are built into the press.
- 2 - External Pipe clamps for coupling, weldneck, and flange fittings are available as well.



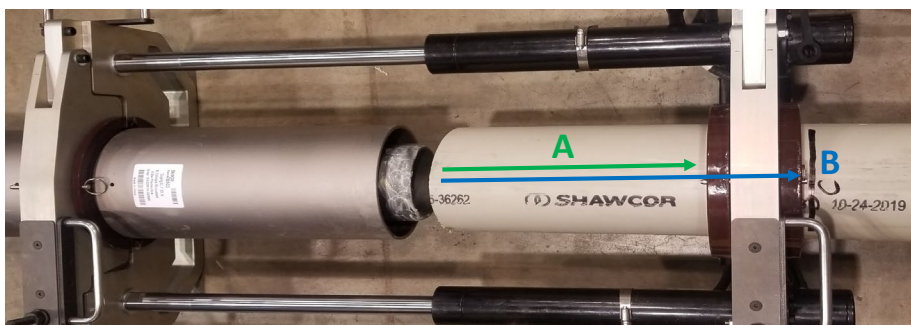
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2

Min 4" distance

- 3 - Ensure correct pipe clamp is in press (5") 301 or 601



A- Insertion Distance

5 in	14-3/16" -	360mm
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B- Clamp Mark

5 in	18-1/8" -	460mm
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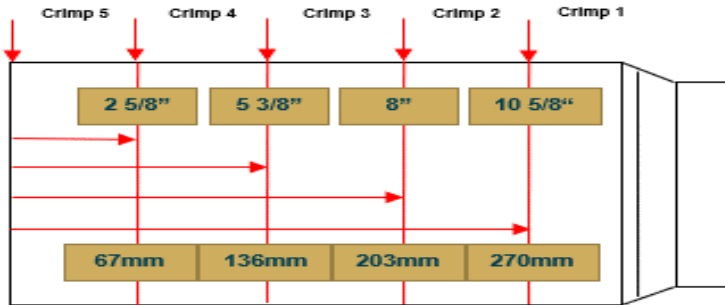
- 4 - Insert round pipe into fitting up to marked insertion line, the 5" mandrel must be inserted in two steps. Read **NOTE** on top of Page 2.

NOTE: The 5" mandrel must be inserted in two steps. The first step is to insert pipe approximately 10", then open the gate, fully open press, move the gate/pipe clamp back to the original pipe clamp mark, and slowly begin to close the press. Stop the pipe insertion once the sleeve has reached the insertion marking located on the pipe. Clamp must never be closer than 4" from the end of the sleeve to avoid damaging the reinforcement fibers during installation.

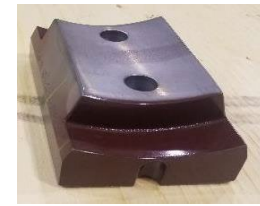
Crimping

Ensure crimper has correct die set installed: **5" FP301 = Orange & 5" FP601= Raspberry**

Crimp all fittings starting from the first crimp line mark closest to the bell of the sleeve. Ensure the edge of the die is positioned flush with your marked line. Once crimp is done, re-position crimper die flush onto next marked line towards the pipe. Repeat as necessary. For your last crimp ensure all dies are flush with the end of the sleeve.



5" FP301 HT Crimper Dies



5" FP601 HT Crimper Dies

Energize the crimper to 9000psi and hold for 20 seconds for each crimp:

Maximum Allowable Pull Force		
Pipe Size	(kg.)	(lbs.)
5"	5,103	11,250

Maximum Operation Bend Radius	
(m)	(ft)
3	10

Min Transport & Handling Bend	
(m)	(ft)
1.4	4.5

Max Scratch Depth: 3.2 mm (0.125" or 1/8 inch)

Sleeve Length & Width (uncrimped)

Type	(L)- in	(L)- mm	301 (W)- in	301 (W)- mm	601 (W)- in	601 (W)- mm
Coupling	37.05	941.07	7	177.8	7.34	186.43
Weldneck	28.37	720.59	7	177.8	7.34	186.43
Flange	23.66	600.96	7	177.8	7.34	186.43

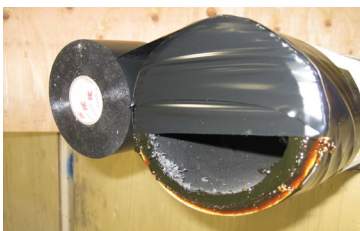
Note: Dimensions are approximate for fitting identification purposes

Completion - as per Wrapping Application section in Installation Guide

Wrap fitting in High Temp Denso Tape

Wrap either Patco/3M or Polyken Pipeline Tape tightly over Denso Tape on all fittings

Night Capping



Paste and tape all ends of exposed pipe to keep exposed fibers dry. Examples: Surface lines, In Bell Holes, Partial Reels. **For short term storage, the use of a Flexpipe shrink cap is highly recommended.**

