



Model 711 Plus RUBBER JOINTS WITH FULL FACE RUBBER FLANGES AND INTEGRAL CONTROL RODS

OPERATION, INSTALLATION AND MAINTENANCE INSTRUCTIONS

General: The Metraflex 711 Plus is an elastomeric expansion joints with full face rubber flanges and integral control rods. The 711 Plus is specifically designed for use on plastic pipe where the load put on a plastic flange from traditional control rods would damage the flange. They are designed to isolate vibration, absorb thermal expansion, and allow for minor pipe misalignment. Consult the factory submittal for specific performance specifications.

Application:

1. The 711 Plus is designed for use with standard IPS pipe flat or standard raised face steel flanges. Consult Metraflex if the joint is to be used with pipe and fittings made to other dimensions. Do not bolt directly to another component with an elastomer face.
2. Grooved Flange Adapter: If you must bolt directly to a Victaulic® flange you must use a Metraflex Transition Flange from Metraflex or equal.
3. Plastic Pipe Flanges: The full-face rubber flange allows for connection to plastic piping flanges such as PVC and fiberglass that require flat faced flange connections.
4. Check Valves: When connecting to any center guided style silent check valve, only install 711 FRP on the discharge side.
5. The Model 711 Plus is available in a wide range of elastomers. Check the compatibility of the elastomer selected for the application

Joint Preparation

1. Before installation check the interior, exterior and flange faces of the expansion joint for cuts or gouges.
2. Care must be used when pushing the joint into the breach between the mating flanges.
3. It is acceptable (but not necessary) to lubricate the expansion joint flanges with a thin film of graphite dispersed in glycerin or water to ease installation and disassembly.

Installation:

1. Install at face-to-face dimension shown on drawing/catalog. Installation at different lengths or between flanges that are not parallel can lead to failure. Under no circumstance are flange bolts to be used to stretch the joint into contact with a mating flange. Installation tolerance for overall length and misalignment is 1/8"
2. **DO NOT** use gaskets between the wide arch joint and the mating flange surface.
3. If bolt threads are facing the joint, trim the length of the bolts so they do not extend past the nut more than 2 threads or 1/8" to avoid contact with the joint.
4. Using plated steel washers between the nut and the flange is required at the split between backing rings.
5. Bolt Torque. Use a torque wrench and the criss-cross method to apply torque to the nuts. First, uniformly torque the nuts to approximately 60% of the minimum torque. Ensure that the gap between the flanges is even around the flange. Then complete the tightening process. The gap between the flanges must be uniform when finished. **Recommended flange bolt torque for the following joint sizes is: 1" to 2" – 45 ft-lb, 2-1/2" to 8" - 60 ft-lb, 10" to 20" – 80 ft lb. Do not over tighten to the point where there is metal to metal contact between the joint flange and the mating flange. NOTE – Rubber tends to relax after initial tightening, so it is necessary to retighten the flange bolts 24 hours after initial installation to the recommended torque. We recommend rechecking the torque after 3 weeks.**
6. It may be necessary to reset the integral control rods if they were removed for installation or to limit the maximum amount of extension.
7. Do not paint or insulate the joint, except when Hypalon is applied as a UV protectant.

Testing:

1. Joint may be one-time pressure tested to 1.5 times the product's maximum operating pressure. Do not exceed maximum pressure or temperature during operation.
2. The integral control rods should be set prior to testing the system.

Storage: Ideal storage is a warehouse with a relatively dry, cool location. Store flange face down on a pallet or wooden platform. Do not store heavy items on top of an expansion joint. Ten year shelf-life can be expected with ideal conditions. If storage must be outdoors joint should be placed on wooden platforms and should not be in contact with the ground. Cover with a tarp to prevent exposure to sunlight/UV rays.

Large Joint Handling: Do not lift with ropes or bars through the bolt holes. If lifting through the bore, use padding or a saddle to distribute the weight. Make sure cables or forklift tines do not contact rubber.

Maintenance: Periodically inspect the joint for bolt torque, damage, cracking or hardening. The Wide Arch rubber joint has no serviceable parts.

Note: Some of this information has been taken from the Fluid Sealing Association Handbook on Non-Metallic Expansion Joints.

Contact Metraflex or your local Metraflex Representative with any questions.

