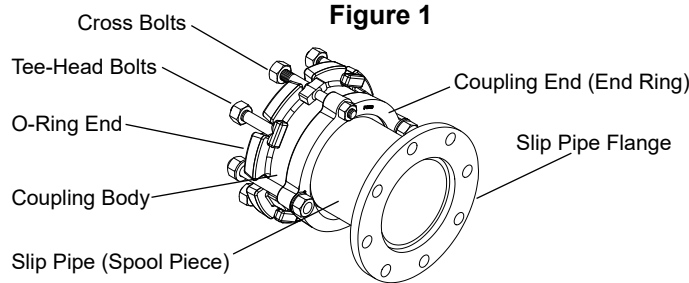


Ford Dismantling Joint - FDJ (FFCA Style 3" - 12") Installation Instructions

Refer to the Ford website (www.fordmeterbox.com) for additional and most recent installation instructions and product information.

1. Remove plastic ties from assembly.
2. Inspect all FDJ parts to ensure no damage has occurred. Verify the mating flanges to ensure they match the FDJ drilling. Verify the space requirements for the dismantling joint to function properly. **The spool piece must remain inserted a minimum of 2 inches into the flange coupling body at final assembly.**
3. Remove nuts from cross bolts on o-ring end of assembly. See Figure 1.
4. Retract nuts to full extent of cross bolts on coupling end of assembly. Properly block and shim all components for safety and alignment.
5. Install o-ring end of contracted FDJ assembly first by inserting cross bolts into flanged end of mating pipeline and loosely install nuts. Do not tighten at this time. Place tee-head bolts into vacant bolt slots on assembly and into mating flange and install nuts. Evenly and alternately tighten all fasteners at o-ring end to secure flange. (Do not yet tighten coupling end ring [cross bolt] fasteners until Step 9.)
6. (See chart and sketch below for component identification and torque values).
7. Expand to mate slip pipe flange to flanged end of pipeline. Ensure a proper flange gasket (not supplied) is in place between flanges.
8. Install flange bolts (not supplied) and tighten to manufacturer's specifications.
9. Evenly and alternately tighten 5/8" cross bolts nuts on coupling ring end of assembly to 60-70 FT-LB.
10. Recheck the torque on all bolts after line pressurization.



SIZE	O-RING END		COUPLING END
	Cross Bolts	T-Bolts	Cross Bolts
3" & 4" FDJ	(5/8") 60-70 ft. lb.	(5/8") 60-70 ft. lb.	(5/8") 60-70 ft. lb.
6" FDJ	(3/4") 75-90 ft. lb.	(3/4") 75-90 ft. lb.	(5/8") 60-70 ft. lb.
8" FDJ	(3/4") 75-90 ft. lb.	N/A	(5/8") 60-70 ft. lb.
10" FDJ	(7/8") 90-110 ft. lb.	N/A	(5/8") 60-70 ft. lb.
12" FDJ	(7/8") 90-110 ft. lb.	N/A	(5/8") 60-70 ft. lb.

Ford Dismantling Joint with Tie Rods - FDJ-R (FFCA Style 3"-12") Installation Instructions

1. Remove plastic ties from assembly.
2. Inspect all FDJ parts to ensure no damage has occurred. Verify the mating flanges match the FDJ flange drilling. Verify the space requirements for the dismantling joint to function properly. **The spool piece must remain inserted a minimum of 2 inches into the flange coupling body at final assembly.**
3. Remove nuts from cross bolts on o-ring end of assembly.
4. Retract nuts to full extent of cross bolts on coupling end ring. Contract the FDJ-R assembly. Properly block and shim all components for proper safety and alignment.
5. Install o-ring end of contracted FDJ-R assembly by attaching the flanged end of mating pipeline onto the cross bolts and loosely install nuts. Make sure to leave two sets of corresponding holes (from flange to flange) open on both flanges 180 degrees apart to accommodate the tie-rods. Do not tighten at this time.
6. Insert the tie-rods into the o-ring end flange holes remaining open. Make sure to thread two nuts (on each rod) between the coupling end ring and the back of the slip pipe flange prior to inserting the rods through the slip pipe flange. The ends of the rods must be positioned to extend through the mating flanges on each end (enough to receive and tighten the nuts) and through the coupling end ring. See Figure 2. (10" & 12" coupling end rings have enlarged holes to allow the tie-rods to pass.) Tighten the o-ring end tee-head/cross bolts to secure the mating flange. (See chart above for torque values.) Make sure the tie-rod nuts at the o-ring end and coupling end ring remain loose to allow proper tightening of all remaining flange bolts.
7. Expand the slip pipe flange to flanged end of pipeline **leaving the slip pipe a minimum of 2 inches into the flange coupling body at final assembly.** Ensure a proper flange gasket (not supplied) is in place between flanges.
8. Place tee-head bolts (flange bolts), not supplied, into all vacant bolt slots on assembly into slip pipe flange flange and install nuts. Evenly and alternately tighten all tee-head bolts (flange bolts) and tighten to manufacturer's specifications.
9. Snug the two tie rod nuts against the inside of the slip pipe flange. Tighten the two inside tie-rod nuts that secure the flange to the same torque as the cross bolts on the o-ring end.) Hold one and tighten the other.
10. Evenly and alternately tighten 5/8" nuts on coupling flange end of assembly and the two tie rod nuts against the coupling end ring nuts to 60-70 FT-LB.
11. Recheck the torque on all bolts after line pressurization.

