



Square to Round Coupler

Installation Quick Sheet

631863

Installation

1. Install expeller and/or expeller tube so that the square tube and round tube to be joined are 1.375" [34.93mm] apart. **NOTE:** *This dimension is critical to the proper installation of the coupler.* Holes may need to be drilled in both the square and/or round tubes. Drill (2) $\varnothing.531$ " [13.5mm] thru-holes in the ends of the round tube and (2) $\varnothing.397$ " [10.1mm] thru-holes in the ends of the square tube. Locating dimensions are shown in Figure 1.
2. Assemble (1) round expeller tube or coupler tube (631818) to each round tube coupler by attaching (1) inner coupler (631860) and (1) outer coupler (631859) to each round expeller tube (or coupler tube) using (2) 1/2-13 x 3-3/4" hex bolts (011101) and (2) 1/2-13 hex nuts (011103) per pair. **Round couplers** should be installed so they overlap *vertically*; the inner coupler slides inside the outer coupler. The *vertical* bolts should be installed first; tightening them draws the couplers toward each other, bringing the horizontal bolt holes in line so bolts can be installed and tightened afterwards, as shown in Figure 2.
3. Assemble (1) square expeller tube to each square tube coupler by attaching (1) inner coupler (631862) and (1) outer coupler (631861) to each square expeller tube using (2) 3/8-16 x 2-3/4" hex bolts (011102) and (2) 3/8-16 hex nuts (011104) per pair. **Square couplers** should be installed so they overlap *horizontally*; the inner coupler slides inside the outer coupler. The *horizontal* bolts should be installed first; tightening them draws the couplers toward each other, bringing the vertical bolt holes in line so bolts can be installed and tightened afterwards, as shown in Figure 3.

Figure 1

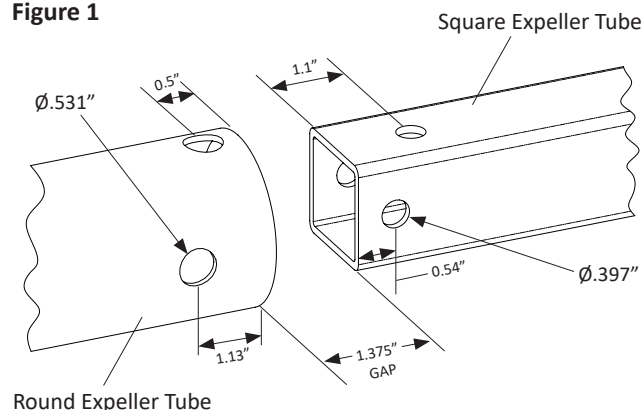


Figure 2

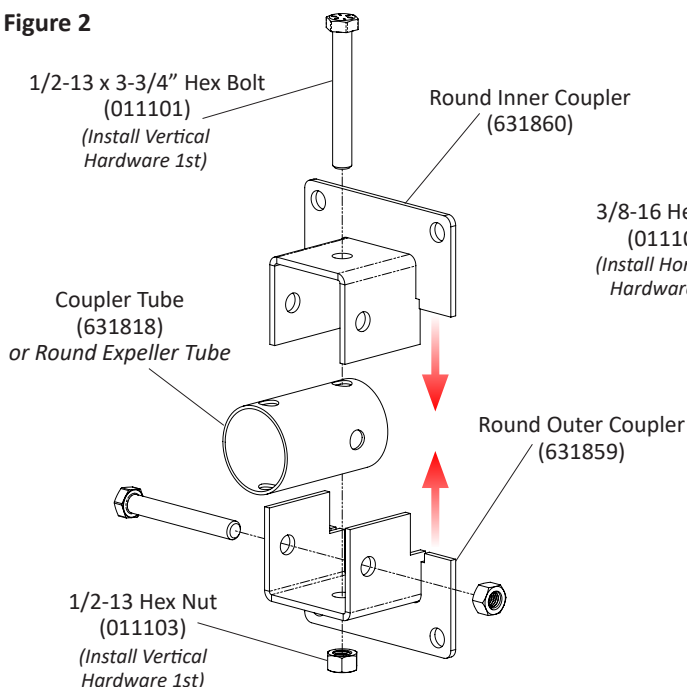
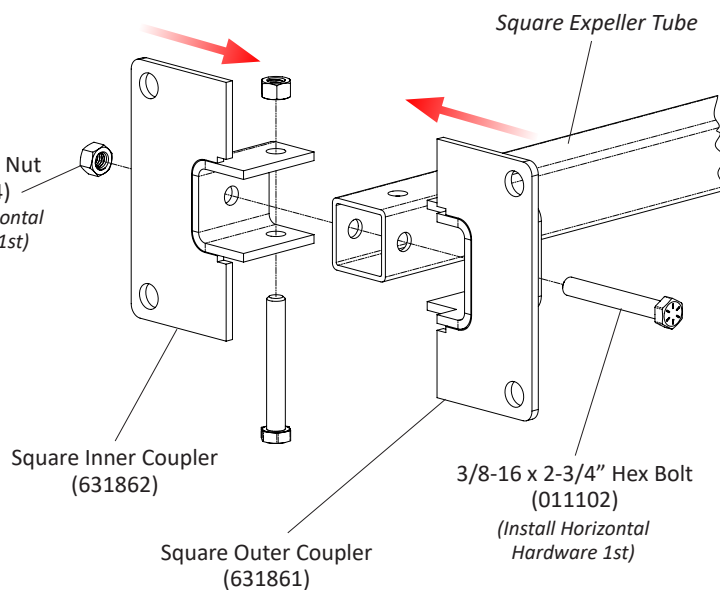


Figure 3



Installation - continued

4. Use (4) 1/2-13 X 1" hex bolts (011105) and (4) 1/2-13 hex nuts (011103) to join the pre-assembled round and square couplers together, as shown in Figure 4. Tighten all hardware. Figure 5 shows the coupler fully assembled.

Figure 4

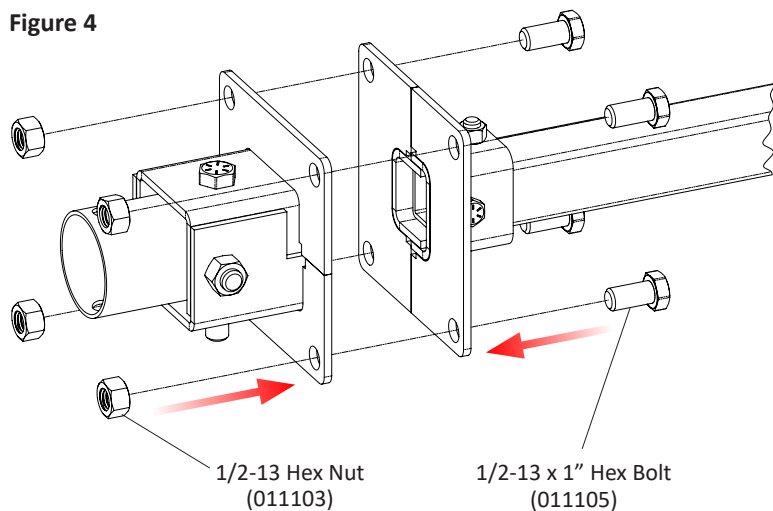
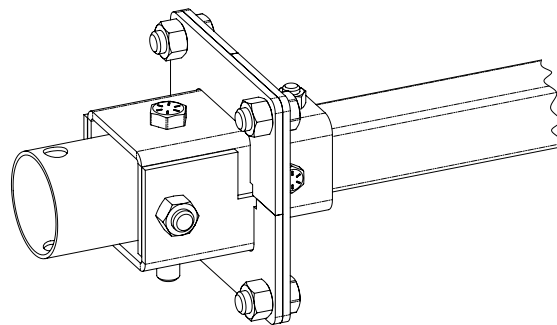
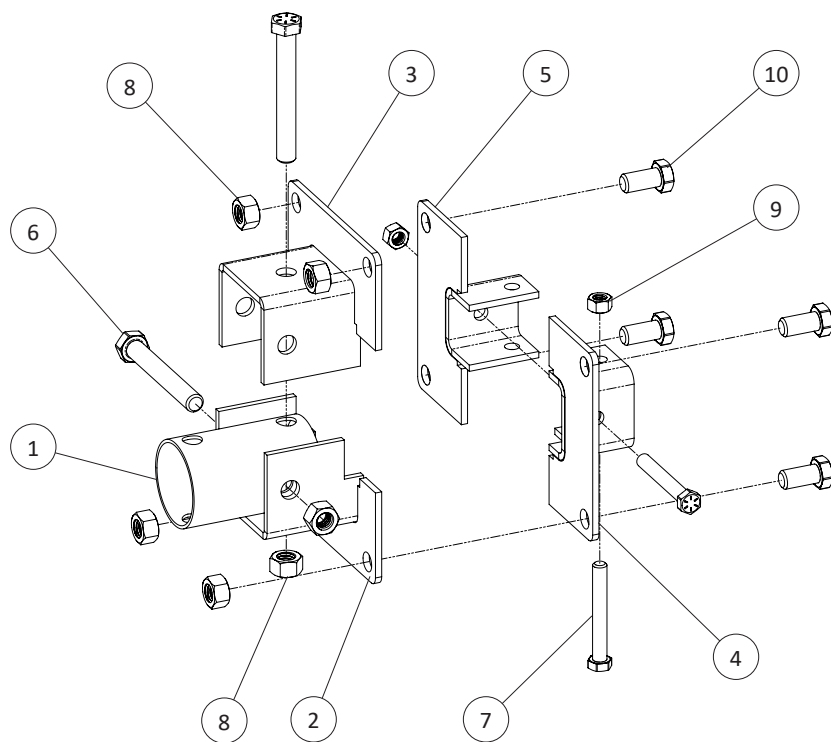


Figure 5



Parts List



ITEM #	PART #	QTY	DESCRIPTION
SQUARE TO ROUND COUPLER KIT (631863)			
1	631818	4	TUBE, COUPLER, 3.7"
2	631859	4	COUPLER, ROUND, OUTER
3	631860	4	COUPLER, ROUND, INNER
4	631861	4	COUPLER, SQUARE, OUTER
5	631862	4	COUPLER, SQUARE, INNER
HDW BAG, SQUARE TO ROUND COUPLER (631864)			
6	011101	8	1/2-13 X 3-3/4" HEX BOLT
7	011102	8	3/8-16 X 2-3/4" HEX BOLT
8	011103	24	1/2-13 HEX NUT
9	011104	8	3/8-16 HEX NUT
10	011105	16	1/2-13 X 1" HEX BOLT

North America:

Phone: 800.99VALCO; 800.998.2526

Fax: 419.678.2200

Email: sales@val-co.com

990346

[-]

International:

Phone: (+1) 419.678.8731

Fax: (+1) 419.678.2200

Email: intl.sales@val-co.com