

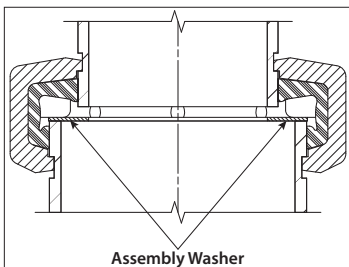
! WARNING



- Read and understand all instructions before attempting to install any Victaulic piping products.
 - Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.
 - Wear safety glasses, hardhat, and foot protection.
- Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.

NOTICE

- Victaulic #60 End Caps must not be used on the smaller end of Style 750 Reducing Couplings in systems where vacuums may develop.



Assembly Washer

FOR VERTICAL INSTALLATIONS: An assembly washer is recommended to prevent smaller pipe from telescoping inside larger pipe in vertical installations (refer to graphic above). Contact Victaulic for details.



1. CHECK PIPE ENDS: The outside surface of the pipe, between the groove and the pipe end, must be smooth and free from indentations, projections (including weld seams), and roll marks to ensure a leak-tight seal. All oil, grease, loose paint, dirt, and cutting particles must be removed.



2. CHECK GASKET AND

LUBRICATE: Check the gasket to make sure it is suitable for the intended service. Apply a thin coat of Victaulic Lubricant or silicone lubricant to the gasket sealing lips and exterior.

! CAUTION

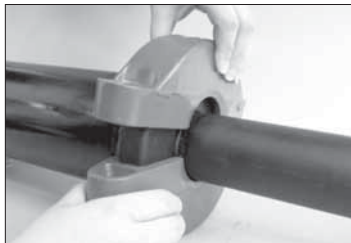
- Always use a compatible lubricant to prevent the gasket from pinching/tearing during installation. Failure to follow this instruction could result in joint leakage.



3. INSTALL GASKET: Install the larger opening of the gasket over the larger pipe end. Make sure no portion of the gasket extends into the pipe groove.



4. JOIN PIPE ENDS: Align the centerlines of the pipes and insert the smaller pipe end into the gasket. Make sure no portion of the gasket extends into the pipe groove.



5. INSTALL HOUSINGS: Install the housings over the gasket. Make sure the larger openings of the housings face the larger pipe and that the housings' keys engage the grooves completely on both pipe ends.



CAUTION

- Make sure the gasket does not become rolled or pinched while installing the housings.

Failure to follow this instruction could cause damage to the gasket, resulting in joint leakage.



6. INSTALL BOLTS/NUTS: Install the bolts, and thread a nut finger-tight onto each bolt. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.



7. TIGHTEN NUTS: Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. Make sure the housings' keys engage the grooves completely. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching.

7a. Visually inspect the bolt pads at each joint to ensure metal-to-metal contact is achieved.



WARNING

- For proper assembly, the nuts must be tightened until metal-to-metal contact occurs at the bolt pads.
- Keep hands away from coupling openings during tightening.

Failure to follow these instructions could cause joint failure, serious personal injury, and property damage.

Style 750 Helpful Information

Size	Nut Size	Socket Size
Nominal Size inches/ Actual mm	inches/ Metric	inches/ mm
2 x 1 – 1 1/2 60.3 x 33.7 – 48.3	3/8 M10	1 1/16 17
2 1/2 x 2 73.0 x 60.3	3/8 M10	1 1/16 17
76.1 mm x 2 60.3	1/2 M12	7/8 22
3 x 2 – 2 1/2 88.9 x 60.3 – 73.0	1/2 M12	7/8 22
76.1 mm	1/2 M12	7/8 22
4 x 2 – 3 114.3 x 60.3 – 88.9	5/8 M16	1 1/16 27
114.3 mm x 76.1 mm	5/8 M16	1 1/16 27
5 x 4 141.3 x 114.3	3/4 M20	1 1/4 32
6 x 4 – 5 168.3 x 114.3 – 141.3	3/4 M20	1 1/4 32
165.1 mm x 114.3 mm	3/4 M20	1 1/4 32
8 x 6 219.1 x 168.3	7/8 M22	1 7/16 36
10 x 8 273.0 x 219.1	1 M24	1 5/8 41