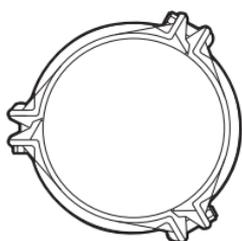


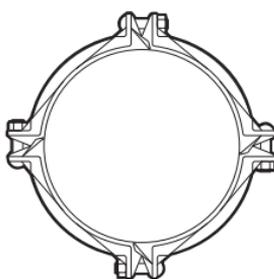
Style 07 (Non-AGS) - Zero-Flex Rigid Coupling (14-inch/355.6-mm and Larger Sizes)

⚠ WARNING				
				
<ul style="list-style-type: none">• 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. <p>Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.</p>				

Style 07 Couplings in 14-inch/355.6-mm and larger sizes are cast, as shown below, to ease handling.



Typical 14 – 18-inch/
355.6 – 457-mm Sizes



Typical 20 – 24-inch/
508 – 610-mm Sizes

1. Follow steps 1 – 4 of the “Preparatory Steps for Coupling Installation” section.



2. ASSEMBLE SEGMENTS:

Assemble the segments loosely (nuts should be flush with ends of bolts), leaving one bolt and nut off to allow for the “swing-over” feature, or assemble the segments loosely into two equal halves (whichever permits easier handling).



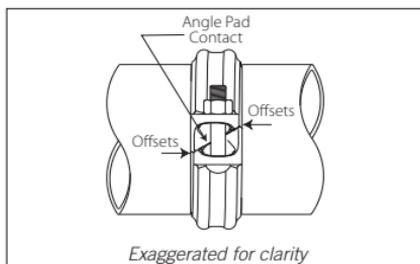
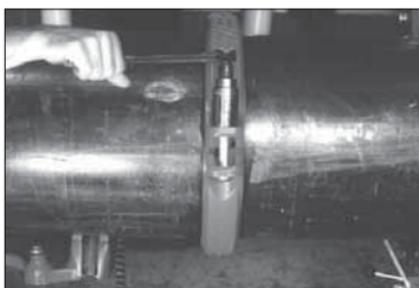
3. INSTALL HOUSINGS: Using the “swing-over” feature, install the housings over the gasket. Make sure the housings’ keys engage the grooves completely on both pipe ends.

⚠ 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.



- 4. INSTALL REMAINING BOLT/NUT:** While supporting the weight of the assembly, install the remaining bolt, and thread the nut finger-tight onto the bolt.
NOTE: Make sure the oval neck of each bolt seats properly in the bolt hole.



- 5. TIGHTEN NUTS:** Tighten all nuts evenly by alternating bolt pads until metal-to-metal contact occurs at the angle bolt pads. Make sure the housings' keys engage the grooves completely on both pipe ends and that the offsets are equal at the bolt pads. Equal, positive offsets are necessary to ensure a rigid joint (refer to the example above). **NOTE:** It is important to tighten all nuts evenly to prevent gasket pinching.

- 5a. APPLY TORQUE:** Apply torque to each nut with a torque wrench. Refer to the following table for the torque requirement. **NOTE:** If the required torque is achieved before metal-to-metal contact occurs at the angle bolt pads, check the assembly by referring to the requirements in the "Installation Inspection" section.

- 6.** Inspect the bolt pads of each coupling to ensure proper assembly is achieved.

Style 07 Torque Requirements

Size		Torque Requirements
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	ft-lbs N•m
14 – 18	14.000 – 18.000	250
	355.6 – 457	339
20 – 24	20.000 – 24.000	300
	508 – 610	407

⚠ WARNING

- For Victaulic Style 07 Couplings in 14-inch/355.6-mm and larger sizes, the nuts must be tightened evenly by alternating sides until metal-to-metal contact occurs at the bolt pads and the required torque value is achieved.
 - For Victaulic rigid, angle-bolt-pad couplings, equal offsets must be present 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 07 Helpful Information

Nominal Size inches	Size	Style 07	
	Actual Pipe Outside Diameter inches/mm	Nut Size inches/Metric	Socket Size inches/mm
14 – 18	14.000 – 18.000	7/8 M22	1 1/16 36
	355.6 – 457		
20 – 24	20.000 – 24.000	1 M24	1 5/8 41
	508 – 610		