

Style 75 - Flexible Coupling

Style 77 - Flexible Coupling - Two Segments for 24-inch/610-mm and Smaller Sizes

Style 77A - Flexible Aluminum Coupling

Style 77S - Flexible Stainless Steel Coupling

Style 77DX - Flexible Stainless Steel Coupling for Duplex and Super Duplex Pipe

Style 475 - Flexible Stainless Steel Coupling

Style 475DX - Flexible Stainless Steel Coupling for Duplex and Super Duplex Pipe

⚠ 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

- The following installation steps feature photos of a Style 77 Coupling. However, the same installation steps apply to Styles 75, 77A, 77S, 77DX, 475, and 475DX Couplings in the size ranges listed above.

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

NOTICE

For Styles 475/475DX Couplings Only:

- Styles 475/475DX Couplings have a tongue-and-recess feature at the bolt pads. The housings’ tongue and recess features must be mated properly (tongue in recess).



2. **INSTALL HOUSINGS:** Install the housings over the gasket. Make sure the housings’ keys engage the grooves completely on both pipe ends. Refer to the notice above for Styles 475/475DX Couplings.

⚠ 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.

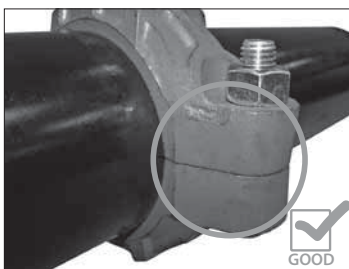


3. **INSTALL BOLTS/NUTS:** Install the bolts, and thread a nut finger-tight onto each bolt. For couplings supplied with stainless steel hardware, apply an anti-seize compound to the bolt threads. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.

NOTICE

For 3/4 - 6-inch/26.9 - 168.3-mm Styles 77S and 77DX Flexible Stainless Steel Couplings Only:

- A flat washer must be installed under each nut.

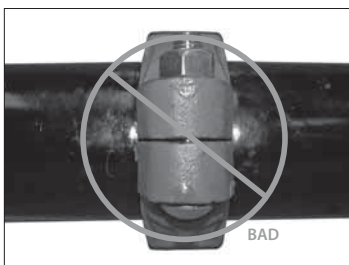


4. TIGHTEN NUTS: Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. Make sure the housings' keys engage the grooves completely. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching.

⚠ 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.



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

Style 75, 77, 77S, and 475/475DX Helpful Information

Size		Style 75		Style 77		Styles 77S/77DX		Styles 475/475DX	
Nominal Size inches or mm	Actual Pipe Outside Diameter inches mm	Nut Size inches/ Metric	Socket Size inches/ mm	Nut Size inches/ Metric	Socket Size inches/ mm	Nut Size inches/ Metric	Socket Size inches/ mm	Nut Size inches/ Metric	Socket Size inches/ mm
¾	1.050 26.9	—	—	¾ M10	1 1/16 17	¾ M10	1 1/16 17	—	—
1	1.315 33.7	¾ M10	1 1/16 17	¾ M10	1 1/16 17	¾ M10	1 1/16 17	¾ M10	1 1/16 17
1 ¼	1.660 42.4	¾ M10	1 1/16 17	½ M12	7/8 22	¾ M10	1 1/16 17	¾ M10	1 1/16 17
1 ½	1.900 48.3	¾ M10	1 1/16 17	½ M12	7/8 22	¾ M10	1 1/16 17	¾ M10	1 1/16 17
2	2.375 60.3	¾ M10	1 1/16 17	½ M12	7/8 22	¾ M10	1 1/16 17	¾ M10	1 1/16 17
2 ½	2.875 73.0	¾ M10	1 1/16 17	½ M12	7/8 22	¾ M10	1 1/16 17	¾ M10	1 1/16 17
76.1 mm	3.000 76.1	¾ M10	1 1/16 17	½ M12	7/8 22	—	—	¾ M10	1 1/16 17
3	3.500 88.9	½ M12	7/8 22	½ M12	7/8 22	½ M12	7/8 22	½ M12	7/8 22
3 ½	4.000 101.6	½ M12	7/8 22	5/8 M16	1 1/16 27	—	—	—	—
4	4.500 114.3	½ M12	7/8 22	5/8 M16	1 1/16 27	5/8 M16	1 1/16 27	½ M12	7/8 22
108.0mm	4.250 108.0	½ M12	7/8 22	5/8 M16	1 1/16 27	—	—	—	—



Style 75, 77, 77S, and 475/475DX Helpful Information (Continued)

Size		Style 75		Style 77		Style 77S/77DX		Styles 475/475DX	
Nominal Size inches or mm	Actual Pipe Outside Diameter inches mm	Nut Size inches/Metric	Socket Size inches/mm	Nut Size inches/Metric	Socket Size inches/mm	Nut Size inches/Metric	Socket Size inches/mm	Nut Size inches/Metric	Socket Size inches/mm
127.0 mm	5.000 127.0	5/8 M16	1 1/16 27	—	—	—	—	—	—
5	5.563 141.3	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	—	—	—	—
133.0 mm	5.250 133.0	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	—	—	—	—
139.7 mm*	5.500 139.7	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	—	—	1/2 M12	7/8 22
152.4 mm	6.000 152.4	5/8 M16	1 1/16 27	—	—	—	—	—	—
6	6.625 168.3	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	5/8# M16	1 1/16# 27	—	—
159.0 mm	6.250 159.0	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	—	—	—	—
165.1 mm*	6.500 165.1	5/8 M16	1 1/16 27	3/4 M20	1 1/4 32	—	—	5/8 M16	1 1/16 27
203.2 mm	8.000 203.2	3/4 M20	1 1/4 32	—	—	—	—	—	—
8§	8.625 219.1	3/4 M20	1 1/4 32	7/8 M22	1 7/16 36	7/8 M22	1 7/16 36	—	—
254.0 mm	10.000 254.0	7/8 M22	1 7/16 36	—	—	—	—	—	—
10§	10.750 273.0	—	—	1 M24	1 5/8 41	1 M24	1 5/8 41	—	—
304.8 mm	12.000 304.8	7/8 M22	1 7/16 36	—	—	—	—	—	—
12§	12.750 323.9	—	—	1 M24	1 5/8 41	1 M24	1 5/8 41	—	—
13 1/2 OD	13.000 342.9	—	—	1 M24	1 5/8 41	—	—	—	—
200A (JIS)	— 216.3	3/4 M20	1 1/4 32	7/8 M22	1 7/16 36	—	—	—	—
250A (JIS)	— 267.4	—	—	1 M24	1 5/8 41	—	—	—	—
300A (JIS)	— 318.5	—	—	1 M24	1 5/8 41	—	—	—	—
14§	14.000 355.6	—	—	1 M24	1 5/8 41	1 M24	1 5/8 41	—	—
16§	16.000 406.4	—	—	1 M24	1 5/8 41	1 M24	1 5/8 41	—	—
18§	18.000 457	—	—	1 1/8 M27	1 13/16 46	1 M24	1 5/8 41	—	—
20	20.000 508	—	—	1 1/8 M27	1 13/16 46	—	—	—	—
24	24.000 610	—	—	1 1/8 M27	1 13/16 46	—	—	—	—

* Style 475DX Flexible Stainless Steel Couplings are not available in these sizes

The nut size for 6-inch/168.3-mm Style 77DX Couplings is 3/4 inch/M20. The socket size is 1 1/4 inch/32 mm.

§ Style 77DX Couplings are not available in these sizes

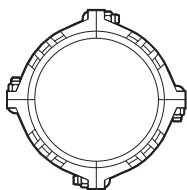
Style 77 (Non-AGS) - Flexible Coupling - Four or Six Segments for 14-inch/355.6-mm and Larger Sizes

! WARNING

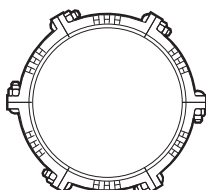


- Read and understand all instructions before attempting to install any Victaulic piping products.
 - Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.
 - Wear safety glasses, hardhat, and foot protection.
- Failure to follow these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

Style 77 Couplings in 14-inch/355.6-mm and larger sizes are cast, as shown below, to ease handling.

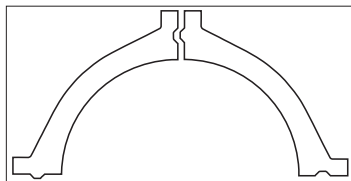
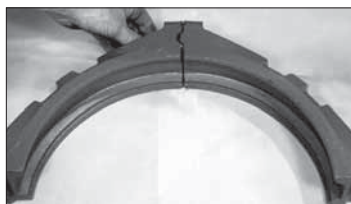


14 – 22-inch/355.6 – 559-mm Sizes



24-inch/610-mm Size

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



2. ASSEMBLE SEGMENTS:

Assemble the segments loosely into two equal halves, as shown above. Allow clearance between the segments to ease assembly onto the pipe. **NOTE:** For bolt pads that contain a tongue-and-recess feature, make sure the housings are mated, as shown above.

! 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.



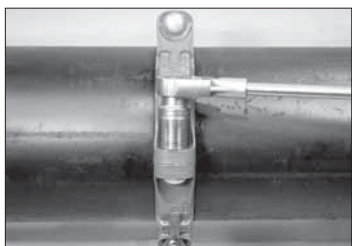
3. INSTALL FIRST SEGMENT ASSEMBLY:

Install one of the pre-assembled halves over the gasket. Make sure the housings' keys engage the grooves completely on both pipe ends.





3a. INSTALL REMAINING SEGMENT ASSEMBLY: Install the second assembly onto the pipe. Make sure the housings' keys engage the grooves completely on both pipe ends. While supporting the weight of the assembly, install the remaining bolts, and thread the nuts finger-tight onto the bolts. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.



4. TIGHTEN NUTS: Tighten all 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 all nuts evenly to prevent gasket pinching.

4a. Visually inspect the bolt pads at each joint to ensure metal-to-metal contact is achieved.

CAUTION

- 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 77 Helpful Information

Nominal Size inches or mm	Size		Style 77	
	Actual Pipe Outside Diameter inches/mm	Nut Size inches/ Metric	Socket Size inches/ mm	
14 – 18	14.000 – 18.000 355.6 – 457	1 M24	1 5/8 41	
20 – 24	20.000 – 24.000 508 – 610	1 1/8 M27	1 13/16 46	
28 – 30	28.000 – 30.000 711 – 762	1 M24	1 5/8 41	
377.0mm	14.842 377.0	1 M24	1 5/8 41	
426.0mm	16.771 426.0	1 M24	1 5/8 41	
480.0mm	18.897 480.0	1 1/8 M27	1 13/16 46	
530.0mm	20.866 530.0	1 1/8 M27	1 13/16 46	
630.0mm	24.803 630.0	1 1/8 M27	1 13/16 46	