

# **Vic-Press Schedule 10S System Products for Schedules 5S and 10S Stainless Steel Pipe**

## **Installation Instructions**



## CAUTION

- **DO NOT** force the pipe into the coupling or fitting.
- Insert the pipe into the coupling or fitting with a slight twisting action to ease insertion.

Forcing the pipe into position may cause damage to the seal, resulting in joint leakage and/or property damage.



### 2. For Standard Couplings and Fittings:

Insert the pipe into the coupling or fitting with a slight twisting action to ease insertion. The pipe must contact the pipe stop inside the coupling or fitting. Make sure the pipe is inserted fully up to the mark that was made in previous steps.

**2a. For Slip Couplings:** Insert the pipe into the slip coupling with a slight twisting action to ease insertion. Since slip couplings do not contain a pipe stop, make sure the pipe is inserted fully up to the mark that was made in the “Vic-Press Schedule 10S Slip Couplings” section.



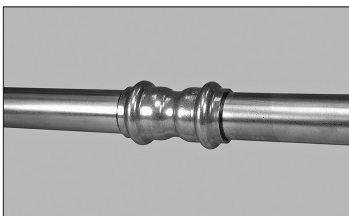
## WARNING

- Before operating the Victaulic PFT510 Vic-Press Schedule 10S Tool, read and understand the TM-PFT510 Operating and Maintenance Manual and all labels on the tool.
- **DO NOT ALTER THE PFT510 VIC-PRESS SCHEDULE 10S TOOL OR JAWS IN ANY WAY. ALTERATIONS TO ANY TOOL COMPONENTS WILL VOID THE VICTAULIC WARRANTY.**

Failure to follow instructions may result in serious personal injury, improper tool operation, improper joint assembly, and property damage.

## NOTICE

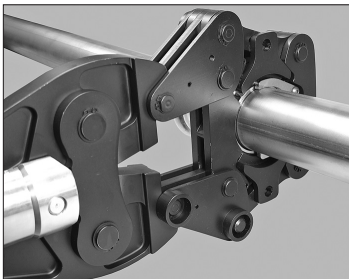
- For Vic-Press Schedule 10S System Products with threaded connections, the outlet section of the fitting must be held rigid with a pipe wrench during tightening.



Standard Vic-Press Jaw for ½-inch/21.3-mm, ¾-inch/26.9-mm, and 1-inch/33.7-mm Sizes



Press Ring/Vic-Press Adapter Jaw Assembly for 1½-inch/48.3-mm and 2-inch/60.3-mm Sizes



**3.** Align the pipe. Make sure the joint is straight and the pipe marks indicate full insertion into the coupling or fitting before performing the pressing operation. The PFT510 Vic-Press Schedule 10S Tool will not straighten a deflected joint during the pressing operation. Straight joints can be achieved through proper supports and careful tool handling. **NOTE:** For 1½-inch/48.3-mm and 2-inch/60.3-mm sizes, the press ring/Vic-Press adapter jaw assembly (shown above) must be utilized. Always refer to the TM-PFT510 Operating and Maintenance Manual for details on proper tool setup and operation.

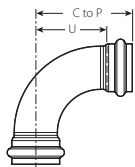
# VIC-PRESS SCHEDULE 10S SYSTEM FITTINGS

Styles P568 and P586 – 90° Elbows (P x P)

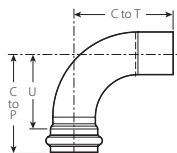
Styles P562 and P542 – 90° Street Elbows (P x T)

Styles P571 and P591 – 45° Elbows (P x P)

Styles P563 and P543 – 45° Street Elbows (P x T)



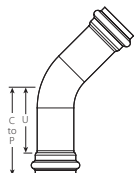
STYLES P568 AND P586



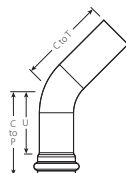
STYLES P562 AND P542

| Size                      |   | Styles P568 and P586<br>90° Elbows |                           | Styles P562 and P542<br>90° Street Elbows |                           |               |
|---------------------------|---|------------------------------------|---------------------------|---|---------------------------|---------------|
| Nominal Size<br>inches/mm | Actual Pipe Outside Diameter<br>inches/mm | C to P<br>inches/mm                | U<br>Takeout<br>inches/mm | C to P*<br>inches/mm                      | U<br>Takeout<br>inches/mm | C to T        |
| ½<br>15                   | 0.840<br>21.3                             | 2.64<br>67.1                       | 1.53<br>38.9              | 2.64<br>67.1                              | 1.53<br>38.9              | 3.04<br>77.2  |
| ¾<br>20                   | 1.050<br>26.7                             | 2.95<br>74.9                       | 1.89<br>48.0              | 2.95<br>74.9                              | 1.89<br>48.0              | 3.35<br>85.1  |
| 1<br>25                   | 1.315<br>33.7                             | 3.52<br>89.4                       | 2.33<br>59.2              | 3.52<br>89.4                              | 2.33<br>59.2              | 4.32<br>109.7 |
| 1 ½<br>40                 | 1.900<br>48.3                             | 4.55<br>115.6                      | 3.18<br>80.8              | 4.55<br>115.6                             | 3.18<br>80.8              | 4.55<br>115.6 |
| 2<br>50                   | 2.375<br>60.3                             | 5.52<br>140.2                      | 3.90<br>99.1              | 5.52<br>140.2                             | 3.90<br>99.1              | 5.52<br>140.2 |

\* C to T dimensions for Styles P562 and P542 are equivalent to the C to P dimensions



STYLES P571 AND P591



STYLES P563 AND P543

| Size                      |   | Styles P571 and P591<br>45° Elbows |                           | Styles P563 and P543<br>45° Street Elbows |                           |               |
|---------------------------|---|------------------------------------|---------------------------|---|---------------------------|---------------|
| Nominal Size<br>inches/mm | Actual Pipe Outside Diameter<br>inches/mm | C to P<br>inches/mm                | U<br>Takeout<br>inches/mm | C to P*<br>inches/mm                      | U<br>Takeout<br>inches/mm | C to T        |
| ½<br>15                   | 0.840<br>21.3                             | 1.89<br>48.0                       | 0.83<br>21.1              | 1.89<br>48.0                              | 0.83<br>21.1              | 1.89<br>48.0  |
| ¾<br>20                   | 1.050<br>26.7                             | 2.56<br>65.0                       | 1.50<br>38.1              | 2.56<br>65.0                              | 1.50<br>38.1              | 2.56<br>65.0  |
| 1<br>25                   | 1.315<br>33.7                             | 3.27<br>83.1                       | 2.09<br>53.1              | 3.27<br>83.1                              | 2.09<br>53.1              | 3.27<br>83.1  |
| 1 ½<br>40                 | 1.900<br>48.3                             | 4.96<br>126.0                      | 3.59<br>91.2              | 4.96<br>126.0                             | 3.59<br>91.2              | 4.96<br>126.0 |
| 2<br>50                   | 2.375<br>60.3                             | 5.84<br>148.3                      | 4.22<br>107.2             | 5.84<br>148.3                             | 4.22<br>107.2             | 5.84<br>148.3 |

\* C to T dimensions for Styles P563 and P543 are equivalent to the C to P dimensions

⚠ Always refer to the current Victaulic submittal publication in the G-100 General Catalog or on the website [www.victaulic.com](http://www.victaulic.com) for the most up-to-date dimensional information.

