

**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.

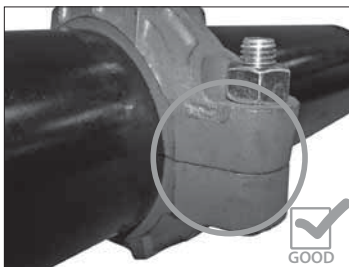


3. **INSTALL BOLTS/NUTS:** Install the bolts, and thread a nut finger-tight onto each bolt. For couplings supplied with stainless steel hardware, apply an anti-seize compound to the bolt threads. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.

## 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.

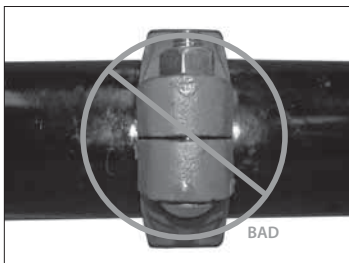


**4. TIGHTEN NUTS:** Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. Make sure the housings' keys engage the grooves completely. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching.

### **⚠ 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