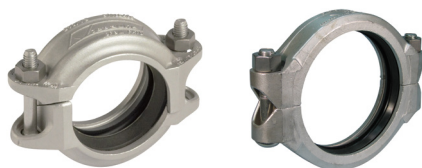


Victaulic® Stainless Steel Rigid Coupling

Style 489



1.0 PRODUCT DESCRIPTION

Available Sizes:

- 1 ½ – 12"/DN40 – DN300

Pipe Material:

- Stainless steel

Maximum Working Pressure:

- Accommodates pressures up to 600 psi/4136 kPa
- Working pressure dependent on material, wall thickness and size of pipe

Application:

- Provides a rigid pipe joint designed to restrict axial or angular movement

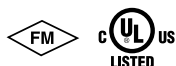
Pipe Preparation:

- Exclusively for use with fittings, valves, accessories and pipe which feature ends formed with the Victaulic OGS groove profile (see Section 7.0 for Reference Materials)

NOTE

- For duplex and super duplex options, please see [publication 17.33](#) for the Style 489DX coupling.

2.0 CERTIFICATION/LISTINGS



This system is certified to ISO 9001:2008 by the LPCB under certificate No. 104

- See [publication 02.06](#): Victaulic Potable Water Approvals ANSI/NSF for potable water approvals if applicable.

NOTES

- See [publication 10.01](#) for Fire Protection Certifications/Listings Reference Guide.
- Sizes ranging 1 ½" (DN 40) to 318.5 mm are FM approved up to 300 psi (2070 kPa) on Schedule 10S stainless steel pipe, for use on wet and dry fire sprinkler systems.

ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.



3.0 SPECIFICATIONS – MATERIAL

Housing:

Type 316 stainless steel, conforming to ASTM A351, A743 and A744, Grade CF8M.

Optional: Type 304 stainless steel, conforming to ASTM A-351, A-743 and A-744, Grade CF8. (Regional availability only. Please contact Victaulic more details.)

Gasket: (specify choice¹)

Grade “E” EPDM

EPDM (Green stripe color code). Temperature range -30°F to +230°F/-34°C to +110°C. May be specified for cold and hot water service within the specified temperature range plus a variety of dilute acids, oil free air and many chemical services. UL Classified in accordance with ANSI/NSF 61 for cold +73°F/+23°C and hot +180°F/+82°C potable water service and ANSI/NSF 372. **NOT COMPATIBLE FOR PETROLEUM SERVICES OR STEAM SERVICES.**

Grade “EF” EPDM²

EPDM (Green “X” color code). May be specified for hot and cold water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. Also meets hot and cold potable water requirements per DVGW W270, UBA Elastomer Guideline, ÖVGW, SVGW, and French ACS approved for EN681-1 Type WA cold potable, and Type WB hot potable water service. WRAS approved material to BS 6920:2014 for cold and hot potable water service up to +149°F/+65°C. **NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.**

Grade “EW” EPDM

EPDM (Green W stripe color code). Temperature range -30°F to +230°F/-34°C to +110°C. May be specified for hot water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. WRAS approved material to BS 6920 for cold and hot potable water service up to +149°F/+65°C. UL Classified in accordance with ANSI/NSF 61 for cold +73°F/+23°C and hot +180°F/+82°C potable water service and ANSI/NSF 372. **NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.**

Grade “T” Nitrile

Nitrile (Orange stripe color code). Temperature range -20°F to +180°F/-29°C to +82°C. May be specified for petroleum products, hydrocarbons, air with oil vapors, vegetable and mineral oils within the specified temperature range; not compatible for hot dry air over +140°F/+60°C and water over +150°F/+66°C. **NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.**

Grade “O” Fluoroelastomer

Fluoroelastomer (Blue stripe color code). Temperature range +20°F to +300°F/-7°C to +149°C. May be specified for many oxidizing acids, petroleum oils, halogenated hydrocarbons, lubricants, hydraulic fluids, organic liquids and air with hydrocarbons. **NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.**

Grade “A” White Nitrile

White nitrile (White gasket). Temperature range +20°F to +180°F/-7°C to +82 °C. No carbon black content. Meets FDA requirements. Conforms to CFR Title 21 Part 177.2600. Not compatible for hot water services over +150°F/+66°C or for hot, dry air over +140°F/+60°C. **NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES.**

Others

For alternate gasket selection, reference Victaulic [publication 05.01](#): Victaulic Seal Selection Guide.

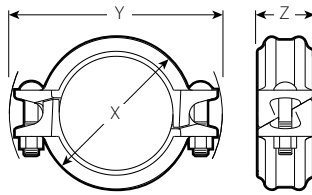
¹ Services listed are General Service Guidelines only. It should be noted that there are services for which these gaskets are not compatible. Reference should always be made to the latest [Victaulic Seal Selection Guide](#) for specific gasket service guidelines and for a listing of services which are not compatible.

² Available exclusively in Europe.

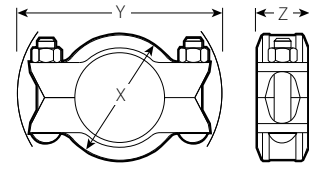
Bolt/Nuts:

Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM F593, Group 2 (316 stainless steel), condition CW. Stainless steel heavy nuts meeting the mechanical property requirements of ASTM F594, Group 2 (316 stainless steel), condition CW, with galling reducing coating.

4.0 DIMENSIONS



1 ½ – 4"/DN40 – DN100 sizes



5 – 12"/127 mm – DN300 sizes

Size		Pipe End Separation ³	Bolt/Nut ⁴		Nut Torque ft-lbs N-m	Dimensions			Weight
Nominal inches DN	Actual Outside Diameter inches mm	Allowable inches mm	Qty.	Size inches		X inches mm	Y inches mm	Z inches mm	Approximate (Each) lb kg
1 ½ DN40	1.900 48.3	0.05 1.3	2	¾ x 2 ½	18 25	2.86 73	4.42 118	1.84 47	1.6 0.7
2 DN50	2.375 60.3	0.05 1.3	2	¾ x 2 ½	18 25	3.34 85	5.19 132	1.86 47	1.6 0.7
2 ½	2.875 73.0	0.05 1.3	2	¾ x 2 ½	18 25	3.92 100	5.62 143	1.86 47	1.9 0.9
DN65	3.000 76.1	0.05 1.3	2	¾ x 2 ½	18 25	4.02 102	5.72 145	1.86 47	2.0 0.9
3 DN80	3.500 88.9	0.05 1.3	2	½ x 2 ¾	45 61	4.54 115	6.78 172	1.86 47	2.8 1.3
4 DN100	4.500 114.3	0.19 4.8	2	½ x 2 ¾	45 61	5.77 147	7.90 201	2.07 53	4.0 1.8
DN125	5.500 139.7	0.25 6.4	2	¾ x 4 ¼	75 - 100 100 - 135	7.07 180	11.13 283	2.38 60	12.0 5.5
5	5.563 141.3	0.25 6.4	2	¾ x 4 ¼	85 - 125 115 - 170	7.05 179	10.63 270	2.25 57	12.50 5.7
	6.500 165.1	0.25 6.4	2	7/8 x 5 ½	125 - 200 170 - 275	8.16 207	12.68 321	2.50 64	15.5 7.0
6 DN150	6.625 168.3	0.25 6.4	2	7/8 x 5 ½	125 - 200 170 - 275	8.16 207	12.68 321	2.50 64	15.5 7.0
	8.515 216.3	0.25 6.4	2	1 x 5 ½	200 - 300 275 - 400	10.63 270	15.00 381	2.75 70	24.0 10.9
8 DN200	8.625 219.1	0.25 6.4	2	1 x 5 ½	200 - 300 275 - 400	10.63 270	15.00 381	2.75 70	24.0 10.9
	10.528 267.4	0.25 6.4	2	1 x 6 ½	200 - 300 275 - 400	13.09 332	17.25 438	3.00 76	33.0 15.0
10 DN250	10.750 273.0	0.25 6.4	2	1 x 6 ½	200 - 300 275 - 400	13.09 332	17.25 438	3.00 76	33.0 15.0
	12.539 318.5	0.25 6.4	2	1 x 6 ½	200 - 300 275 - 400	15.13 384	19.13 486	3.13 80	40.0 18.1
12 DN300	12.750 323.9	0.25 6.4	2	1 x 6 ½	200 - 300 275 - 400	15.13 384	19.13 486	3.13 80	40.0 18.1

³ The allowable pipe end separation dimension shown is for system layout purposes only. Style 489 rigid couplings are considered rigid connections and will not accommodate expansion/contraction or angular movement of the piping system. Contact Victaulic for torsional resistance information.

⁴ Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.

5.0 PERFORMANCE

Performance on ANSI wall thicknesses

Pipe Diameter		Style 489				
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness		Groove Type	Maximum	
		inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
1 ½ DN40	1.900 48.3	0.200 5.1	80S	C	600 4136	1701 7,566
		0.145 3.7	40S	Std/C	600 4136	1701 7,566
		0.109 2.8	10S	RX	300 2065	849 3,777
		0.065 1.7	5S	RX	200 1379	567 2,522
2 DN50	2.375 60.3	0.218 5.5	80S	C	600 4136	2658 11,821
		0.154 3.9	40S	Std/C	600 4136	2658 11,821
		0.109 2.8	10	RX	300 2065	1327 5,902
		0.065 1.7	5S	RX	200 1379	886 3,941
2 ½ DN65	2.875 73.0	0.276 7.0	80S	C	600 4136	3894 17,323
		0.203 5.2	40S	Std/C	600 4136	3894 17,323
		0.120 3.1	10S	RX	300 2065	1944 8,649
		0.083 2.1	5S	RX	232 1600	1506 6,699
3 DN80	3.500 88.9	0.300 7.6	80S	C	600 4136	5771 25,673
		0.216 5.5	40S	Std/C	600 4136	5771 25,673
		0.120 3.1	10S	RX	300 2065	2882 12,818
		0.083 2.1	5S	RX	232 1600	2232 9,929
4 DN100	4.500 114.3	0.337 8.6	80S	C	600 4136	9541 42,439
		0.237 6.0	40S	Std/C	600 4136	9541 42,439
		0.120 3.1	10S	RX	300 2065	4763 21,189
		0.083 2.1	5S	RX	232 1600	3690 16,413

RX = Roll Set for light wall stainless steel pipe marked with the prefix "RX"

Std = Standard roll set marked with the prefix "R"

C = Cut groove

NOTES

- For pressure ratings on wall thickness not mentioned please contact Victaulic
- Working Pressure and End Load are total, from all internal and external loads, based on stainless steel pipe, roll grooved with Victaulic rolls in accordance with Victaulic specifications. "RX" rolls must be used for Schedules 5S, 10S and 10. Standard rolls should be used for Schedule 40S and Standard Weight pipe.
- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.0 PERFORMANCE (CONTINUED)

Performance on ANSI wall thicknesses

Pipe Diameter		Style 489				
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness		Groove Type	Maximum	
		inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
5	5.563 141.3	0.375 6.6	80S	C	600 4136	14580 64,857
		0.258 6.6	40S	Std/C	600 4136	14580 64,857
		0.134 3.4	10S	RX	375 2586	9115 40,544
		0.109 2.8	5S	RX	275 1896	6684 29,732
6 DN150	6.625 168.3	0.432 11.0	80S	C	750 5171	25854 115,003
		0.280 7.1	40S	Std/C	750 5171	25854 115,003
		0.134 3.4	10S	RX	300 2065	10324 45,925
		0.109 2.8	5S	RX	250 1724	8618 38,334
8 DN200	8.625 219.1	0.500 12.7	80S	C	600 4136	35049 155,903
		0.322 8.2	40S	Std/C	600 4136	35049 155,903
		0.148 3.8	10S	RX	300 2065	17499 77,838
		0.109 2.8	5S	RX	200 1379	11686 51,980
10 DN250	10.750 273.0	0.500 12.7	80S	C	600 4136	54446 242,188
		0.365 9.3	40S	Std/C	600 4136	54446 242,188
		0.165 4.2	10S	RX	300 2065	27184 120,918
		0.134 3.4	5S	RX	250 1724	22691 100,933
12 DN300	12.750 323.9	0.500 12.7	80S	C	600 4136	76590 340,687
		0.375 9.5	40S	Std/C	600 4136	76590 340,687
		0.180 4.6	10S	RX	300 2065	38239 170,097
		0.156 4.0	5S	RX	200 1379	25536 113,590

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NOTES

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- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
DN40	1.900 48.3	5.0 0.197	C	4136 600	7,566 1701
		3.6 0.142	Std/C	3792 550	6,937 1559
		3.2 0.126	Std	2930 425	5,360 1205
		2.6 0.102	RX	1896 275	3,468 780
		2.0 0.079	RX	1600 232	2,927 658
		1.6 0.063	RX	1379 200	2,522 567
2 DN50	2.375 60.3	5.6 0.220	C	4136 600	11,821 2658
		4.0 0.157	Std/C	4136 600	11,821 2658
		3.6 0.142	Std	3620 525	10,346 2326
		3.2 0.126	Std	3620 525	7,882 1772
		2.9 0.114	Std	2241 325	6,404 1440
		2.6 0.102	RX	1896 275	5,419 1218
		2.3 0.091	RX	1724 250	4,927 1108
		2.0 0.079	RX	1600 232	4,537 1028
		1.6 0.063	RX	1379 200	3,941 886

RX = Roll Set for light wall stainless steel pipe marked with the prefix "RX"

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C = Cut groove

NOTES

- For pressure ratings on wall thickness not mentioned please contact Victaulic
- Working Pressure and End Load are total, from all internal and external loads, based on stainless steel pipe, roll grooved with Victaulic rolls in accordance with Victaulic specifications. "RX" rolls must be used for Schedules 5S, 10S and 10. Standard rolls should be used for Schedule 40S and Standard Weight pipe.
- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
DN65	3.000 76.1	7.1 0.280	C	4136 600	18,862 4240
		6.4 0.252	C	4136 600	18,862 4240
		5.0 0.197	Std/C	3275 475	14,935 3358
		4.0 0.157	Std	2586 375	11,791 2651
		3.6 0.142	Std	2413 350	11,005 2474
		3.1 0.122	Std	2065 300	9,417 2117
		2.9 0.114	RX	2065 300	9,433 2121
		2.6 0.102	RX	1896 275	8,647 1944
		2.3 0.091	RX	1724 250	7,875 1770
		2.1 0.083	RX	1600 232	7,297 1640
		2.0 0.079	RX	1600 232	7,297 1640
3 DN80	3.500 88.9	8.0 0.315	C	4136 600	25,673 5771
		5.6 0.220	Std/C	4136 600	25,673 5771
		4.0 0.157	Std	2758 400	17,119 3848
		3.6 0.142	Std	2413 350	14,979 3367
		3.2 0.126	Std	2065 300	12,839 2886
		2.9 0.114	RX	2065 300	12,839 2886
		2.6 0.102	RX	1896 275	11,769 2646
		2.3 0.091	RX	1724 250	10,719 2410
		2.0 0.079	RX	1600 232	9,931 2233

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- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
4 DN100	4.500 114.3	8.8 0.346	C	4136 600	42,439 9541
		6.3 0.248	C	4136 600	42,439 9541
		4.5 0.177	Std	3103 450	31,836 7157
		3.6 0.142	Std	2065 300	21,224 4771
		2.9 0.114	RX	2065 300	21,224 4771
		2.6 0.102	RX	1896 275	19,455 4374
		2.0 0.079	RX	1600 232	16,417 3691
		10.0 0.394	C	4136 600	63,396 14252
		7.1 0.280	C	4136 600	63,396 14252
		6.6 0.260	Std/C	4136 600	63,396 14252
DN125	5.500 139.7	6.3 0.248	Std/C	3964 575	60,767 13661
		5.6 0.220	Std/C	3447 500	52,841 11879
		5.0 0.197	Std	3101 450	47,524 10684
		4.0 0.157	Std	2413 350	36,989 8315
		3.4 0.134	RX	2065 300	31,652 7116
		3.2 0.126	RX	2065 300	31,704 7127
		3.0 0.118	RX	1896 275	29,062 6534
		2.8 0.110	RX	1896 275	29,062 6534
		2.6 0.102	RX	1724 250	26,420 5940
		2.0 0.079	RX	1600 232	24,525 5513

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- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
	6.500 165.1	11.0	C	5171	110704
		0.432		750	24887
		7.1	ST,C	5171	110704
		0.280		750	24887
		5.0	ST	3447	73803
		0.197		500	16592
		3.4	ST	2068	44282
		0.134		300	9955
		2.8	RX	1724	36901
		0.109		250	8296
6 DN150	6.625 168.3	11.0	C	5171	115,003
		0.433		750	25854
		7.1	Std/C	5171	115,003
		0.280		750	25854
		5.0	Std	3447	76,668
		0.197		500	17236
		4.5	Std	3101	69,002
		0.177		450	15512
		4.0	Std	2586	57,501
		0.157		375	12927
		3.2	RX	1896	42,168
		0.126		275	9480
		3.0	RX	1896	42,168
		0.118		275	9480
		2.6	RX	1600	35,583
		0.102		232	7999
		2.0	RX	1600	35,574
		0.079		232	7997
	8.515 216.3	8.2	ST,C	4137	151984
		0.323		600	34167
		6.5	ST	3275	120320
		0.256		475	27049
		4.0	ST	2241	82324
		0.157		325	18507
		2.8	RX	1207	44329
		0.109		175	9965

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- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
8 DN200	8.625 219.1	12.5	C	4136	155,903
		0.492		600	35049
		8.0	Std/C	4136	155,903
		0.315		600	35049
		6.5	Std/C	3275	123,449
		0.256		475	27752
		6.3	Std/C	3275	123,449
		0.248		475	27752
		5.0	Std	2586	97,459
		0.197		375	21910
		4.0	Std	2241	84,465
		0.157		325	18989
		3.6	RX	1896	71,470
		0.142		275	16067
		32	RX	1600	60,295
		0.126		232	13555
	10.528 267.4	3.0	RX	1551	58,476
		0.118		225	13146
		2.6	RX	1207	45,481
		0.102		175	10225
		2.0	RX	1034	38,984
		0.079		150	3764
		9.3	ST,C	4137	232338
		0.366		600	52232
		6.5	ST,C	3103	174253
		0.256		450	39174
		4.0	ST	2068	116169
		0.157		300	26116
		3.4	RX	1600	89837
		0.135		232	20196

RX = Roll Set for light wall stainless steel pipe marked with the prefix "RX"

Std = Standard roll set marked with the prefix "R"

C = Cut groove

NOTES

- For pressure ratings on wall thickness not mentioned please contact Victaulic
- Working Pressure and End Load are total, from all internal and external loads, based on stainless steel pipe, roll grooved with Victaulic rolls in accordance with Victaulic specifications. "RX" rolls must be used for Schedules 5S, 10S and 10. Standard rolls should be used for Schedule 40S and Standard Weight pipe.
- Contact Victaulic for performance on other pipe. See [publication 24.01: Pipe Preparation Tool Specifications](#) for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses

Pipe Diameter		Style 489			
Nominal inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		mm inches		Working Pressure kPa psi	End Load N lb
10 DN250	10.750 273.0	14.2	C	4136	242,188
		0.559		600	54446
		12.5	C	4136	242,188
		0.492		600	54446
		10.0	C	4136	242,188
		0.394		600	54446
		6.3	Std/C	2930	171,585
		0.248		425	38574
		4.0	RX	2065	121,119
		0.157		300	27229
		3.6	RX	1724	100,933
		0.142		250	22691
		3.2	RX	1600	93,690
		0.126		232	21062
	12.539 318.5	3.0	RX	1379	80,746
		0.118		200	18153
		2.6	RX	1034	60,560
		0.102		150	13614
		2.0	RX	689	40,373
		0.079		100	9076
		10.3	C	4137	329574
		0.405		600	74091
		6.5	ST,C	2930	233448
		0.256		425	52481
		4.5	RX	2068	164787
		0.177		300	37046
12 DN300	12.750 323.9	4.0	RX	1379	109858
		0.157		200	24697
		12.5	C	4136	340,687
		0.492		600	76590
		10.0	C	4136	340,687
		0.394		600	76590
		7.1	Std/C	3101	255,568
		0.280		450	57454
		5.0	RX	2241	184,577
		0.197		325	41495
		4.5	RX	2065	170,379
		0.177		300	38303
		4.0	RX	1379	113,590
		0.157		200	25536

RX = Roll Set for light wall stainless steel pipe marked with the prefix "RX"

Std = Standard roll set marked with the prefix "R"

C = Cut groove

NOTES

- For pressure ratings on wall thickness not mentioned please contact Victaulic
- Working Pressure and End Load are total, from all internal and external loads, based on stainless steel pipe, roll grooved with Victaulic rolls in accordance with Victaulic specifications. "RX" rolls must be used for Schedules 5S, 10S and 10. Standard rolls should be used for Schedule 40S and Standard Weight pipe.
- Contact Victaulic for performance on other pipe. See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown. Metric thread size bolts are available for all coupling sizes upon request. Contact Victaulic for details.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

6.0 NOTIFICATIONS

WARNING

- Victaulic RX roll sets must be used when grooving light-wall/thin-wall stainless steel pipe for use with Victaulic Couplings.

Failure to use Victaulic RX roll sets when grooving light-wall/thin-wall stainless steel pipe may cause joint failure, resulting in serious personal injury and/or property damage.

NOTICE

- Victaulic RX grooving rolls must be ordered separately. They are identified by a silver color and the designation RX on the front of the roll sets.



WARNING



- Read and understand all instructions before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Depressurize and drain the piping system before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Wear safety glasses, hardhat, and foot protection.

Failure to follow these instructions could result in death or serious personal injury and property damage.

7.0 REFERENCE MATERIALS

[05.01: Victaulic Gasket Selection Guide](#)

[17.01: Victaulic® Stainless Steel Pipe End Preparation](#)

[17.09: Victaulic® Ductile Iron Grooved Couplings Performance Data for Stainless Steel Pipe](#)

[24.01: Victaulic® Pipe Preparation Tool Specifications](#)

[26.01: Victaulic® Design Data](#)

[29.01: Victaulic® Terms and Conditions/Warranty](#)

[I-100: Victaulic® Field Installation Handbook](#)

User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, and the applicable building codes and related regulations as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company's standard conditions of sale, installation guide, or this disclaimer.

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Note

This product shall be manufactured by Victaulic or to Victaulic specifications. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of the product you are installing. Handbooks are included with each shipment of Victaulic products, providing complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

Warranty

Refer to the Warranty section of the current Price List or contact Victaulic for details.

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