Victaulic® Duplex Stainless Steel Rigid Coupling Style 489DX

17.33



1.0 PRODUCT DESCRIPTION

Available Sizes

- 2 – 12"/DN50 – DN300

Maximum Working Pressure

- Up to 1200 psi/8273 kPa/83 bar
- Working pressure dependent on material, wall thickness, and size of pipe. Please see section 5.0 for details.

Application

- Provides a rigid pipe joint designed to restrict axial or angular movement. Contact Victaulic for information on torsional resistance.
- This product joins Original Groove System (OGS) roll grooved and cut grooved pipe, as well as grooved fittings, valves and accessories

Pipe Material

- Stainless steel
  - Roll and cut grooved austenitic stainless steel (Types 304/304L/316/316L) conforming to ASTM A312/A312M or equivalent
  - Roll and cut grooved duplex stainless steel conforming to ASTM A790 Gr. 2205 or equivalent
  - Roll and cut grooved super duplex stainless steel conforming to ASTM A790 Gr. 2507 or equivalent
  - Roll and cut grooved super austenitic stainless steel (Types 254SMO and AL6XN) conforming to ASTM A312/A312M (UNS S31254 and N08367) or equivalent
  - Roll and cut groove Zeron 100 super duplex stainless steel conforming to ASTM A790 UNS S32760 or equivalent

2.0 CERTIFICATIONS/LISTINGS

CLASSIFIED C UL US WATER QUALITY ANSI/NSF 61 & 372

CE EN 10311 CPR (EU) No. 305/2011

NOTES

- The Grade "E3" (EPDM) gasket material is 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.
- See publication 02.06 for potable water approvals if applicable.

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

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3.0 SPECIFICATIONS – MATERIAL

Housing:

☐ Duplex stainless steel (CE8MN) conforming to ASTM A890 and the chemical property requirements of ASTM A995.

☐ Optional Housing: Super Duplex stainless steel (CE3MN) conforming to ASTM A890 and chemical property requirements of ASTM A995.

Gaskets:[1]

Grade "E3" EPDM

EPDM (Green and Silver stripes 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 specific temperature range plus a variety of dilute acids, oil-free air and many chemical services. **NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.**

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.

Bolts/Nuts: (specify choice)

☐ Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM A1082, UNS S32750 (super duplex stainless steel). Stainless steel heavy nuts meeting the mechanical property requirements of ASTM A1082, UNS S327500 (super duplex stainless steel), supplementary requirement S5, with galling reducing coating.

- ☐ Optional: For imperial-sized couplings only[2]: Silicon bronze heavy hex nut meeting the requirements of ASME/ANSI B18.2.2 and ASTM F467 Type 651. Type 316 Stainless steel flat washer meeting the requirements of ASME/ANSI B18.21.1.

☐ Optional: Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM A193 Grade B8M, Class 2 (316 stainless steel). Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM A194 Grade 8M (316 stainless steel), condition CW, with galling reducing coating.

- ☐ Optional: For imperial-sized couplings only[2]: Silicon bronze heavy hex nut meeting the requirements of ASME/ANSI B18.2.2 and ASTM F467 Type 651. Type 316 Stainless steel flat washer meeting the requirements of ASME/ANSI B18.21.1.

2 Washers are only supplied when silicon bronze heavy hex nuts are specified.

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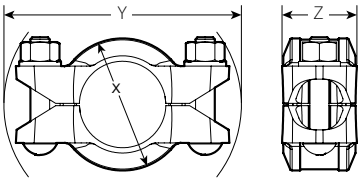
4.0 DIMENSIONS

Style 489DX Rigid Coupling



Size		Pipe End Separation[2]	Bolt/Nut[2,3]			Dimensions			Weight
Nominal inches DN	Actual Outside Diameter inches mm	Allowable inches mm	Qty.	Size inches mm	Nut Torque ft-lbs N-m	X inches mm	Y inches mm	Z inches mm	Approximate (Each) lb kg
2 DN50	2.375 60.3	0.05 1.3	2	½ x 2 ¾	45 - 60 60 - 80	3.44 87.4	6.18 157.0	1.95 49.5	3.0 1.4
2 ½	2.875 73.0	0.05 1.3	2	⅝ x 3 ½	60 - 90 80 - 120	4.00 101.6	7.22 183.4	1.95 49.5	3.9 1.8
DN65	3.000 76.1	0.05 1.3	2	⅝ x 3 ½	60 - 90 80 - 120	3.96 100.6	7.42 188.5	1.95 49.5	3.9 1.8
3 DN80	3.500 88.9	0.05 1.3	2	⅝ x 3 ½	60 - 90 80 - 120	4.69 119.1	7.84 199.1	1.95 49.5	4.6 2.1
4 DN100	4.500 114.3	0.19 4.8	2	¾ x 4 ¼	85 - 125 115 - 170	5.94 150.9	9.68 245.9	2.09 53.1	8.5 3.9
DN125	5.500 139.7	0.25 6.4	2	¾ x 4 ¼	85 - 125 115 - 170	7.01 178.1	10.94 277.9	2.31 58.7	11.8 5.3
6 DN150	6.625 168.3	0.25 6.4	2	⅞ x 5 ½	125 - 200 170 - 275	8.16 207.3	12.70 322.6	2.31 58.7	15.5 7.0
	6.500 165.1	0.25 6.4	2	⅞ x 5 ½	125 - 200 170 - 275	8.03 204.0	12.70 322.6	2.31 58.7	15.5 7.0
8 DN200	8.625 219.1	0.25 6.4	2	1 x 5 ½	200 - 300 275 - 400	10.62 269.7	15.04 382.0	2.62 66.5	24.0 10.9
10 DN250	10.750 273.0	0.25 6.4	2	1 x 6 ½	250 - 350 339 - 475	13.09 332.5	17.29 439.2	2.69 68.3	33.0 15.0
12 DN300	12.750 323.9	0.25 6.4	2	1 x 6 ½	250 - 350 339 - 475	15.13 384.3	19.13 485.9	2.81 71.4	40.0 18.1

[2] For field installation only. Style 489DX is essentially rigid and does not permit expansion or contraction.

[3] Metric thread size bolts are available (color coded gold) for all coupling sizes upon request. Contact Victaulic for details.

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5.0 PERFORMANCE

Performance on ANSI wall thicknesses (Austenitic Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness		Groove Type	Maximum	
Nominal inches DN	**Actual Outside Diameter** inches mm	inches mm	**ANSI** Schedule Number		**Working Pressure** psi kPa	**End Load** lb N
2 DN50	2.375 60.3	0.218 5.5	80S	C	750 5171	3323 14780
		0.154 3.9	40S	Std/C	750 5171	3323 14780
		0.109 2.8	10S	RX	500 3447	2217 9861
		0.065 1.7	5S	RX	325 2241	1440 6405
2½	2.875 73.0	0.276 7.0	80S	C	750 5171	4869 21658
		0.203 5.2	40S	Std/C	750 5171	4869 21658
		0.120 3.1	10S	RX	500 3447	3248 14449
		0.083 2.1	5S	RX	325 2241	2110 9386
3 DN80	3.500 88.9	0.300 7.6	80S	C	750 5171	7216 32098
		0.216 5.5	40S	Std/C	750 5171	7216 32098
		0.120 3.1	10S	RX	500 3447	4814 21415
		0.083 2.1	5S	RX	325 2241	3127 13910
4 DN100	4.500 114.3	0.337 8.6	80S	C	750 5171	11928 53059
		0.237 6.0	40S	Std/C	750 5171	11928 53059
		0.120 3.1	10S	RX	400 2758	6362 28298
		0.083 2.1	5S	RX	250 1725	3979 17700
6 DN150	6.625 168.3	0.280 7.1	40S	Std/C	750 5171	25854 115003
		0.134 3.4	10S	RX	300 2068	10324 45925
		0.109 2.8	5S	RX	250 1724	8618 38334

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 and 10S. Standard rolls should be used for Schedule 40S.
- 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.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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5.0 PERFORMANCE (CONTINUED)

Performance on ANSI wall thicknesses (Austenitic Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness		Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
8 DN200	8.625 219.1	0.322 8.2	40S	Std/C	600 4136	35049 155903
		0.148 3.8	10S	RX	300 2068	17499 77838
		0.109 2.8	5S	RX	200 1379	11686 51980
10 DN250	10.750 273.0	0.365 9.3	40S	Std/C	600 4136	54446 242188
		0.165 4.2	10S	RX	300 2068	27184 120918
		0.134 3.4	5S	RX	250 1724	22691 100933
12 DN300	12.750 323.9	0.375 9.5	40S	Std/C	600 4136	76590 340687
		0.181 4.6	10S	RX	300 2068	38239 170097
		0.156 4.0	5S	RX	200 1379	25536 113590

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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 and 10S. Standard rolls should be used for Schedule 40S.
- Contact Victaulic for performance on other pipe. See publication 24.01: Pipe Preparation Tool Specifications for more information pertaining to tools.
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5.1 PERFORMANCE

Performance on ISO wall thicknesses (Austenitic Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness	Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm		Working Pressure kPa psi	End Load N lb
2 DN50	2.375 60.3	0.220 5.6	C	5171 750	14780 3323
		0.157 4.0	Std/C	5171 750	14780 3323
		0.142 3.6	Std	4654 675	13302 2990
		0.126 3.2	Std	4137 600	11824 2658
		0.114 2.9	Std	3620 525	10346 2326
		0.102 2.6	RX	3275 475	9360 2104
		0.091 2.3	RX	2930 425	8375 1883
		0.079 2.0	RX	2586 375	7347 1652
		0.063 1.6	RX	2241 325	6405 1440
DN65	3.000 76.1	0.280 7.1	C	5171 750	23582 5301
		0.252 6.4	C	5171 750	23582 5301
		0.197 5.0	Std/C	4482 650	20438 4595
		0.157 4.0	Std	3964 575	18079 4064
		0.142 3.6	Std	3792 550	17293 3888
		0.122 3.1	Std	3450 500	15733 3537
		0.114 2.9	RX	3275 475	14935 3358
		0.102 2.6	RX	2930 425	13363 3004
		0.091 2.3	RX	2413 350	11005 2474
		0.083 2.1	RX	2241 325	10220 2297
		0.079 2.0	RX	2241 325	10220 2297

Size		Pipe Wall Thickness	Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm		Working Pressure kPa psi	End Load N lb
3 DN80	3.500 88.9	0.315 8.0	C	5171 750	32098 7216
		0.220 5.6	Std/C	5171 750	32098 7216
		0.157 4.0	Std	4137 600	25678 5773
		0.142 3.6	Std	3792 550	23538 5292
		0.126 3.2	Std	3450 500	21398 4811
		0.114 2.9	RX	3275 475	20328 4570
		0.102 2.6	RX	2930 425	18189 4089
		0.091 2.3	RX	2413 350	14979 3367
		0.079 2.0	RX	2241 325	13910 3127
4 DN100	4.500 114.3	0.346 8.8	C	5171 750	53059 11928
		0.248 6.3	C	5171 750	53059 11928
		0.177 4.5	Std	3964 575	40679 9145
		0.142 3.6	Std	3103 450	31836 7157
		0.114 2.9	RX	2586 375	26530 5964
		0.102 2.6	RX	2238 325	22958 5161
		0.079 2.0	RX	1600 232	16417 3691

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 pipe thicknesses indicated above. Standard rolls should be used for pipe thicknesses indicated above.
- 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.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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5.1 PERFORMANCE (CONTINUED)

Performance on ISO wall thicknesses (Austenitic Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness	Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm		Working Pressure kPa psi	End Load N lb
DN125	5.500 139.7	0.394 10.0	C	5171 750	79261 17819
		0.280 7.1	C	5171 750	79261 17819
		0.260 6.6	Std	5171 750	79261 17819
		0.260 6.6	C	5171 750	79261 17819
		0.248 6.3	Std/C	4826 700	73977 16631
		0.220 5.6	Std/C	4137 600	63409 14255
		0.197 5.0	Std	3620 525	55487 12474
		0.157 4.0	Std	2586 375	39631 8909
		0.134 3.4	RX	2068 300	31652 7116
		0.126 3.2	RX	2068 300	31704 7127
		0.118 3.0	RX	1896 275	29062 6534
		0.110 2.8	RX	1896 275	29062 6534
		0.102 2.6	RX	1724 250	26420 5940
		0.079 2.0	RX	1600 232	24525 5513
6 DN150	6.625 168.3	0.433 11.0	C	5171 750	115003 25854
		0.280 7.1	C	5171 750	115003 25854
		0.280 7.1	Std	5171 750	115003 25854
		0.197 5.0	Std	3447 500	76668 17236
		0.177 4.5	Std	3103 450	69002 15512
		0.157 4.0	Std	2586 375	57501 12927
		0.126 3.2	RX	1896 275	42168 9480
		0.118 3.0	RX	1896 275	42168 9480
		0.102 2.6	RX	1600 232	35583 7999
		0.079 2.0	RX	1600 232	35574 7997
8 DN200	8.625 219.1	0.492 12.5	C	4136 600	155903 35049
		0.315 8.0	Std/C	4136 600	155903 35049
		0.256 6.5	Std/C	3275 475	123449 27752
		0.248 6.3	Std/C	3275 475	123449 27752
		0.197 5.0	Std	2586 375	97459 21910
		0.157 4.0	Std	2068 300	77968 17528
		0.142 3.6	RX	1896 275	71470 16067
		0.126 3.2	RX	1600 232	60295 13555
		0.118 3.0	RX	1551 225	58476 13146
		0.102 2.6	RX	1207 175	45481 10225
		0.079 2,0	RX	1034 150	38984 8764
10 DN250	10.750 273.0	0.559 14.2	C	4136 600	242188 54446
		0.492 12.5	C	4136 600	242188 54446
		0.394 10.0	C	4136 600	242188 54446
		0.248 6.3	Std/C	2930 425	171585 38574
		0.157 4.0	RX	2065 300	121119 27229
		0.142 3.6	RX	1724 250	100933 22691
		0.126 3.2	RX	1600 232	93690 21062
		0.118 3.0	RX	1379 200	80746 18153
		0.102 2.6	RX	1034 150	60560 13614
		0.079 2.0	RX	689 100	40373 9076
12 DN300	12.750 323.9	0.492 12.5	C	4136 600	340687 76590
		0.394 10.0	C	4136 600	340687 76590
		0.280 7.1	Std/C	3101 450	255568 57454
		0.197 5.0	RX	2241 325	184577 41495
		0.177 4.5	RX	2068 300	170379 38303
		0.157 4.0	RX	1379 200	113590 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 pipe thicknesses indicated above. Standard rolls should be used for pipe thicknesses indicated above.
- 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.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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5.2 PERFORMANCE

Performance on ANSI wall thickness (Super Austenitic, Duplex, and Super Duplex Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness		Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	 inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
2 DN50	2.375 60.3	0.154 3.9	40S	C	1200 8273	5316 23656
2½	2.875 73.0	0.203 5.2	40S	C	1200 8273	7790 34666
3 DN80	3.500 88.9	0.216 5.5	40S	C	1200 8273	11545 51375
4 DN100	4.500 114.3	0.237 6.0	40S	C	1200 8273	19084 84924
6 DN150	6.625 168.3	0.280 7.1	40S	C	1200 8273	41370 184030
8 DN200	8.625 219.1	0.322 8.2	40S	C	1200 8273	70110 311870
10 DN250	10.750 273.0	0.365 9.3	40S	C	1200 8273	108920 484500
12 DN300	12.750 323.9	0.375 9.5	40S	C	1200 8273	153210 681520

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, cut grooved in accordance with Victaulic specifications.
- 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.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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5.3 PERFORMANCE

Performance on ANSI wall thickness (Duplex Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness		Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	 inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
2 DN50	2.375 60.3	0.109 2.8	10S	RX	700 4826	3101 13794
2½	2.875 73.0	0.120 3.0	10S	RX	700 4826	4544 20214
3 DN80	3.500 88.9	0.120 3.0	10S	RX	700 4826	6735 29958
4 DN100	4.500 114.3	0.120 3.0	10S	RX	560 3861	8906 39618
6 DN150	6.625 168.3	0.134 3.4	10S	RX	420 2896	14478 64402
8 DN200	8.625 219.1	0.148 3.8	10S	RX	420 2896	24539 109155
10 DN250	10.750 273.0	0.165 4.2	10S	RX	420 2896	38120 169567
12 DN300	12.750 323.9	0.180 4.6	10S	RX	420 2896	53624 238532

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

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 Schedule 10S.
- 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.
- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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5.4 PERFORMANCE

Performance on ANSI wall thickness (Super Duplex Stainless Steel Pipe Materials)

Size		Pipe Wall Thickness		Groove Type	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	 inches mm	ANSI Schedule Number		Working Pressure psi kPa	End Load lb N
2 DN50	2.375 60.3	0.109 2.8	10S	RX	800 5516	3544 15765
2½	2.875 73.0	0.120 3.0	10S	RX	800 5516	5193 23102
3 DN80	3.500 88.9	0.120 3.0	10S	RX	800 5516	7697 34238
4 DN100	4.500 114.3	0.120 3.0	10S	RX	640 4413	10179 45277
6 DN150	6.625 168.3	0.134 3.4	10S	RX	480 3309	16546 73602
8 DN200	8.625 219.1	0.148 3.8	10S	RX	480 3309	28045 124749
10 DN250	10.750 273.0	0.165 4.2	10S	RX	480 3309	43566 193791
12 DN300	12.750 323.9	0.180 4.6	10S	RX	480 3309	61285 272608

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

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 Schedule 10S.
- Contact Victaulic for performance on other pipe. See publication 24.01: Pipe Preparation Tool Specifications for more information pertaining to tools.
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- WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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6.0 NOTIFICATIONS

⚠ WARNING



- **Read and understand all instructions before attempting to install any Victaulic products.**
- **Always verify that the piping system has been completely depressurized and drained immediately prior to installation, removal, adjustment, or maintenance of any Victaulic products.**
- **Confirm that any equipment, branch lines, or sections of piping that may have been isolated for/during testing or due to valve closures/positioning are identified, depressurized, and drained immediately prior to installation, removal, adjustment, or maintenance of any Victaulic products.**
- **Always read and follow the I-ENDCAP, Victaulic End Cap Installation Safety Instructions, which can be downloaded at Victaulic.com.**
- **Wear safety glasses, hardhat, foot protection, and hearing protection.**
- **It is the system designer's responsibility to verify suitability of stainless steel components for use with the intended fluid media within the piping system and external environment.**
- **The material specifier shall evaluate the effect of chemical composition, pH level, operating temperature, chloride level, oxygen level, and flow rate on stainless steel components to confirm system life will be acceptable for the intended service.**
- **Always reference Victaulic publication 17.01 for stainless steel pipe end preparation and grooving roll set requirements. Grooving roll sets for stainless steel pipe must be ordered separately.**

Failure to follow these instructions could compromise system integrity or cause system failure, resulting in death or serious personal injury and property damage.

⚠ 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.**

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7.0 REFERENCE MATERIALS

05.01: Seal Selection Guide Elastomeric Seal Construction
17.01: Stainless Steel Pipe End Preparation
17.25: Victaulic Stainless Steel Rigid Coupling Style 489
24.01: Victaulic Pipe Preparation Tool Specifications
25.01: Original Groove System (OGS) Groove Specifications
26.01: Victaulic Design Data
29.01: Victaulic Terms and Conditions of Sale
I-100: Field Installation Handbook
I-ENDCAP: Victaulic® End Cap Installation Safety Instructions

User Responsibility for Product Selection and Suitability
Each user bears final responsibility for determining the suitability of Victaulic products for their end-use application, in accordance with industry standards, project specifications, and Victaulic's published performance, maintenance, and safety data, as well as all warnings and installation 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, warranty, installation instructions, or this disclaimer.

Installation
Always refer to and follow the Victaulic Installation Handbook or installation instructions for 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 victaulic.com.

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

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