Victaulic® Duplex Grooved Couplings
Style 77DX Duplex Stainless Steel Flexible Coupling



1.0 PRODUCT DESCRIPTION

Available Sizes:

- ¾ – 6"/DN20 – DN150

NOTE

- For 8 – 18"/DN200 – DN450 sizes, Victaulic offers stainless steel couplings. See publication 17.03 for the Style 77S Stainless Steel Flexible Coupling.

Maximum Working Pressure:

- Up to 1200 psi/8273 kPa/82 Bar on duplex/super duplex stainless steel
- Up to 750 psi/5171 kPa/51 Bar on 304/316 stainless steel

WARNING

- FOR ONE TIME FIELD TEST ONLY. The maximum allowable working pressure may be increased to 1 ½ times the figures shown.
- Working pressure dependent on material, wall thickness and size of pipe.

Application:

- Joins OGS standard roll grooved and cut grooved pipe, as well as OGS grooved fittings, valves and accessories

Pipe Material:

- 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

2.0 CERTIFICATIONS/LISTINGS

CE

EN 10311
CPR (EU)
No. 305/2011

NOTE

- See Victaulic 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 the chemical property requirements of ASTM A995.

Gasket (specify choice)[1]:

☐ **Grade "E" EPDM**
EPDM (Green 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. 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 "EF" EPDM[2]**
EPDM (Green "X" color code). Temperature range -30°F to +230°F/-34°C to +110°C. 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 UBA Elastomer Guideline, SVGW, and French ACS approved for EN681-1 Type WA cold potable, and Type WB hot potable water service. NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.

☐ **Grade "EW" EPDM**
EPDM (Green W 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.

☐ **Other**
For alternate gasket selection, reference 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.

Bolts/Nuts: (specify choice)[3,4]:

☐ Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM F593, Group 2 (316 stainless steel), condition CW. Silicon bronze heavy hex nut meeting the requirements of ASME/ANSI B18.2.2 and ASTM F467 Type 651. Stainless steel flat washer meeting the requirements of ASME/ANSI B18.21.1, Type 316.

☐ Optional: Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM F594, Group 2 (316 stainless steel), condition CW, with galling-reducing coating.

☐ Optional: Duplex/Super duplex hardware

3 Bolts/nuts are available in imperial size only.

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

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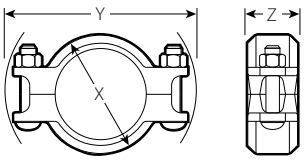
4.0 DIMENSIONS



Size		Allowable Pipe End Separation[3]	Deflection from Centerline[3]		Bolt/Nut[4]		Dimensions			Weight
Nominal inches DN	Actual Outside Diameter inches mm	Min. - Max. inches mm	Per Coupling degrees	Pipe inches/ft mm/m	Required Qty.	Size inches	X inches mm	Y inches mm	Z inches mm	Approximate (Each) lb kg
¾ DN20	1.050 26.9	0 – 0.06 0 – 1.5	3° - 24´	0.72 60	2	⅜ X 2	2.08 52	3.89 98	1.70 44	1.2 0.5
1 DN25	1.315 33.7	0 – 0.06 0 – 1.5	2° - 43´	0.57 47	2	⅜ X 2	2.54 64	4.50 114	1.66 42	1.6 0.7
1 ¼ DN32	1.660 42.4	0 – 0.06 0 – 1.5	2° - 10´	0.45 38	2	⅜ X 2	2.87 72	4.79 122	1.76 44	1.9 0.9
1 ½ DN40	1.900 48.3	0 – 0.06 0 – 1.5	1° - 56´	0.40 33	2	⅜ X 2	3.24 82	4.80 122	1.76 44	2.1 1.0
2 DN50	2.375 60.3	0 – 0.06 0 – 1.5	1° - 31´	0.32 27	2	⅜ X 2	3.70 94	5.33 136	1.84 46	2.5 1.1
2 ½	2.875 73.0	0 – 0.06 0 – 1.5	1° - 15´	0.26 22	2	⅜ X 2	4.20 106	5.79 148	1.84 46	2.9 1.3
3 DN80	3.500 88.9	0 – 0.06 0 – 1.5	1° - 2´	0.22 18	2	½ X 2 ¾	4.83 122	6.99 178	1.84 46	4.1 1.9
4 DN100	4.500 114.3	0 – 0.13 0 – 3.3	1° - 36´	0.34 28	2	⅝ X 3 ½	5.93 150	9.00 228	2.06 52	6.7 3.0
6 DN150	6.625 168.3	0 – 0.13 0 – 3.3	1° - 12´	0.21 17	2	¾ X 4 ¼	8.30 210	11.06 280	2.06 52	8.5 3.9
8 – 18 DN200 – DN450	For 8 – 18"/DN200 – DN450 sizes Victaulic offers stainless steel couplings. See publication 17.03 for the Style 77S Stainless Steel Flexible Coupling.									

[3] Allowable Pipe End Separation and Deflection figures show the maximum nominal range of movement available at each joint for standard roll grooved pipe. Figures for standard cut grooved pipe may be doubled. These figures are maximums; for design and installation purposes these figures should be reduced by: 50% for ¾ – 3 ½"/DN20 – DN90; 25% for 4"/DN100 and larger.

[4] Metric thread size bolts are available 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		Performance		
Nominal inches DN	**Actual Outside Diameter** inches mm	**Thickness** inches mm	**ANSI Schedule Number**	**Groove Type**	**Maximum Working Pressure** psi kPa	**Maximum End Load** lbs N
¾ DN20	1.050 26.9	0.154 3.9	80S	C	750 5171	649 2,886
		0.114 2.9	40S	Std/C	750 5171	649 2,886
		0.083 2.1	10S	RX	500 3447	433 1,926
		0.065 1.7	5S	RX	500 3447	433 1,926
1 DN25	1.315 33.7	0.193 4.9	80S	C	750 5171	1019 4,532
		0.142 3.6	40S	Std/C	750 5171	1019 4,532
		0.110 2.8	10S	RX	500 3447	680 3,024
		0.067 1.7	5S	RX	400 2758	543 2,416
1¼ DN32	1.660 42.4	0.193 4.9	80S	C	750 5171	1623 7,220
		0.142 3.6	40S	Std/C	750 5171	1623 7,220
		0.110 2.8	10S	RX	500 3447	1083 4,818
		0.067 1.7	5S	RX	400 2758	866 3,852
1½ DN40	1.900 48.3	0.201 5.1	80S	C	750 5171	2126 9,456
		0.146 3.7	40S	Std/C	750 5171	2126 9,456
		0.110 2.8	10S	RX	500 3447	1419 6,312
		0.067 1.7	5S	RX	400 2758	1134 5,044
2 DN50	2.375 60.3	0.217 5.5	80S	C	750 5171	3323 14,782
		0.154 3.9	40S	Std/C	750 5171	3323 14,782
		0.110 2.8	10S	RX	500 3447	2217 9,862
		0.067 1.7	5S	RX	325 2241	1440 6,406

NOTES

- 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
- Working Pressure and End Load are total, from all internal and external loads, based on ANSI stainless steel pipe roll or cut grooved to Victaulic specifications. "RX" rolls must be used for Schedules 5S and 10S. Standard rolls must be used for Schedule 40S. Contact Victaulic for performance on other pipe.

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5.0 PERFORMANCE (continued)

Performance on ANSI Wall Thicknesses (Austenitic Stainless Steel Pipe Materials):

Size		Pipe Wall Thickness		Performance		
Nominal inches DN	**Actual Outside Diameter** inches mm	**Thickness** inches mm	**ANSI Schedule Number**	**Groove Type**	**Maximum Working Pressure** psi kPa	**Maximum End Load** lbs N
2½	2.875 73.0	0.276 7.0	80S	C	750 5171	4869 21,658
		0.205 5.2	40S	Std/C	750 5171	4869 21,658
		0.122 3.1	10S	RX	500 3447	3248 14,448
		0.083 2.1	5S	RX	325 2241	2110 9,386
3 DN80	3.500 88.9	0.299 7.6	80S	C	750 5171	7221 32,120
		0.217 5.5	40S	Std/C	750 5171	7221 32,120
		0.122 3.1	10S	RX	500 3447	4814 21,414
		0.083 2.1	5S	RX	325 2241	3127 13,910
4 DN100	4.500 114.3	0.339 8.6	80S	C	750 5171	11937 53,098
		0.236 6.0	40S	Std/C	750 5171	11937 53,098
		0.122 3.1	10S	RX	400 2758	6343 28,216
		0.083 2.1	5S	RX	250 1724	3979 17,700
6 DN150	6.625 168.3	0.432 11.0	80S	C	750 5171	25873 115,088
		0.280 7.1	40S	Std/C	500 3447	17249 76,728
		0.134 3.4	10S	RX	200 1379	6875 30,582
		0.110 2.8	5S	RX	125 862	4310 19,172
8 –18 DN200 – DN450	8.625 – 18.000 219.1 – 457.2	For 8 – 18"/DN200 – DN450 sizes Victaulic offers stainless steel couplings. See publication 17.03 for the Style 77S Stainless Steel Flexible Coupling.				

NOTES

- 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
- Working Pressure and End Load are total, from all internal and external loads, based on ANSI stainless steel pipe roll or cut grooved to Victaulic specifications. "RX" rolls must be used for Schedules 5S and 10S. Standard rolls must be used for Schedule 40S. Contact Victaulic for performance on other pipe.

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5.1 PERFORMANCE

Performance on ISO Wall Thicknesses (Austenitic Stainless Steel Pipe Materials):

Size		Pipe Wall Thickness	Performance		
Nominal inches DN	Actual Outside Diameter inches mm	Thickness inches mm	Groove Type	Maximum Working Pressure psi kPa	Maximum End Load lbs N
¾ DN20	1.050 26.9	0.157 4.0	C	750 5171	649 2,886
		0.126 3.2	C	750 5171	649 2,886
		0.102 2.6	Std	650 4482	563 2,504
		0.079 2.0	RX	500 3447	433 1,926
		0.063 1.6	RX	500 3447	433 1,926
1 DN25	1.315 33.7	0.177 4.5	C	750 5171	1019 4,532
		0.126 3.2	Std	625 4309	849 3,776
		0.102 2.6	RX	475 3275	645 2,870
		0.091 2.3	RX	450 3103	611 2,718
		0.079 2.0	RX	425 2930	577 2566
		0.063 1.6	RX	400 2758	543 2,416
1¼ DN32	1.660 42.4	0.197 5.0	C	750 5171	1623 7,220
		0.142 3.6	Std/C	750 5171	1623 7,220
		0.126 3.2	Std	625 4309	1354 6,022
		0.102 2.6	RX	475 3275	1028 4,572
		0.079 2.0	RX	425 2930	920 4,092
		0.063 1.6	RX	400 2758	866 3,852
1½ DN40	1.900 48.3	0.197 5.0	C	750 5171	2126 9,456
		0.142 3.6	Std/C	750 5171	2126 9,456
		0.126 3.2	Std	600 4137	1701 7,566
		0.102 2.6	RX	475 3275	1347 5,992
		0.079 2.0	RX	425 2930	1205 5,360
		0.063 1.6	RX	400 2758	1134 5,044

NOTES

- 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
- Working Pressure and End Load are total, from all internal and external loads, based on ISO stainless steel pipe roll or cut grooved to Victaulic specifications. "RX" rolls must be used for pipe thicknesses indicated above. Standard rolls must be used for pipe thicknesses indicated above. Contact Victaulic for performance on other pipe.

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5.1 PERFORMANCE (continued)

Performance on ISO Wall Thicknesses (Austenitic Stainless Steel Pipe Materials):

Size		Pipe Wall Thickness		Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	 inches mm	Groove Type	Working Pressure psi kPa	End Load lbs N
2 DN50	2.375 60.3	0.220 5.6	C	750 5171	3323 14,782
		0.157 4.0	Std/C	750 5171	3323 14,782
		0.142 3.6	Std	675 4654	2990 13,300
		0.126 3.2	Std	600 4137	2658 11,824
		0.114 2.9	Std	525 3620	2326 10,346
		0.102 2.6	RX	475 3275	2104 9,360
		0.091 2.3	RX	425 2930	1883 8,376
		0.079 2.0	RX	375 2586	1661 7,388
		0.063 1.6	RX	325 2241	1440 6,406
3 DN80	3.500 88.9	0.315 8.0	C	750 5171	7221 32,120
		0.220 5.6	Std/C	750 5171	7221 32,120
		0.157 4.0	Std	600 4137	5717 25,430
		0.142 3.6	Std	550 3792	5316 23,646
		0.126 3.2	Std	525 3620	4915 21,864
		0.114 2.9	RX	450 3103	4477 19,914
		0.102 2.6	RX	425 2930	3971 17,664
		0.091 2.3	RX	350 2413	3465 15,414
		0.079 2.0	RX	325 2241	3127 13,910
		0.063 1.6	RX	N/R	

NOTES

- 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
- N/R = Not Rated
- Working Pressure and End Load are total, from all internal and external loads, based on ISO stainless steel pipe roll or cut grooved to Victaulic specifications. "RX" rolls must be used for pipe thicknesses indicated above. Standard rolls must be used for pipe thicknesses indicated above. Contact Victaulic for performance on other pipe.

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5.1 PERFORMANCE (continued)

Performance on ISO Wall Thicknesses (Austenitic Stainless Steel Pipe Materials):

Size		Pipe Wall Thickness		Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	 inches mm	Groove Type	Working Pressure psi kPa	End Load lbs N
4 DN100	4.500 114.3	0.346 8.8	C	750 5171	11937 53,098
		0.248 6.3	C	750 5171	11937 53,098
		0.177 4.5	Std	575 3964	9044 40,230
		0.142 3.6	Std	450 3103	7308 32,508
		0.114 2.9	RX	375 2586	5871 26,116
		0.102 2.6	RX	325 2241	5161 22,958
		0.079 2.0	RX	250 1724	3979 17,700
		0.063 1.6	RX	N/R	
6 DN150	6.625 168.3	0.433 11.0	C	750 5171	25873 115,088
		0.280 7.1	Std	750 5171	25873 115,088
		0.280 7.1	C	500 3450	17249 76,728
		0.197 5.0	Std	325 2241	10983 48,854
		0.177 4.5	Std	275 1896	9491 42,218
		0.157 4.0	Std	225 1551	7999 35,582
		0.126 3.2	RX	175 1207	6097 27,120
		0.118 3.0	RX	150 1034	5171 23,002
		0.102 2.6	RX	N/R	
		0.079 2.0	RX		
		0.063 1.6	RX		

NOTES

- 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
- N/R = Not Rated
- Working Pressure and End Load are total, from all internal and external loads, based on ISO stainless steel pipe roll or cut grooved to Victaulic specifications. "RX" rolls must be used for pipe thicknesses indicated above. Standard rolls must be used for pipe thicknesses indicated above. Contact Victaulic for performance on other pipe.

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5.2 PERFORMANCE

Performance on ANSI wall thickness (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
¾ DN20	1.050 26.9	0.114 2.9	40S	C	1200 8274	1000 4448
		0.083 2.1	10S	RX	750 5171	649 2888
1 DN25	1.315 33.7	0.133 3.4	40S	C	1200 8274	1600 7118
		0.110 2.8	10S	RX	750 5171	1019 4530
1 ¼ DN32	1.660 42.4	0.145 3.7	40S	C	1200 8274	2500 11120
		0.110 2.8	10S	RX	750 5171	1623 7220
1 ½ DN40	1.900 48.3	0.140 3.6	40S	C	1200 8274	3400 15124
		0.110 2.8	10S	RX	750 5171	2126 9458
2 DN50	2.375 60.3	0.154 3.9	40S	C	1200 8274	5300 23576
		0.110 2.8	10S	RX	750 5171	3323 14780
2 ½	2.875 73.0	0.203 5.2	40S	C	1200 8274	7700 34252
		0.122 3.1	10S	RX	750 5171	4869 21658
3 DN80	3.500 88.9	0.216 5.5	40S	C	1200 8274	11500 51154
		0.122 3.1	10S	RX	750 5171	7216 32098
4 DN100	4.500 114.3	0.237 6.0	40S	C	1200 8274	19000 84516
		0.122 3.1	10S	RX	600 4137	9543 42448
6 DN150	6.625 168.3	0.280 7.1	40S	C	1200 8274	41397 184144
		0.134 3.4	10S	RX	225 1551	7756 34500

NOTES

- RX = Roll Set for light wall stainless steel pipe marked with the prefix "RX"
- C = Cut groove
- Working Pressure and End Load are total, from all internal and external loads, based on ANSI stainless steel pipe, roll or cut grooved to Victaulic specifications. "RX" rolls must be used for Schedule 10S. Contact Victaulic for performance on other pipe.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

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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.**

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

7.0 REFERENCE MATERIALS

02.06: Victaulic Potable Water Approvals ANSI/NSF
05.01: Victaulic Seal Selection Guide
17.01: Victaulic Pipe Preparation for use on Stainless Steel Pipe
17.16: Victaulic Stainless Steel OGS Fittings
17.18: Victaulic Duplex and Super Duplex Stainless Steel OGS Fittings
17.33: Style 489DX Duplex Stainless Steel Rigid Coupling
17.50: Victaulic® Stainless Steel Schedule 40S OGS Fittings
24.01: Pipe Preparation Tool Specifications
25.01: Victaulic Original Groove System (OGS) Groove Specifications
26.01: Victaulic Design Data
29.01: Victaulic Terms and Conditions of Sale
I-100: Victaulic 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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Note
All products bearing a Victaulic trademark are manufactured by Victaulic or to Victaulic specifications. All products are to be installed only in accordance with the applicable Victaulic installation instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

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