






QuickVic™ Rigid Coupling for Steel Pipe

STYLE 107



WARNING

⚠ 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 during installation.

Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.

INSTRUCTIONS FOR THE INITIAL INSTALLATION OF STYLE 107 COUPLINGS



1. **DO NOT DISASSEMBLE THE COUPLING:** Style 107 Couplings are installation ready. The coupling is designed so that the installer does not need to remove the bolts and nuts for installation. This design facilitates installation by allowing the installer to “stab” the grooved end of pipe/mating components into the coupling.
2. **CHECK PIPE/MATING COMPONENT ENDS:** The outside surface of the pipe/mating component, between the groove and the pipe/mating component end, must be smooth and free from indentations, projections, and roll marks to ensure a leak-tight seal. All oil, grease, dirt, and cutting particles must be removed. Measurements taken across grooved pipe/mating component ends must not exceed the maximum allowable flare diameter. Refer to current Victaulic specifications for the maximum allowable flare diameter.
3. **CHECK GASKET:** Check the gasket to make sure it is suitable for the intended service. The color code identifies the gasket grade. Refer to submittal 05.01 for the color code chart.

⚠ WARNING

- Always use a compatible lubricant to prevent the gasket from pinching or tearing during installation.

Failure to follow this instruction could result in joint leakage.

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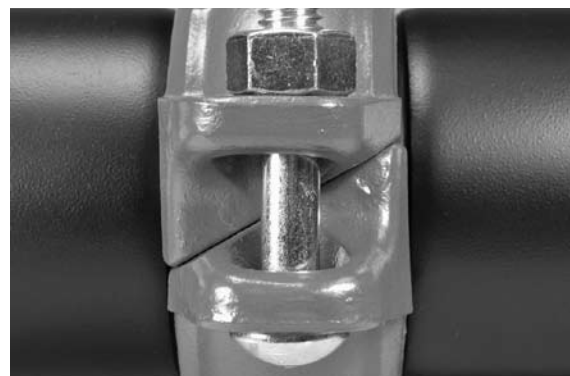
4. **LUBRICATE GASKET:** Apply a thin coat of Victaulic Lubricant or silicone lubricant only to the sealing lips of the gasket interior.
NOTE: The gasket exterior is supplied with a factory-applied lubricant, so there is no need to remove the gasket from the housings to apply additional lubricant to the exterior surface.

⚠ WARNING	
	<ul style="list-style-type: none"> • Never leave a Style 107 Coupling partially assembled. A partially assembled Style 107 Coupling poses a drop hazard. • Keep hands away from the pipe/mating component ends and the openings of the coupling when attempting to “stab” the grooved end of pipe/mating components into the coupling. <p>Failure to follow these instructions could cause serious personal injury and/or property damage.</p>



5. **ASSEMBLE JOINT:** Assemble the joint by inserting (“stabbing”) the grooved end of a pipe/mating component into each opening of the coupling. The ends of the grooved pipe/mating components must be inserted into the coupling until contact with the center leg of the gasket occurs. A visual check is required to ensure the coupling keys align with the grooves in the pipe/mating components.

⚠ WARNING
<ul style="list-style-type: none"> • For Victaulic rigid, angle-bolt-pad couplings, the nuts must be tightened evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. • For Victaulic rigid, angle-bolt-pad couplings, equal offsets must be present at the bolt pads. • Keep hands away from coupling openings during tightening. <p>Failure to follow these instructions could cause joint failure, serious personal injury, and property damage.</p>



6. **TIGHTEN NUTS:** Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the angle bolt pads. Make sure the housings’ keys completely engage the grooves and the offsets are equal at the bolt pads. This is necessary to ensure a rigid joint.
NOTE: It is important to tighten the nuts evenly to prevent gasket pinching. An impact wrench or standard socket wrench can be used to bring the bolt pads into metal-to-metal contact. Refer to the “Impact Wrench Usage Guidelines” section on page 4.

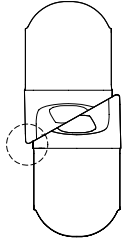
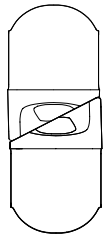
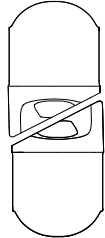
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7. Visually inspect the bolt pads at each joint to ensure metal-to-metal contact is achieved.

NOTICE

Visual inspection of each joint is critical. Improperly assembled joints must be corrected before the system is placed in service.

GOOD		BAD
		
PROPERLY ASSEMBLED JOINT POSITIVE OFFSET WITH BOLT PAD CONTACT	PROPERLY ASSEMBLED JOINT NEUTRAL OFFSET WITH BOLT PAD CONTACT	IMPROPERLY ASSEMBLED JOINT BOLT PAD GAP

Drawings are exaggerated for clarity

INSTRUCTIONS FOR RE-INSTALLATION OF STYLE 107 COUPLINGS

Since the coupling housings conform to the outside diameter of the pipe/mating component during an initial installation, “stabbing” the pipe/mating components into the coupling may not be possible upon re-installation. If this is the case, refer to the following steps for re-installing the coupling.

1. Make sure the system is depressurized and drained completely before attempting to disassemble any couplings.
2. Follow steps 2 – 3 on page 1.



3. **LUBRICATE GASKET:** Apply a thin coat of Victaulic Lubricant or silicone lubricant to the gasket sealing lips and exterior.



4. **INSTALL GASKET:** Insert the grooved end of a pipe/mating component into the gasket until it contacts the center leg of the gasket.



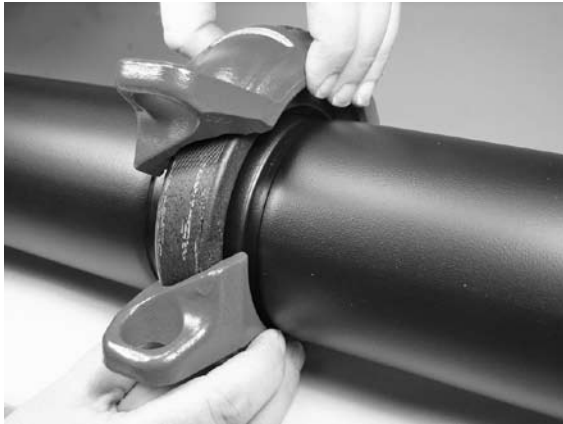
5. **JOIN PIPE/MATING COMPONENTS:** Align the two grooved ends of the pipe/mating components. Insert the other pipe/mating component end into the gasket until it contacts the center leg of the gasket. **NOTE:** Make sure no portion of the gasket extends into the groove of either pipe/mating component.



6. **ASSEMBLE HOUSINGS:** Insert one bolt into the housings, and thread the nut loosely onto the bolt to allow for the “swing-over” feature, as shown above. **NOTE:** The nut should be backed off no further than flush with the end of the bolt.

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- 7. INSTALL HOUSINGS:** Using the “swing-over” feature, install the housings over the gasket. Make sure the housings’ keys engage the grooves properly on both pipes/mating components.



- 8. INSTALL REMAINING BOLT/NUT:** Install the remaining bolt, and thread the nut finger-tight onto the bolt. **NOTE:** Make sure the oval necks of the bolts seat properly in the bolt holes.
- 9. TIGHTEN NUTS:** Follow steps 6 and 7 on page 2 to complete the assembly.

IMPACT WRENCH USAGE GUIDELINES

WARNING

- Nuts must be tightened evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. For angle-bolt-pad couplings, even offsets must be present at the bolts pads to obtain pipe-joint rigidity.
- **DO NOT** continue to use an impact wrench after the visual installation guidelines for the coupling are achieved.

Failure to follow these instructions could cause gasket pinching and coupling damage, resulting in joint failure, serious personal injury, and property damage.

Due to the speed of assembly when using an impact wrench, the installer should take extra care to ensure nuts are tightened evenly by alternating sides until proper assembly is complete. Always refer to the Victaulic assembly instructions, supplied with the product, for complete installation requirements.

Impact wrenches do not provide the installer with direct “wrench feel” or torque to judge nut tightness. Since some impact wrenches are capable of high output, it is important to develop a familiarity with the impact wrench to avoid damaging or fracturing bolts or coupling bolt pads during installation. **DO NOT** continue to use an impact wrench after the visual installation requirements for the coupling are achieved.

Perform trial assemblies with the impact wrench and socket or torque wrenches to help determine the capability of the impact wrench. Using the same method, periodically check additional nuts throughout the system installation.

For safe and proper use of impact wrenches, always refer to the impact wrench manufacturer’s operating instructions. In addition, verify that proper impact grade sockets are being used for coupling installation.

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