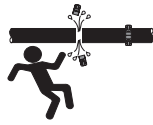


StrengThin™ Rigid Coupling

STRENGTHIN™

STYLE D08

⚠ WARNING

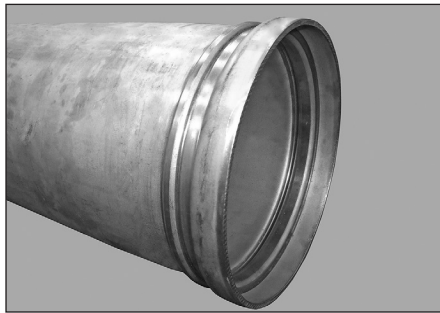


- Read and understand all instructions before attempting to install any Victaulic piping products.
- These products must be used only on pipe that is end formed to StrengThin™ specifications using the VSF216 End-Forming Tool.
- **DO NOT** attempt to assemble these products on pipe that is direct grooved to Victaulic Advanced Groove System (AGS) or Victaulic Original Groove System (OGS) specifications.
- 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 cause improper product installation, resulting in death, serious personal injury, or property damage.

INSTALLATION INSTRUCTIONS

The information contained in this instruction sheet must be referenced to ensure proper installation of Style D08 StrengThin Rigid Couplings. Style D08 Couplings require pipe that is end formed with the VSF216 End-Forming Tool and StrengThin die sets (refer to the TM-VSF216 for complete tool setup requirements).



1. CHECK PIPE ENDS: The outside surface of the pipe ends must be smooth and free from indentations and projections to ensure a leak-tight seal. All oil, grease, and dirt must be removed.

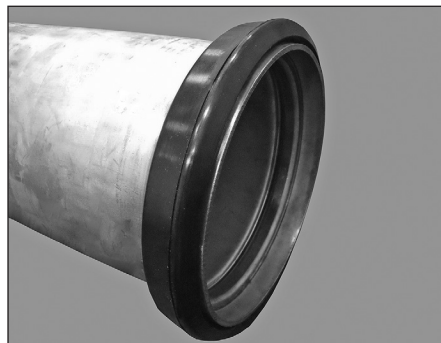


2. CHECK GASKET AND LUBRICATE: Check the gasket to make sure it is suitable for the intended service. The color code identifies the gasket grade. Apply a thin coat of Victaulic Lubricant or silicone lubricant to the gasket sealing lips and exterior.

⚠ CAUTION

- A compatible lubricant must be used to prevent the gasket from pinching/tearing during installation.

Failure to use a compatible lubricant could cause damage to the gasket, resulting in joint leakage and property damage.



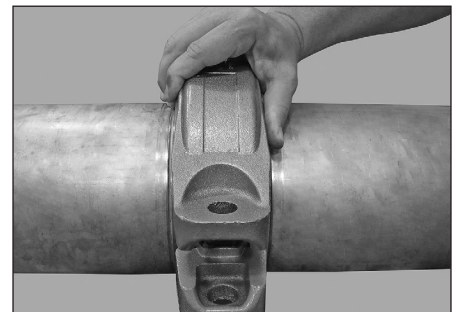
3. POSITION GASKET: Position the gasket over the pipe end. Make sure the gasket does not overhang the pipe end.



4. JOIN PIPE ENDS: Align and bring the two pipe ends together. Slide the gasket into position and center it between the grooves, as shown. Make sure no portion of the gasket extends into the groove in either pipe end.

NOTICE

- Style D08 Coupling housings have a tongue and recess feature. The tongue and recess features must be mated properly (tongue in recess) during installation.



5. INSTALL HOUSINGS: Install the housings over the gasket with the tongue and recess features mated properly (tongue in recess). Make sure the housings' keys engage the grooves completely on both pipe ends.

StrengThin™ Rigid Coupling

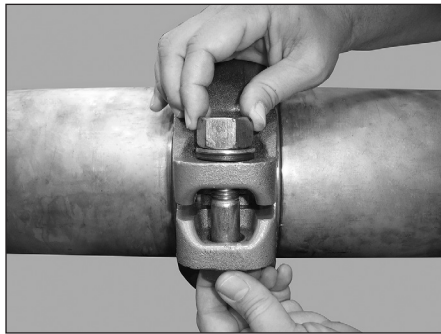
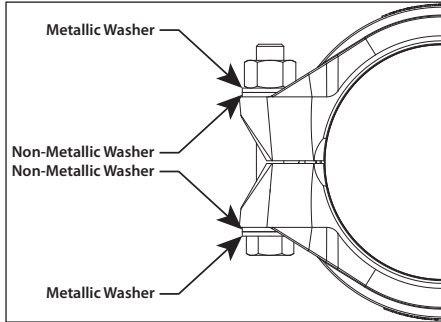


STYLE D08

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 and property damage.



6. LUBRICATE AND INSTALL BOLTS: Lubricate the bolt threads with a coat of anti-seize compound or Victaulic Lubricant. Install the bolts with washers in the orientation shown above.

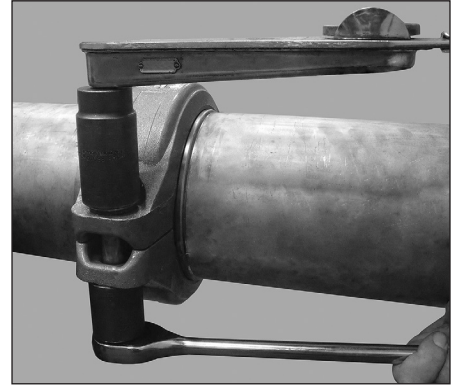
WARNING

- The housings' tongue and recess feature must mate properly (tongue in recess).
- The washers must be inserted between the bolt head/bolt pad and nut/bolt pad in the orientation shown in these instructions.
- For proper assembly, the nuts must be tightened evenly by alternating sides until equal gaps are present at each bolt pad AND the required torque values are achieved.
- Keep hands away from coupling openings during tightening.

Failure to follow these instructions could cause joint failure, resulting in serious personal injury or property damage.



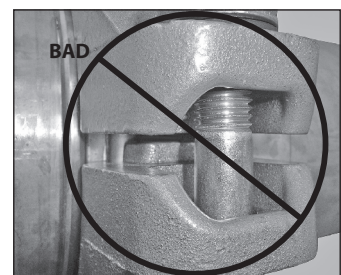
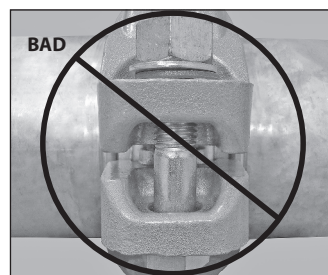
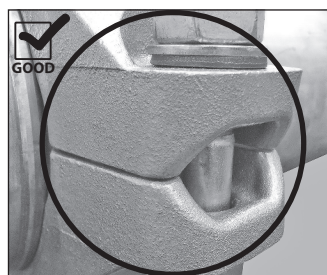
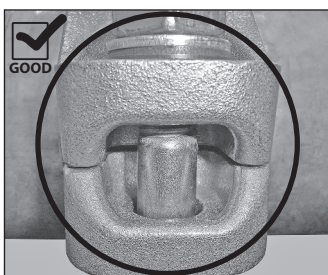
7. TIGHTEN NUTS: Tighten the nuts evenly by alternating sides. Make sure the housings' keys engage the grooves completely and the gaps are equal at the bolt pads. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching.



8. APPLY TORQUE: Apply torque to each nut with a torque wrench. Refer to the "Style D08 Torque Requirements" table below.

STYLE D08 TORQUE REQUIREMENTS

Nominal Size inches	Size		Required Torque ft-lbs N•m
	Nominal Size inches	Actual Pipe Outside Diameter inches/mm	
2, 2½, & 3	2.375, 2.875, & 3.500	60.3, 73.0, & 88.9	35 - 50 47 - 68
	4	4.500 114.3	
6	6.625 168.3	110 - 150 149 - 203	
8	8.625 219.1	225 - 325 305 - 441	
10 & 12	10.750 & 12.750 273.0 & 323.9	350 - 450 475 - 610	
14 & 16	14.000 & 16.000 355.6 & 406.4	500 - 600 678 - 813	



9. Inspect the bolt pads at each joint to ensure proper assembly is achieved (gaps are equal at each bolt pad and the required torque values are achieved).

STYLE D08 HELPFUL INFORMATION

Size		Bolt Size	Bolt Socket Size	Nut Size	Nut Socket Size
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	inches/Metric	inches/mm	inches/Metric	inches/mm
2, 2½, & 3	2.375, 2.875, & 3.500	½	¾	½	7/8
	60.3, 73.0, & 88.9	M12	18	M12	22
4	4.500	5/8	15/16	5/8	1 1/16
	114.3	M16	24	M16	27
6	6.625	¾	1 1/8	¾	1 ¼
	168.3	M20	30	M20	32

Size		Bolt Size	Bolt Socket Size	Nut Size	Nut Socket Size
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	inches/Metric	inches/mm	inches/Metric	inches/mm
8	8.625	1	1 ½	1	1 3/8
	219.1	M24	36	M24	41
10 & 12	10.750 & 12.750	1 ¼	1 7/8	1 ¼	2
	273.0 & 323.9	M30	46	M30	50
14 & 16	14.000 & 16.000	1 ½	2 ¼	1 ½	2 3/8
	355.6 & 406.4	M36	55	M36	60

For complete contact information, visit www.victaulic.com

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