



**Vic-Press™ Specification for Schedule 10S Stainless Steel Pipe**  
**2" (DN50) and Smaller**

**1.01 General:**

**A. Specification Includes:**

1. General.
2. Materials:
  - a. Pipe
  - b. Victaulic Vic-Press™ Couplings and Fittings
  - c. Victaulic Vic-Press™ Valves
3. Execution.

**B. Submittals:**

1. Vic-Press™ products shall be shown on drawings and product submittals.

**C. References:**

1. American Society for Testing Materials (ASTM):
  - a. ASTM A-276 – Stainless Steel Bars and Shapes.
  - b. ASTM A-312 - Seamless and Welded Austenitic Stainless Steel Pipe.
  - b. ASTM D-2000 – Standard Classification System for Rubber Products in Automotive Application.

**D. Quality Assurance:**

1. All Vic-Press™ fittings, couplings, and valves shall be the products of Victaulic.
2. Tools used for marking pipe and installing Vic-Press™ materials shall be manufactured by Victaulic and be of the proper size and type.



## 2.01 Materials

A. **Pipe:** ASTM A312, Type [[304/304L] [316/316L], Sch. 10S, pipe, dimensions conforming to ANSI/ASME B36.19M-1985.

B. **Fittings:**

1. Vic-Press 304™: ASTM A-312 stainless steel housings with ASTM A-276 and A-312 outlets and austenitic stainless steel plain or grooved ends, type 304, complete with synthetic rubber Grade “H” (HNBR) seals rated for applicable services to +210 Deg F [+98 Deg C]; Grade “E” EPDM for applicable services to +250 Deg F [+120 Deg C]; or Grade “O” Fluoroelastomer for applicable services to +300 Deg F [+149 Deg C]. System shall be rated to 500 psi (3447 kPa) unless noted otherwise.

- a. Flange Adapters: ANSI Class 150 flange adapter, Van Stone type with stainless steel back-up flange and Vic-Press™ ends. Rated for services to 275 psi (1876 kPa). Victaulic Style P565.
- b. Unions: Threaded union, 304/304L stainless steel, with Vic-Press™ ends. Victaulic Style P584.
- c. Vic-Press with HNBR or EPDM seals shall be ANSI/NSF 61 Annex G Certified for Potable Water.
- d. Vic-Press system shall be FM approved for fire protection services.

2. Vic-Press 316™: ASTM A-312 stainless steel housings with ASTM A-276 and A-312 outlets and stainless steel plain or grooved ends, type 316, complete with synthetic rubber Grade “H” (HNBR) seals rated for applicable services to +210 Deg F [+98 Deg C]; Grade “E” EPDM for applicable services to +250 Deg F [+120 Deg C]; or Grade “O” Fluoroelastomer for applicable services to +300 Deg F [+149 Deg C]. System shall be rated to 500 psi (3447 kPa) unless noted otherwise.

- a. Flange Adapters: ANSI Class 150 flange adapter, Van Stone type with stainless steel back-up flange and Vic-Press™ ends. Rated for services to 275 psi (1876 kPa). Victaulic Style P566.
- b. Unions: Threaded union, 316/316L stainless steel, with Vic-Press™ ends. Victaulic Style P585.
- c. Vic-Press with HNBR or EPDM seals shall be ANSI/NSF 61 Annex G Certified for Potable Water.
- d. Vic-Press system shall be FM approved for fire protection services.

C. **Valves:**



1. CF8M stainless steel body, ball, and stem, PTFE seats, 304 stainless steel handle, nut, and stem washer, with Schedule 10S stainless steel type 316 Vic-Press™ and/or grooved ends. Rated for services to 400 psi (2750 kPa). Victaulic Series P569. The valves shall have a blow-out proof stem and self-adjusting floating ball which provides uniform sealing. The full port design minimizes pressure drop for maximum flow efficiency. Valves shall be three-piece swing-out design to permit easy in-line maintenance.
2. ASTM B30 forged brass body, chrome-plated brass ball and stem, PTFE seats, zinc-plated carbon steel handle, with austenitic stainless steel ends for use with Vic-Press™ couplings and fittings. Rated for services to 300 psi (2065 kPa). Victaulic Series 589.

**D. Tooling:**

1. Victaulic Vic-Press™ Tool for Schedule 10S pipe, Model PFT510.
2. Tools shall be fitted with the proper sized Victaulic jaws for pressing.

**3.01 Execution:**

**A. Installation:**

1. Install in accordance with manufacturer's latest recommendations. Follow the instructions listed in the latest Victaulic I-P500 assembly manual.
2. Pipe shall be square cut, plus or minus 0.030", properly deburred and cleaned.
3. Pipe ends shall be marked at the required location, using a manufacturer-supplied gauge, to ensure full insertion into the coupling or fitting during assembly. Use a Victaulic "PFT-510" series tool with the proper sized jaw for pressing.
4. The Vic-Press™ System meets the support and hanging requirements of ASME B31.1, B31.3, and B31.9.

**B. Training:**

1. Victaulic's factory trained representative shall provide on-site training for contractor's field personnel prior to installation in the use of PFT tools, application, and installation of products.

**C. Application:**



1. Use Vic-Press™ in lieu of soldered copper, or socket-welded or butt-welded steel, or threaded steel for pipe sizes ½” (DN15) through 2” (DN50).
2. Use Vic-Press™ end valves where possible. Install Vic-Press 304™ flange or threaded adapters where flanged or threaded valves are required.
3. Services shall be verified as suitable for the temperature range and the seal elastomer. Suggested applications may include:
  - a. Compressed Air.
  - b. Instrument Air.
  - c. Lube Oil.
  - d. Cooling Water.
  - e. Deionized / Demineralized Water.
  - f. Eye Wash / Emergency Shower Station Water.
  - g. Potable Water.
  - h. Fire Protection / Sprinkler.
4. Victaulic’s representative shall periodically visit the jobsite and review installation. Contractor shall remove and replace any joints deemed improperly installed.