



### 3.0 SPECIFICATIONS – MATERIAL

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**Housing:** Ductile iron conforming to ASTM A536, Grade 65-45-12. Ductile iron conforming to ASTM A395, Grade 65-45-15, is available upon special request.

**Housing Coating:**

Orange enamel.

Optional: Hot dipped galvanized.

Optional: Contact Victaulic with your requirements for other coatings.

**Jaws:**

Carbon steel, case hardened, electroplated, except sizes 1"/DN25, DN65 and DN125, which utilize stainless steel, Type 416, hardened.

**Gaskets: (specify choice<sup>1</sup>)**

**Grade “E” EPDM**

EPDM (Green 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 “T” Nitrile**

Nitrile (Orange color code). Temperature range –20°F to +180°F/–29°C to +82°C. May be specified for oil related services, including air with oil vapor, this gasket may be specified for temperatures rated up to +180°F/+82°C. For water related services, this gasket may be specified for temperatures rated up to +150°F/+66°C. For oil free, dry air services, this gasket may be specified for temperatures rated up to +140°F/+60°C. **NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.**

**Others**

For alternate gasket selection, reference [publication 05.01](#): Victaulic Seal Selection Guide.

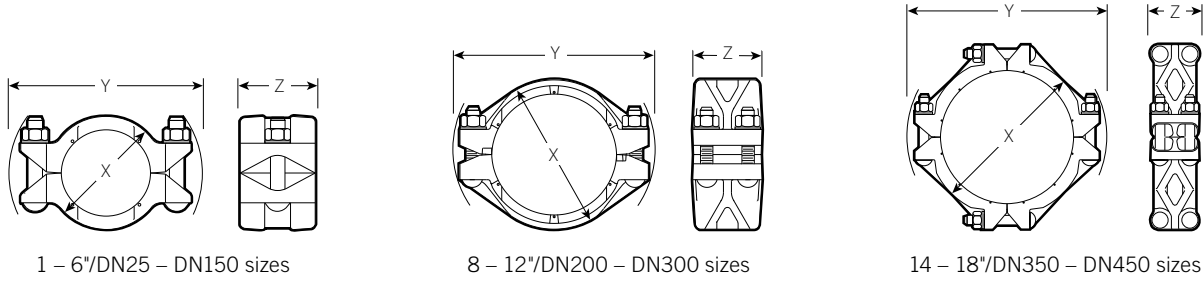
<sup>1</sup> Services listed are General Service Recommendations only. It should be noted that there are services for which these gaskets are not recommended. Reference should always be made to the latest [Victaulic Seal Selection Guide](#) for specific gasket service recommendations and for a listing of services which are not recommended.

**Bolts/Nuts:**

Standard: Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449 (imperial) and ISO 898-1 (metric) Class 9.8 (M10-M16) and Class 8.8 (M20 and greater). Carbon steel hex nuts meeting the mechanical property requirements of ASTM A563 Grade B (imperial – heavy hex nuts) and ASTM A563M Class 9 (metric – hex nuts). Track bolts and hex nuts are zinc electroplated per ASTM B633 ZN/FE5, finish Type III (imperial) or Type II (metric).

**Washers (sizes 6"/DN150 and larger):** Hardened steel washers meeting ASTM F436 Type 3 (weathering steel).

## 4.0 DIMENSIONS



| Size                    |   | Bolt/Nut <sup>2</sup> |                        | Dimensions        |                   |                   | Aprox. Weight<br>lb<br>kg |
|-------------------------|---|-----------------------|------------------------|-------------------|-------------------|-------------------|---------------------------|
| Nominal<br>inches<br>DN | Actual<br>Outside<br>Diameter<br>inches<br>mm | Qty.                  | Size<br>inches         | X<br>inches<br>mm | Y<br>inches<br>mm | Z<br>inches<br>mm |                           |
| 1<br>DN25               | 1.315<br>33.7                                 | 2                     | 3/8 x 2                | 2.63<br>67        | 4.25<br>108       | 2.25<br>57        | 1.7<br>0.8                |
| 1 1/2<br>DN40           | 1.900<br>48.3                                 | 2                     | 1/2 x 2 1/2            | 3.25<br>83        | 5.50<br>140       | 2.88<br>73        | 3.6<br>1.6                |
| 2<br>DN50               | 2.375<br>60.3                                 | 2                     | 5/8 x 3 1/4            | 3.75<br>95        | 6.75<br>171       | 3.38<br>86        | 5.3<br>2.4                |
| 2 1/2                   | 2.875<br>73.0                                 | 2                     | 5/8 x 3 1/4            | 4.25<br>108       | 7.13<br>181       | 3.38<br>86        | 5.7<br>2.5                |
| DN65                    | 3.000<br>76.1                                 | 2                     | 1/2 x 2 3/4            | 4.75<br>121       | 6.25<br>159       | 2.75<br>70        | 4.4<br>2.0                |
| 3<br>DN80               | 3.500<br>88.9                                 | 2                     | 3/4 x 4 1/4            | 5.00<br>127       | 8.50<br>216       | 3.38<br>86        | 8.7<br>3.9                |
| 3 1/2<br>DN90           | 4.000<br>101.6                                | 2                     | 3/4 x 4 1/4            | 5.50<br>140       | 9.25<br>235       | 3.63<br>92        | 10.6<br>4.8               |
| 4<br>DN100              | 4.500<br>114.3                                | 2                     | 3/4 x 4 1/4            | 6.13<br>156       | 10.00<br>254      | 4.00<br>102       | 12.8<br>5.8               |
| DN125                   | 5.500<br>139.7                                | 2                     | 3/4 x 5                | 7.88<br>200       | 10.75<br>260      | 3.25<br>83        | 9.0<br>4.1                |
| 5                       | 5.563<br>141.3                                | 2                     | 7/8 x 5                | 7.25<br>184       | 11.38<br>289      | 4.38<br>111       | 17.3<br>7.8               |
| 6<br>DN150              | 6.625<br>168.3                                | 2                     | 1 x 6 <sup>3</sup>     | 8.50<br>216       | 13.38<br>340      | 4.38<br>111       | 23.2<br>10.5              |
|                         | 6.500<br>165.1                                | 2                     | 1 x 6 <sup>3</sup>     | 8.38<br>213       | 13.25<br>337      | 4.38<br>111       | 22.2<br>10.1              |
| 8<br>DN200              | 8.625<br>219.1                                | 4                     | 7/8 x 5 <sup>3</sup>   | 10.88<br>276      | 14.38<br>365      | 5.00<br>127       | 37.2<br>16.9              |
| 10<br>DN250             | 10.750<br>273.0                               | 4                     | 7/8 x 5 <sup>3</sup>   | 13.38<br>340      | 16.38<br>416      | 5.00<br>127       | 48.2<br>21.9              |
| 12<br>DN300             | 12.750<br>323.9                               | 4                     | 1 x 6 1/2 <sup>3</sup> | 15.50<br>394      | 19.63<br>499      | 5.13<br>130       | 60.0<br>27.2              |
| 14<br>DN350             | 14.000<br>355.6                               | 8                     | 1 x 6 1/2 <sup>3</sup> | 16.75<br>425      | 20.75<br>527      | 5.38<br>137       | 89.0<br>40.4              |
| 16<br>DN400             | 16.000<br>406.4                               | 8                     | 1 x 6 1/2 <sup>3</sup> | 19.00<br>483      | 22.63<br>575      | 5.38<br>137       | 105.0<br>47.6             |
| 18<br>DN450             | 18.000<br>457.0                               | 8                     | 1 x 6 1/2 <sup>3</sup> | 21.00<br>533      | 23.50<br>597      | 5.38<br>137       | 125.0<br>56.7             |

<sup>2</sup> Metric thread size bolts (plated) are available (color coded) for all coupling sizes upon request. Contact Victaulic for details.

<sup>3</sup> Supplied with flat washers.

## 5.0 PERFORMANCE

### Pressure Ratings and End Loads Carbon Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 1<br>DN25               | 1.315<br>33.7                           | 0.179<br>4.55                    | 80              | 35<br>48   | —   | —                                |
|                         |   | 0.133<br>3.38                    | 40              |  | 600<br>4137                                 | 800<br>3560                      |
|                         |   | 0.109<br>2.77                    | 10              |  | 600<br>4137                                 | 800<br>3560                      |
|                         |   | 0.065<br>1.65                    | 5               |  | 400<br>2758                                 | 550<br>2450                      |
| 1½<br>DN40              | 1.900<br>48.3                           | 0.200<br>5.08                    | 80              | 60<br>81   | 750<br>5171                                 | 2100<br>9345                     |
|                         |   | 0.145<br>3.68                    | 40              |  | 750<br>5171                                 | 2100<br>9345                     |
|                         |   | 0.109<br>2.77                    | 10              |  | 600<br>4137                                 | 1700<br>7565                     |
|                         |   | 0.065<br>1.65                    | 5               |  | 400<br>2758                                 | 1100<br>4895                     |
| 2<br>DN50               | 2.375<br>60.3                           | 0.218<br>5.54                    | 80              | 150<br>203   | 750<br>5171                                 | 3300<br>14685                    |
|                         |   | 0.154<br>3.91                    | 40              |  | 750<br>5171                                 | 3300<br>14685                    |
|                         |   | 0.109<br>2.77                    | 10              |  | 400<br>2758                                 | 1800<br>8010                     |
|                         |   | 0.065<br>1.65                    | 5               |  | 200<br>1379                                 | 900<br>4005                      |
| 2½                      | 2.875<br>73.0                           | 0.276<br>7.01                    | 80              | 150<br>203   | 600<br>4137                                 | 3890<br>17310                    |
|                         |   | 0.203<br>5.16                    | 40              |  | 600<br>4137                                 | 3890<br>17310                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 300<br>2068                                 | 1900<br>8455                     |
|                         |   | 0.083<br>2.11                    | 5               |  | 150<br>1034                                 | 1000<br>4450                     |
| 3<br>DN80               | 3.500<br>88.9                           | 0.300<br>7.62                    | 80              | 200<br>271   | 600<br>4137                                 | 5770<br>25675                    |
|                         |   | 0.216<br>5.49                    | 40              |  | 600<br>4137                                 | 5770<br>25675                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 225<br>1551                                 | 2160<br>9610                     |
|                         |   | 0.083<br>2.11                    | 5               |  | 125<br>862                                  | 1200<br>5340                     |

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.0 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Carbon Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 3½<br>DN90              | 4.000<br>101.6                          | 0.318<br>8.08                    | 80              | 200<br>271   | 500<br>3447                                 | 6280<br>27945                    |
|                         |   | 0.226<br>5.74                    | 40              |  | 500<br>3447                                 | 6280<br>27945                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 200<br>1379                                 | 2500<br>11125                    |
|                         |   | 0.083<br>2.11                    | 5               |  | 100<br>689                                  | 1250<br>5565                     |
| 4<br>DN100              | 4.500<br>114.3                          | 0.337<br>8.56                    | 80              | 200<br>271   | 450<br>3103                                 | 7155<br>31840                    |
|                         |   | 0.237<br>6.02                    | 40              |  | 450<br>3103                                 | 7155<br>31840                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 175<br>1207                                 | 2800<br>12460                    |
|                         |   | 0.083<br>2.11                    | 5               |  | 60<br>414                                   | 950<br>4230                      |
| 5                       | 5.563<br>141.3                          | 0.375<br>9.53                    | 80              | 250<br>339   | 350<br>2413                                 | 8500<br>37825                    |
|                         |   | 0.258<br>6.55                    | 40              |  | 350<br>2413                                 | 8500<br>37825                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 150<br>1034                                 | 3600<br>16020                    |
|                         |   | 0.109<br>2.77                    | 5               |  | 75<br>517                                   | 1800<br>8010                     |
| 6<br>DN150              | 6.625<br>168.3                          | 0.432<br>10.97                   | 80              | 250<br>339   | 300<br>2068                                 | 10340<br>46015                   |
|                         |   | 0.280<br>7.11                    | 40              |  | 300<br>2068                                 | 10340<br>46015                   |
|                         |   | 0.134<br>3.40                    | 10              |  | 100<br>689                                  | 3500<br>15575                    |
|                         |   | 0.109<br>2.77                    | 5               |  | 75<br>517                                   | 2600<br>11570                    |
| 6.500<br>165.1          | 6.500<br>165.1                          | 0.250<br>6.35                    | —               | 250<br>339   | 300<br>2068                                 | 9955<br>44300                    |
|                         |   | 0.200<br>5.08                    | —               |  | 175<br>1207                                 | 6000<br>26700                    |
|                         |   | 0.150<br>3.81                    | —               |  | 100<br>689                                  | 3500<br>15575                    |

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.0 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Carbon Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 8<br>DN200              | 8.625<br>219.1                          | 0.322<br>8.18                    | 40              | 250<br>339   | 250<br>1724                                 | 14600<br>64970                   |
|                         |   | 0.277<br>7.04                    | 30              |  | 200<br>1379                                 | 11700<br>52065                   |
|                         |   | 0.148<br>3.76                    | 10              |  | 100<br>689                                  | 6000<br>26700                    |
|                         |   | 0.109<br>2.77                    | 5               |  | 50<br>345                                   | 3000<br>13350                    |
| 10<br>DN250             | 10.750<br>273.0                         | 0.365<br>9.27                    | 40              | 300<br>407   | 250<br>1724                                 | 22700<br>101015                  |
|                         |   | 0.307<br>7.80                    | 30              |  | 175<br>1207                                 | 15900<br>70755                   |
|                         |   | 0.165<br>4.19                    | 10              |  | 75<br>517                                   | 6800<br>30260                    |
|                         |   | 0.134<br>3.40                    | 5               |  | 50<br>345                                   | 4500<br>20025                    |
| 12<br>DN300             | 12.750<br>323.9                         | 0.375<br>9.53                    | STD             | 350<br>475   | 250<br>1724                                 | 31900<br>141955                  |
|                         |   | 0.330<br>8.38                    | 30              |  | 150<br>1034                                 | 19100<br>84995                   |
|                         |   | 0.180<br>4.57                    | 10              |  | 100<br>689                                  | 12700<br>56515                   |
|                         |   | 0.165<br>4.19                    | 5               |  | 75<br>517                                   | 9500<br>42275                    |
| 14<br>DN350             | 14.000<br>355.6                         | 0.375<br>9.53                    | STD             | 350<br>475   | 200<br>1379                                 | 30800<br>137060                  |
| 16<br>DN400             | 16.000<br>406.4                         | 0.375<br>9.53                    | STD             | 350<br>475   | 150<br>1034                                 | 30200<br>134390                  |
| 18<br>DN450             | 18.000<br>457.2                         | 0.375<br>9.53                    | STD             | +  | +   | +                                |

+ Contact Victaulic for more details.

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.1 PERFORMANCE

### Pressure Ratings and End Loads Stainless Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 1<br>DN25               | 1.315<br>33.7                           | 0.133<br>3.38                    | 40              | 35<br>48   | 600<br>4137                                 | 800<br>3560                      |
|                         |   | 0.109<br>2.77                    | 10              |  | 400<br>2758                                 | 550<br>2450                      |
|                         |   | 0.065<br>1.65                    | 5               |  | 250<br>1724                                 | 350<br>1555                      |
| 1½<br>DN40              | 1.900<br>48.3                           | 0.145<br>3.56                    | 40              | 60<br>81   | 500<br>3447                                 | 1400<br>6230                     |
|                         |   | 0.109<br>2.77                    | 10              |  | 400<br>2758                                 | 1100<br>4895                     |
|                         |   | 0.065<br>1.65                    | 5               | N/R  | N/R   | N/R                              |
| 2<br>DN50               | 2.375<br>60.3                           | 0.154<br>3.91                    | 40              | 150<br>203   | 500<br>3447                                 | 2200<br>9790                     |
|                         |   | 0.109<br>2.77                    | 10              |  | 400<br>2758                                 | 1800<br>8010                     |
|                         |   | 0.065<br>1.65                    | 5               | N/R  | N/R   | N/R                              |
| 2½                      | 2.875<br>73.0                           | 0.203<br>5.16                    | 40              | 150<br>203   | 400<br>2758                                 | 2500<br>11125                    |
|                         |   | 0.120<br>5.16                    | 10              |  | 250<br>1724                                 | 1500<br>6675                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 3<br>DN80               | 3.500<br>88.9                           | 0.216<br>5.49                    | 40              | 200<br>271   | 400<br>2758                                 | 3800<br>16910                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 200<br>1379                                 | 1900<br>8455                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |

N/R = Not recommended

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.19.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

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- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.1 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Stainless Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 3½<br>DN90              | 4.000<br>101.6                          | 0.226<br>5.74                    | 40              | 200<br>271   | 300<br>2068                                 | 3700<br>16465                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 150<br>1034                                 | 1900<br>8455                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 4<br>DN100              | 4.500<br>114.3                          | 0.237<br>6.02                    | 40              | 200<br>271   | 250<br>1724                                 | 3900<br>17355                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 80<br>552                                   | 1300<br>5785                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 5                       | 5.563<br>141.3                          | 0.258<br>6.55                    | 40              | 250<br>339   | 200<br>1379                                 | 4800<br>21360                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 75<br>517                                   | 1800<br>8010                     |
|                         |   | 0.109<br>2.77                    | 5               | N/R  | N/R   | N/R                              |
| 6<br>DN150              | 6.625<br>168.3                          | 0.280<br>7.11                    | 40              | 250<br>339   | 200<br>1379                                 | 6800<br>30260                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 75<br>517                                   | 2600<br>11570                    |
|                         |   | 0.109<br>2.77                    | 5               | N/R  | N/R   | N/R                              |
|                         | 6.500<br>165.1                          | 0.280<br>7.11                    | 40              | 250<br>339   | 200<br>1379                                 | 6800<br>30260                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 75<br>517                                   | 2600<br>11570                    |
|                         |   | 0.109<br>2.77                    | 5               | N/R  | N/R   | N/R                              |

N/R = Not recommended

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.19.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.



## 5.1 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Stainless Steel Pipe

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 8<br>DN200              | 8.625<br>219.1                          | 0.322<br>8.18                    | 40              | 250<br>339   | 200<br>1379                                 | 11000<br>48950                   |
|                         |   | 0.148<br>3.76                    | 10              |  | 75<br>517                                   | 4400<br>19580                    |
|                         |   | 0.109<br>2.77                    | 5               |  | 25<br>172                                   | 1460<br>6495                     |
| 10<br>DN250             | 10.750<br>273.0                         | 0.365<br>9.27                    | 40              | 300<br>407   | 100<br>689                                  | 9000<br>40050                    |
|                         |   | 0.165<br>4.19                    | 10              |  | 50<br>345                                   | 4500<br>20025                    |
|                         |   | 0.134<br>3.40                    | 5               |  | 25<br>172                                   | 2250<br>10010                    |
| 12<br>DN300             | 12.750<br>323.9                         | 0.406<br>10.31                   | 40              | 350<br>475   | 100<br>689                                  | 12750<br>56735                   |
|                         |   | 0.180<br>4.67                    | 10              |  | 50<br>345                                   | 6400<br>28480                    |
|                         |   | 0.156<br>3.96                    | 5               |  | 25<br>172                                   | 3200<br>14240                    |

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.19.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.2 PERFORMANCE

### Pressure Ratings and End Loads Aluminum Pipe<sup>7</sup>

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 1<br>DN25               | 1.315<br>33.7                           | 0.179<br>4.55                    | 80              | N/R  | N/R   | N/R                              |
|                         |   | 0.133<br>3.38                    | 40              | 35<br>48   | 600<br>4137                                 | 800<br>3560                      |
|                         |   | 0.109<br>2.77                    | 10              |  | 300<br>2068                                 | 400<br>1780                      |
|                         |   | 0.065<br>1.65                    | 5               | 100<br>689   | 135<br>601                                  |                                  |
| 1½<br>DN40              | 1.900<br>48.3                           | 0.200<br>5.08                    | 80              | 60<br>81   | 500<br>3447                                 | 1400<br>6230                     |
|                         |   | 0.145<br>3.56                    | 40              |  | 400<br>2758                                 | 1100<br>4895                     |
|                         |   | 0.109<br>2.77                    | 10              |  | 300<br>2068                                 | 825<br>3671                      |
|                         |   | 0.065<br>1.65                    | 5               | N/R  | N/R   | N/R                              |
| 2<br>DN50               | 2.375<br>60.3                           | 0.218<br>5.54                    | 80              | 150<br>203   | 400<br>2758                                 | 1800<br>8010                     |
|                         |   | 0.154<br>3.91                    | 40              |  | 300<br>2068                                 | 1300<br>5785                     |
|                         |   | 0.109<br>2.77                    | 10              |  | 200<br>1379                                 | 900<br>4005                      |
|                         |   | 0.065<br>1.65                    | 5               | N/R  | N/R   | N/R                              |
| 2½                      | 2.875<br>73.0                           | 0.276<br>7.01                    | 80              | 150<br>203   | 350<br>2413                                 | 2200<br>9790                     |
|                         |   | 0.203<br>5.16                    | 40              |  | 275<br>1896                                 | 1725<br>7676                     |
|                         |   | 0.120<br>5.16                    | 10              |  | 150<br>1034                                 | 1000<br>4450                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |

N/R = Not recommended

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

<sup>7</sup> Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.2 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Aluminum Pipe<sup>7</sup>

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 3<br>DN80               | 3.500<br>88.9                           | 0.300<br>7.62                    | 80              | 200<br>271   | 300<br>2068                                 | 2880<br>12816                    |
|                         |   | 0.216<br>5.49                    | 40              |  | 200<br>1379                                 | 1920<br>8544                     |
|                         |   | 0.120<br>3.05                    | 10              |  | 100<br>689                                  | 960<br>4272                      |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 3½<br>DN90              | 4.000<br>101.6                          | 0.318<br>8.08                    | 80              | 200<br>271   | 250<br>1724                                 | 3100<br>13795                    |
|                         |   | 0.226<br>5.74                    | 40              |  | 200<br>1379                                 | 2500<br>11125                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 100<br>689                                  | 1250<br>5563                     |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 4<br>DN100              | 4.500<br>114.3                          | 0.337<br>8.56                    | 80              | 200<br>271   | 200<br>1379                                 | 3200<br>14240                    |
|                         |   | 0.237<br>6.02                    | 40              |  | 150<br>1034                                 | 2400<br>10680                    |
|                         |   | 0.120<br>3.05                    | 10              |  | 50<br>345                                   | 800<br>3560                      |
|                         |   | 0.083<br>2.11                    | 5               | N/R  | N/R   | N/R                              |
| 5                       | 5.563<br>141.3                          | 0.375<br>9.53                    | 80              | 250<br>339   | 150<br>1034                                 | 3600<br>16020                    |
|                         |   | 0.258<br>6.55                    | 40              |  | 100<br>689                                  | 2400<br>10680                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 50<br>345                                   | 1200<br>5340                     |
|                         |   | 0.109<br>2.77                    | 5               | N/R  | N/R   | N/R                              |

N/R = Not recommended

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

<sup>7</sup> Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 5.2 PERFORMANCE (Continued)

### Pressure Ratings and End Loads Aluminum Pipe<sup>7</sup>

| Size                    |   | Pipe Wall Thickness <sup>4</sup> |                 | Required Bolt Torque <sup>5</sup><br>Lb • Ft.<br>N • m | Maximum                                     |                                  |
|-------------------------|---|----------------------------------|-----------------|--|---|----------------------------------|
| Nominal<br>inches<br>DN | Actual Outside Diameter<br>inches<br>mm | inches<br>mm                     | Schedule Number |  | Working Pressure <sup>6</sup><br>psi<br>kPa | End Load <sup>6</sup><br>lb<br>N |
| 6<br>DN150              | 6.625<br>168.3                          | 0.432<br>10.97                   | 80              | 250<br>339   | 150<br>1034                                 | 5200<br>23140                    |
|                         |   | 0.280<br>7.11                    | 40              |  | 100<br>689                                  | 3500<br>15575                    |
|                         |   | 0.134<br>3.40                    | 10              |  | 50<br>345                                   | 1750<br>7788                     |
|                         |   | 0.109<br>2.77                    | 5               |  | 35<br>241                                   | 1225<br>5451                     |
| 8<br>DN200              | 8.625<br>219.1                          | 0.322<br>8.18                    | 40              | 250<br>339   | 150<br>1034                                 | 9000<br>40050                    |
|                         |   | 0.277<br>7.04                    | 30              |  | 100<br>689                                  | 6000<br>26700                    |
|                         |   | 0.250<br>6.35                    | 20              |  | 75<br>517                                   | 4500<br>20025                    |
|                         |   | 0.148<br>3.76                    | 10              |  | 50<br>345                                   | 3000<br>13350                    |
| 10<br>DN250             | 10.750<br>273.0                         | 0.356<br>9.27                    | 40              | 300<br>407   | 100<br>698                                  | 9000<br>40050                    |
|                         |   | 0.307<br>7.80                    | 30              |  | 75<br>517                                   | 6300<br>28035                    |
|                         |   | 0.250<br>6.35                    | 20              |  | 50<br>345                                   | 4500<br>20025                    |
|                         |   | 0.165<br>4.19                    | 10              |  | 25<br>172                                   | 2250<br>10013                    |
| 12<br>DN300             | 12.750<br>323.9                         | 0.406<br>10.31                   | 40              | 300<br>407   | 100<br>689                                  | 12800<br>56960                   |
|                         |   | 0.330<br>8.38                    | 30              |  | 75<br>517                                   | 9500<br>42275                    |
|                         |   | 0.250<br>6.35                    | 20              |  | 50<br>345                                   | 6000<br>26700                    |
|                         |   | 0.180<br>4.67                    | 10              |  | 25<br>172                                   | 3150<br>14018                    |

<sup>4</sup> Pipe wall thickness schedule as established in ASME/ANSI B36.10.

<sup>5</sup> Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

<sup>7</sup> Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

#### NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

## 6.0 NOTIFICATIONS

### ⚠ WARNING

- Style 99 *Roust-A-Bout* couplings must be assembled with nuts tightened to full torque specifications.

### ⚠ WARNING



- Read and understand all instructions before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- 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 result in death or serious personal injury and property damage.

## 7.0 REFERENCE MATERIALS

[05.01: Victaulic Seal Selection Guide](#)

[26.01: Victaulic Design Data](#)

[29.01: Victaulic Terms and Conditions/Warranty](#)

[I-100: Victaulic Field Installation Handbook](#)

### User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, and the applicable building codes and related regulations as well as Victaulic performance, maintenance, safety, and warning 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, installation guide, or this disclaimer.

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### Note

This product shall be manufactured by Victaulic or to Victaulic specifications. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

### Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of 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 [www.victaulic.com](http://www.victaulic.com).

### Warranty

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

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