Victaulic® Refuse-to-Fuse™ Transition Coupling for HDPE-to-Steel Pipe

Style 907

19.10

1.0 PRODUCT DESCRIPTION

Available Sizes

- 2 – 8" IPS high-density polyethylene (HDPE) to 2 – 8"/DN50 – DN200 mm grooved steel
- 63 mm – 225 mm ISO high-density polyethylene (HDPE) to 2 – 8"/DN50 – DN200 mm grooved steel

Pipe Material

- HDPE pipe conforming to ASTM D3035 and ASTM F714 or ISO 4427-2 (SDR 7 – 21)

Maximum Working Pressure

- Meets or exceeds the pressure rating of the pipe

Operating Temperature

- Dependent upon pipe manufacturer rating and gasket selection
- Reference section 3.0 for gasket performance options
- Consult pipe manufacturer for pipe material performance limitations

Function

- Provides a single transition from plain end HDPE pipe to grooved steel sized piping system components
- Utilizes patented Installation-Ready™ technology to eliminate loose parts

Pipe Preparation

- For use on plain end HDPE pipe
- Prepare grooved pipe end in accordance with Publication 25.01: Original Groove System (OGS) Groove Specifications

2.0 CERTIFICATION/LISTINGS

NOTE

- See Publication 10.01: Victaulic Fire Protection Approval Reference Guide for details.
- See Publication 02.06: Victaulic Approvals for Potable Water Products – ANSI/NSF 61 and ANSI/NSF 372 if applicable.
- WaterMark™ certification only applies to fusion bonded epoxy-coated couplings with Grade “E” EPDM gaskets. Contact Victaulic for further details.

ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

3.0 SPECIFICATIONS – MATERIAL

Housing: Ductile iron conforming to ASTM A 536, Grade 65-45-12.

Housing Coating: (specify choice)

☐ Standard: Orange enamel for ANSI sizes. Black enamel for ISO sizes and 5" IPS.

☐ Optional: Fusion bonded epoxy, galvanized and other coatings are available. Contact Victaulic for details.

Retaining Ring: Type 316 stainless steel.

Coupling Gasket: (specify choice[1])

☐ **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 "E" EPDM**
EPDM (Green stripe color code). Temperature range –30°F to +230°F/–34°C to +110°C. May be specified for cold and 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 PETROLEUM SERVICES OR STEAM SERVICES.

☐ **Grade "EF" EPDM**
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 DVGW, KTW, ÖVGW, SVGW, and French ACS (Crecep), approved for W534, 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 "O" Fluoroelastomer**
Fluoroelastomer (Blue stripe color code). Temperature range +20°F to +300°F/-34°C to +110°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.

[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 Gasket Selection Guide for specific gasket service guidelines and for a listing of services which are not compatible.

NOTE

- The maximum temperature ratings shown exceed the temperature ratings for HDPE pipe. Consult individual pipe manufacturers for specific temperature limits.

Hardware:

Bolts/Nuts: (specify choice[2])

☐ Standard: Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449 (imperial) and ISO 898-1 Class 9.8 (M10-M16) 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), with fluoropolymer top coat. Hardened steel washers conforming to ASTM F436 Type 3 (weathering steel).

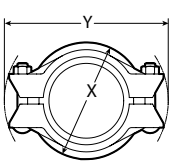
☐ Optional[2]:
2 – 4", 63 – 110 mm: Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM F593, Group 2 (316 stainless steel), condition CW. Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM F594, Group 2 (316 stainless steel), condition CW, with galling reducing coating. Hardened steel washers conforming to ASTM F436 Type 3 (weathering steel).

6 – 8"/125 – 225 mm: Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM A193 Class 2, Grade B8M. Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM A194 Grade 8M Heavy Hex, with galling reducing coating. Hardened steel washers conforming to ASTM F436 Type 3 (weathering steel).

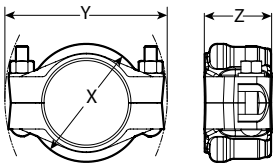
[2] Optional bolts/nuts available in imperial size only

4.0 DIMENSIONS

Style 907 – IPS Standard



Style 907 Pre-Assembled
(Installation-Ready Condition)

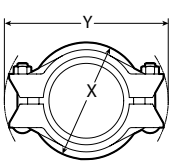


Style 907 Joint Assembled

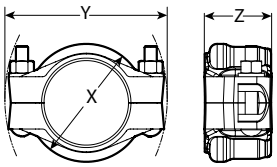
IPS Size		Bolt/Nut		Dimensions					Weight
				Pre-assembled (Installation-Ready™ condition)		Joint Assembled			
Nominal inches mm	Actual Outside Diameter inches mm	Qty.	Size inches	X inches mm	Y inches mm	X inches mm	Y inches mm	Z inches mm	Approximate (Each) lb kg
2 50	2.375 60.3	2	½ x 3¼	3.88 99	6.13 156	3.50 89	6.13 156	3.13 80	4.7 2.1
3 80	3.500 88.9	2	⅝ x 3½	5.13 130	7.63 194	4.50 114	7.63 194	3.13 80	6.6 3.0
4 100	4.500 114.3	2	⅝ x 4¼	6.75 172	8.88 226	6.13 156	8.88 226	3.50 89	9.4 4.3
5 125	5.563 141.3	2	¾ x 4¼	203 8.0	270 10.63	184 7.25	229 11.00	89 3.50	5.4 11.9
6 150	6.625 168.3	2	¾ x 5	8.88 226	11.75 299	8.00 203	11.75 299	3.50 89	13.8 6.3
8 200	8.625 219.1	2	¾ x 6¼	11.63 295	14.13 359	10.38 264	14.75 375	3.88 99	21.4 9.7

4.1 DIMENSIONS

Style 907 – ISO Standard



Style 907 Pre-Assembled
(Installation-Ready Condition)



Style 907 Joint Assembled

ISO Size HPDE Plain End x Grooved End			Bolt/Nut		Dimensions					Weight
					Pre-assembled (Installation-Ready™ condition)		Joint Assembled			
Nominal mm			Qty.	Size [3] mm inches	X mm inches	Y mm inches	X mm inches	Y mm inches	Z mm inches	Approximate (Each) kg lb
63	x	60.3	2	M12 x 83 ½ x 3¼	105 4.13	156 6.13	89 3.50	156 6.13	80 3.13	2.2 4.9
75	x	73.0	2	M16 x 83 ⅝ x 3¼	124 4.88	178 7.00	111 4.38	191 7.50	80 3.13	2.7 5.9
90	x	88.9	2	M16 x 102 ⅝ x 4	133 5.25	194 7.63	118 4.63	191 7.50	80 3.13	3.0 6.5
110	x	114.3	2	M16 x 102 ⅝ x 4	159 6.25	229 9.00	143 5.63	229 9.00	89 3.50	4.4 9.6
125	x	114.3	2	M20 x 108 ¾ x 4¼	181 7.13	254 10.00	163 6.38	267 10.50	89 3.50	5.1 11.3
140	x	141.3	2	M20 x 108 ¾ x 4¼	203 8.0	270 10.63	184 7.25	229 11.00	89 3.50	5.4 11.9
160	x	168.3	2	M20 x 127 ¾ x 5	216 8.50	292 11.50	194 7.63	292 11.50	89 3.50	5.8 12.8
180	x	168.3	2	M20 x 127 ¾ x 5	241 9.50	308 12.13	219 8.63	321 12.63	92 3.63	6.8 15.0
200	x	219.1	2	M20 x 159 ¾ x 6¼	289 11.38	365 14.38	260 10.25	381 15.00	99 3.88	9.8 21.7
225	x	219.1	2	M20 x 159 ¾ x 6¼	299 11.75	365 14.38	270 10.63	381 15.00	99 3.88	10.0 22.0

[3] Metric bolts/nuts standard, with the exception of North American, South American, and Australian shipments, where imperial sizes are standard.

5.0 PERFORMANCE

Style 907 – IPS Standard

Pressure Rating: joints made with Style 907 couplings meet the pressure rating of the HDPE pipe.

IPS Size	PE4710 HDPE Pipe[4] DR					
	7	9	11	13.5	17	21
Nominal Size inches	Pressure Rating psi kPa					
2 - 8	333 2295	250 1725	200 1380	160 1100	125 860	100 690

[4] HDPE pipe conforming to ASTM D3035 and F714 at 73°F/23°C. Reference plastic pipe manufacture data for derating factors at other temperatures.

NOTE

- Victaulic coupling gaskets have been demonstrated to seal under full (29" of Hg/3.4 kPa [absolute]) vacuum requirements. Consult the specific HDPE pipe manufacturer for their recommended limitations regarding maximum vacuum as well as the effects of temperature and pipe ovality.

5.1 PERFORMANCE

Style 907 – ISO Standard

Pressure Rating: joints made with Style 907 couplings meet the pressure rating of the HDPE pipe.

ISO Size	PE100 HDPE Pipe[5] SDR					
	7.4	9	11	13.6	17	21
Nominal Size mm	Pressure Rating Bar kPa psi					
63 – 225	25 2500 363	20 2000 290	16 1600 232	12.5 1250 182	10 1000 145	8 800 116

[5] HDPE pipe conforming to ISO 4427-2 at 68°F/20°C. Reference plastic pipe manufacture data for derating factors at other temperatures.

NOTE

- Contact Victaulic for other polyethylene materials.

5.2 PERFORMANCE

Style 907 – IPS Standard

Allowable Tensile Load (ATL): joints made with Style 907 couplings can sustain tensile loads noted below.

IPS Size	Allowable Tensile Load[6] DR					
	7	9	11	13.5	17	21
Nominal Size inches	lb N					
2	2369 10540	1911 8501	1599 7114	1327 5904	1071 4765	878 3906
3	5146 22890	4151 18463	3473 15449	2882 12821	2327 10349	1906 8478
4	8507 37839	6861 30520	5741 25539	4765 21195	3846 17108	3151 14016
5	12292 54678	10388 46208	8692 38664	7165 31872	5823 25902	4815 21418
6	18437 82013	14871 66151	12444 55353	10327 45938	8336 37081	6829 30377
8	31200 138784	25200 112095	21100 93857	17500 77844	14100 62720	11574 51484

5.3 PERFORMANCE

Style 907 – ISO Standard

Allowable Tensile Load (ATL): joints made with Style 907 couplings can sustain tensile loads noted below.

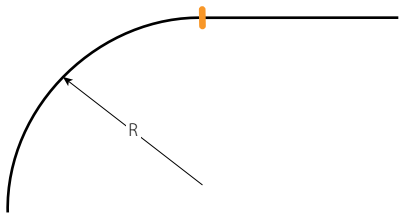
ISO Size	Allowable Tensile Load[6] SDR					
	7.4	9	11	13.6	17	21
Nominal Size mm	N lb					
63	11076 2490	9360 2104	7832 1761	6456 1451	5247 1179	4297 9606
75	15702 3530	13269 2983	11103 2496	9150 2057	7437 1672	6094 1370
90	22616 5084	19112 4297	15992 3595	13182 2964	10713 2408	8776 1973
110	33748 7587	28519 6411	23864 5365	19671 4422	15987 3594	13096 2944
125	43610 9804	36854 8285	30840 6933	25422 5715	20658 4644	16921 3804
140	54678 12292	46208 10388	38664 8692	31872 7165	25902 5823	21218 4770
160	71440 16061	60372 13572	50517 11357	41641 9361	33841 7608	27721 6232
180	90415 20326	76407 17177	63934 14373	52698 11847	42827 9628	35053 7887
200	111561 25080	94276 21194	78889 17735	65029 14619	52849 11881	43290 9732
225	141271 31759	119381 26838	99898 22458	82345 18512	66919 15044	54820 12324

[6] Allowable tensile loads shown are for straight pulling for a maximum period of one half hour at ambient temperature (68°F/20°C).

5.4 PERFORMANCE

Style 907 – IPS Standard

Bend Radius: joints made with Style 907 couplings can sustain a bending radius as recommended by the Plastic Pipe Institute (PPI) in the Handbook of PE Pipe (2nd ed, Chapter 7, Table 4).



IPS Size	Minimum Recommended Bend Radius DR					
Nominal Size inches	7	9	11	13.5	17	21
	inches mm					
2	48 1207	48 1207	59 1508	59 1508	64 1629	155 3937
3	70 1778	70 1778	88 2223	88 2223	95 2400	95 2400
4	90 2286	90 2286	113 2858	113 2858	122 3086	122 3086
5	111 2813	111 2813	138 3516	138 3516	149 3797	149 3797
6	133 3366	133 3366	166 4207	166 4207	179 4543	179 4543
8	173 4382	173 4382	216 5477	216 5477	233 5915	233 5915

5.5 PERFORMANCE

Style 907 – ISO Standard

Bend Radius: joints made with Style 907 couplings can sustain a bending radius as recommended by the Plastic Pipe Institute (PPI) in the Handbook of PE Pipe (2nd ed, Chapter 7, Table 4).

ISO Size	Minimum Recommended Bend Radius SDR					
Nominal Size mm	7.4	9	11	13.6	17	21
	mm inches					
63	1266 50	1266 50	1582 62	1582 62	1709 67	4090 161
75	1507 59	1507 59	1884 74	1884 74	2035 80	4877 192
90	1809 71	1809 71	2261 89	2261 89	2442 96	2442 96
110	2210 87	2210 87	2762 109	2762 109	2983 117	2983 117
125	2512 99	2512 99	3140 124	3140 124	3391 134	3391 134
140	2813 111	2813 111	3516 138	3516 138	3797 149	3797 149
160	3215 127	3215 127	4019 158	4019 158	4340 171	4340 171
180	3617 142	3617 142	4521 178	4521 178	4883 192	4883 192
200	4018 158	4018 158	5022 198	5022 198	5424 214	5424 214
225	4521 178	4521 178	5652 223	5652 223	6104 240	6104 240

6.0 NOTIFICATIONS

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 may cause joint failure, resulting in death or serious personal injury and property damage.

7.0 REFERENCE MATERIALS

I-900: HDPE Products Installation and Assembly Manual
IT-907: Style 907 Installation Tag
05.01: Gasket Selection Guide
19.07: Refuse-to-Fuse™ Style 905 Coupling for Plain End HDPE
19.09: Refuse-to-Fuse™ Style 908 Coupling for Double Grooved HDPE pipe
19.11: Refuse-to-Fuse™ HDPE Plain End Fittings
19.12: Refuse-to-Fuse™ Style 904 Flange Adapter for HDPE-to-Flanged Pipe
29.01: Terms and Conditions/Warranty

