

Victaulic® Rigid Coupling for Australian Standard Copper Style 606-AS



1.0 PRODUCT DESCRIPTION

Available Sizes

- DN50 – DN200/2 - 8"

Pipe Material

- Joins Australian Standard AS 1432 Types B and D copper tubing.

Maximum Working Pressure

- Accommodates pressures ranging from full vacuum (29.9 in Hg/760 mm Hg) up to 260 psi/1790 kPa/17.9 bar
- Working pressure dependent on wall thickness and size of tubing.

Operating Temperature

- -30°F to +250°F/-34°C to +120°C

Function

- Provides a rigid pipe joint designed to restrict axial and angular movement.
- Exclusively for use with fittings, valves, accessories and tubing which feature ends formed to meet the roll groove specifications for Australian Standard AS 1432 copper tubing found in [publication 25.06](#): Copper Tubing Roll Groove Specifications.

Pipe Preparation

- Victaulic has designed tools for grooving Australian Standard AS 1432 copper tubing. Tools must be equipped only with Victaulic rolls designed specifically for grooving AS 1432 copper tubing. DO NOT use rolls intended for light wall stainless steel, aluminum, PVC or steel pipe. For more information, see section 7.0 Reference Materials.
- The GDC-AC Go/No-Go Groove Diameter Cable for Australian Standard AS 1432 copper tubing is available for taking circumferential measurements. See [publication 24.01](#): Victaulic Pipe Preparation Tools for more information.

Codes and Requirements

- Support and hanging requirements correspond to AS/NZS 3500.

2.0 CERTIFICATION/LISTINGS



WaterMark

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

Housing Coating: Copper colored alkyd enamel.

Gasket: Grade “EHP” EPDM

EPDM (Red and Copper stripes). Temperature range –30°F to +250°F/–34°C to +120°C. May be specified for hot water service within the specified temperature range. WaterMark certified against Australian Standard AS 3688. NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.

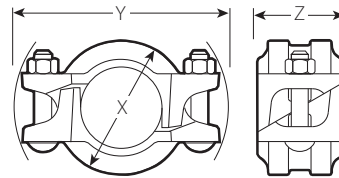
NOTES

- Additional elastomer materials are available. Contact Victaulic for details.
- 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 Seal Selection Guide](#) for specific gasket service guidelines and for a listing of services which are not compatible.

Bolts/Nuts: Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449 (imperial). Carbon steel hex nuts meeting the mechanical property requirements of ASTM A563 Grade B (imperial - Heavy Hex nuts). Track bolts and hex nuts are zinc electroplated per ASTM B633 ZN/FE5, finish Type III (imperial).

4.0 DIMENSIONS

Style 606-AS Rigid Coupling for Australian Standard Copper



Style 606-AS

Size		Tubing End Separation ¹	Bolt/Nut		Dimensions			Weight
Nominal DN inches	Actual Outside Diameter mm inches	Allowable mm inches	Qty.	Size inches	X mm inches	Y mm inches	Z mm inches	Approximate (Each) kg lb
DN50 2	50.8 2.000	0.8 0.03	2	M10 x 51 3/8 x 2	79 3.13	124 4.88	48 1.88	0.6 1.3
DN65 2½	63.5 2.500	0.8 0.03	2	M10 x 51 3/8 x 2	92 3.63	137 5.38	48 1.88	0.9 2.0
DN80 3	76.2 3.000	0.8 0.03	2	M12 x 70 ½ x 2¾	105 4.13	165 6.50	48 1.88	0.9 2.0
DN100 4	101.6 4.000	4.6 0.18	2	M12 x 70 ½ x 2¾	133 5.25	191 7.50	51 2.00	1.4 3.1
DN125 5	127.0 5.000	4.6 0.18	2	M16 x 83 5/8 x 3¼	159 6.25	235 9.25	51 2.00	2.2 4.9
DN150 6	152.4 6.000	4.6 0.18	2	M16 x 83 5/8 x 3¼	184 7.25	257 10.13	51 2.00	2.5 5.5
DN200 8	203.2 8.000	4.6 0.18	2	M16 x 108 5/8 x 4¼	241 9.50	308 12.13	51 2.00	3.5 7.7

¹ The allowable tubing end separation dimension shown is for system layout purposes only. Style 606-AS rigid couplings for copper are considered rigid connections and will not accommodate expansion or contraction of the piping system.

5.0 PERFORMANCE

Style 606-AS Rigid Coupling for Australian Standard Copper

The Style 606-AS coupling has been tested on Australian Standard AS 1432 Types B and D copper tubing to establish the pressure ratings shown in the table below.


Pipe		AS 1432 Type B		AS 1432 Type D	
Nominal Size DN inches	Actual Size mm inches	Maximum Joint Working Pressure ² kPa psi	Maximum Permissible End Load ² N lb	Maximum Joint Working Pressure ² kPa psi	Maximum Permissible End Load ² N lb
DN50 2	50.8 2.000	1790 260	3650 820	650 94	1290 290
DN65 2½	63.5 2.500	1450 210	4580 1030	650 94	2050 460
DN80 3	76.2 3.000	1620 235	7390 1660	650 94	2940 660
DN100 4	101.6 4.000	1210 176	9790 2200	650 94	5250 1180
DN125 5	127.0 5.000	970 141	12230 2750	650 94	8190 1840
DN150 6	152.4 6.000	1000 145	18450 4100	650 94	11790 2650
DN200 8	203.2 8.000	730 106	23710 5330	–	–







² Working Pressure and End Load are total, from all internal and external loads, based on Australian Standard AS 1432 copper tubing roll grooved in accordance with the Victaulic Groove Specifications for Australian Standard AS1432 Copper Tubing found in [publication 25.06](#).

NOTES

- WARNING: FOR ONE-TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.
- Performance ratings also apply to the Victaulic Series 608N-AS butterfly valve and Victaulic Australian Standard copper fittings connected to the indicated types of tubing.
- For use on other Australian Standard AS 1432 copper tubing types, contact Victaulic.


6.0 NOTIFICATIONS

 **WARNING**

- Read and understand all instructions before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Always verify that the piping system has been completely depressurized and drained immediately prior to installation, removal, adjustment, or maintenance of any Victaulic products.
- Wear safety glasses, hardhat, and foot protection.

Failure to follow these instructions could result in death or serious personal injury and property damage.

 **CAUTION**

- Copper roll sets shall be used to roll groove copper tubing. Always specify copper roll sets at the time of order.
- DO NOT use rolls intended for steel, stainless steel, aluminum, PVC, or CPVC pipe or rolls intended for other groove profiles.
- Tools must be equipped only with Victaulic rolls designed specifically for grooving copper tubing (color coded copper).
- Roll grooving tools VE272FS, VE270FSD, and VE268 can be used to roll groove AS 1432 Types B and D copper tubing from DN50 – DN200/2 – 8".
- VE226AC can be used to groove DN50–DN150/2 – 6" copper tubing.
- VE26AC allows in-place manual grooving of DN50 – DN150/2 – 6" copper tubing.

Failure to follow these instructions could damage the tool and cause product failure, resulting in property damage or personal injury.

7.0 REFERENCE MATERIALS

- [05.01: Victaulic Seal Selection Guide](#)
- [22.50: Victaulic QuickVic™ Rigid Coupling for Australian Standard Copper Style 607N-AS](#)
- [22.52: Australian Standard Copper Fittings](#)
- [22.53: Victaulic Butterfly Valve for Australian Standard Copper Series 608N-AS](#)
- [24.01: Victaulic Pipe Preparation Tools](#)
- [25.06: Victaulic Copper Tubing Roll Groove Specifications](#)
- [I-600: Victaulic Field Installation Handbook: Copper Connection Products](#)
- [I-ENDCAP: Victaulic End Cap Installation Safety Instructions](#)

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.

Warranty

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

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