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## Product Description:

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Double grooving procedures are essentially the same as for standard grooving. Victaulic provides a variety of tools for shop and field double grooving to our specifications.

Special double groove dimensions have been established for the Style 808 Duo-Lock series to provide full engagement of the double keys on each side. **These groove dimensions are intended for use ONLY with Schedule 80 or heavier square cut steel pipe, suitable for cut grooving only.**

For easy field double cut grooving, Victaulic offers two Vic-Groover® tools: VDG26GD for 6"/150 mm pipe and VG824 for 8 – 12"/200 – 300 mm pipe. For more information on these special tools, contact the Victaulic Tool Company. Both tools may be driven by available power sources (power mule, universal power/vise and others) set up to Victaulic specifications.

### Job/Owner

System No.	
Location	

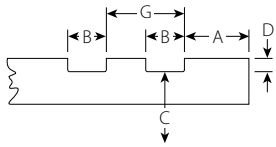
### Contractor

Submitted By	
Date	

### Engineer

Spec Section	
Paragraph	
Approved	
Date	

**Standard Double Cut Groove Specification  
for Style 808 Couplings:**



(1)	(2)			(3)	(4)	(5)	(6)		(7)	(8)
Dimensions Inches/millimeters										
Nominal Pipe Size	Pipe Outside Diameter			Gasket Seat A	Groove Sep. G	Groove Width B	Groove Diameter C		(Ref.) Trial Groove Depth D	Min. Bolt Torque
	inches mm	Basic	Tolerance +      -				Basic	Tol +0.000		
6 150	6.625 168.3	+0.063 +1.60	+0.031 +0.79	0.625 15.88	0.785 20.0	0.375 9.5	6.340 161.0	-0.022 -0.56	0.142 3.6	450 610.2
8 200	8.625 219.1	+0.063 +1.60	+0.031 +0.79	0.750 19.05	0.855 21.7	0.500 12.7	8.240 209.3	-0.022 -0.56	0.192 4.9	500 678.0
10 250	10.750 273.0	+0.063 +1.60	+0.031 +0.79	0.750 19.05	0.855 21.7	0.500 12.7	10.350 262.9	-0.022 -0.56	0.200 5.1	500 678.0
12 300	12.750 323.9	+0.063 +1.60	+0.031 +0.79	0.750 19.05	0.855 21.7	0.500 12.7	12.350 313.7	-0.022 -0.56	0.200 5.1	500 678.0

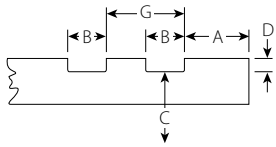
- (1) Nominal IPS pipe size.
- (2)<sup>1</sup> IPS outside diameter. The outside diameter of cut grooved pipe shall not vary more than the tolerance listed. For IPS pipe, the maximum allowable tolerance from square cut ends is 0.045" for 6", and 0.060" for sizes 8" and above measured from true square line.
- (3)<sup>1</sup> Gasket seat. The pipe surface shall be free from indentations and projections from the end of the pipe to the groove, to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease, and rust must be removed. Pipe must be square cut; beveled pipe must not be used.
- (4) Groove separation.
- (5)<sup>1</sup> Groove width. Bottom of groove to be free of loose dirt, chips, rust, and scale that may interfere with proper coupling assembly. Maximum permissible radius at bottom of groove is 0.015".
- (6) Groove diameter. The groove must be of uniform depth for the entire pipe circumference. Groove must be maintained within the "C" diameter tolerance listed.
- (7) Groove depth. For reference only. Groove must conform to the "C" dimension.
- (8) To achieve adequate tension on the bolts this is the minimum torque which must be applied.

**GROOVE MUST CONFORM TO THE GROOVE DIMENSIONS.**

**NOTE: PIPING SYSTEMS MUST ALWAYS BE DEPRESSURIZED AND DRAINED BEFORE ATTEMPTING DISASSEMBLY AND REMOVAL OF ANY VICTAULIC PIPING PRODUCTS.**

<sup>1</sup> Coatings applied to the interior surfaces, including bolt pad mating surfaces, of our bolted grooved and bolted plain end couplings should not exceed 0.010"/0.25 mm. Also, the coating thickness applied to the gasket seating surface and within the groove on the pipe exterior should not exceed 0.010"/0.25 mm.

**“ES” Endseal® Cut Groove Specifications  
for Style 808 Coupling:**



(1)	(2)			(3)	(4)	(5)	(6)		(7)	(8)
Dimensions Inches/millimeters										
Nominal Pipe Size inches mm	Pipe Outside Diameter			Gasket Seat A +0.010 -0.010	Groove Sep. G +0.005 -0.005	Groove Width B +0.010 -0.005	Groove Diameter C		(Ref.) Trial Groove Depth D	Min. Bolt Torque Lb. Ft. N • m
	Basic	Tolerance +      -					Basic	Tol +0.000		
6 150	6.625 168.3	+0.063 +1.60	+0.031 +0.79	0.605 15.4	0.785 20.0	0.375 9.5	6.340 161.0	-0.022 -0.56	0.142 3.6	450 610.2
8 200	8.625 219.1	+0.063 +1.60	+0.031 +0.79	0.714 18.1	0.855 21.7	0.500 12.7	8.240 209.3	-0.022 -0.56	0.192 4.9	500 678.0
10 250	10.750 273.0	+0.063 +1.60	+0.031 +0.79	0.714 18.1	0.855 21.7	0.500 12.7	10.350 262.9	-0.022 -0.56	0.200 5.1	500 678.0
12 300	12.750 323.9	+0.063 +1.60	+0.031 +0.79	0.714 18.1	0.855 21.7	0.500 12.7	12.350 313.7	-0.022 -0.56	0.200 5.1	500 678.0

- (1) Nominal IPS pipe size.
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- (3) Gasket seat. The pipe surface shall be free from indentations and projections from the end of the pipe to the groove, to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease, and rust must be removed. Pipe must be square cut; beveled pipe must not be used.
- (4) Groove separation.
- (5) Groove width. Bottom of groove to be free of loose dirt, chips, rust, and scale that may interfere with proper coupling assembly. Maximum permissible radius at bottom of groove is 0.015".
- (6) Groove diameter. The groove must be of uniform depth for the entire pipe circumference. Groove must be maintained within the "C" diameter tolerance listed.
- (7) Groove depth. For reference only. Groove must conform to the "C" dimension.
- (8) To achieve adequate tension on the bolts this is the minimum torque which must be applied.

**GROOVE MUST CONFORM TO THE GROOVE DIMENSIONS.**

**NOTE: PIPING SYSTEMS MUST ALWAYS BE DEPRESSURIZED AND DRAINED BEFORE ATTEMPTING DISASSEMBLY AND REMOVAL OF ANY VICTAULIC PIPING PRODUCTS.**

**Installation**

Reference should always be made to the [I-100 Victaulic Field Installation Handbook](#) for the product you are installing. Handbooks are included with each shipment of Victaulic products for 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.

**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.

**Trademarks**

Victaulic® is a registered trademark of Victaulic Company.