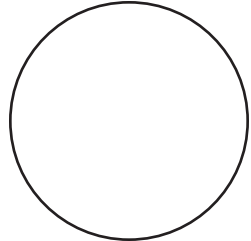


# Flexible Coupling for Joining "XL" Elbows to IPS Carbon Steel Pipe

STYLE XL77 FLEXIBLE COUPLING FOR USE WITH XL100 90° ELBOWS AND XL110 45° ELBOWS



**⚠ WARNING**

- Read and understand all instructions before attempting to install 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 during installation.

Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.

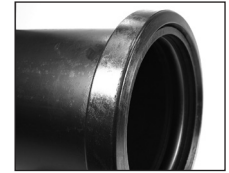
**1. CHECK PIPE END AND FITTING END:** The outside surfaces of the pipe and fitting, between the groove and the pipe or fitting end, must be smooth and free from indentations, projections (including weld seams), and roll marks to ensure a leak-tight seal. All oil, grease, loose paint, dirt, and cutting particles must be removed.

**NOTICE**

- The interior rubber lining of XL100 and XL110 Elbows is ¼ inch/6 mm thicker than the adjoining system.
- "XL" elbows **MUST** be installed only with Style "XL" Couplings.
- Style XL77 Coupling gaskets contain markings for the fitting side. It is important that the "FITTING" side of the gasket is positioned on the fitting (facing away from the pipe end) during assembly.
- Style XL77 Coupling housings contain markings for the fitting side and IPS (pipe) side. It is important that the "FITTING" side of each coupling housing faces toward the fitting during assembly.



**2. CHECK GASKET AND LUBRICATE:** Check the gasket to make sure it is suitable for the intended service. The color code identifies the gasket grade. Refer to Victaulic publication 05.01 in the G-100 General Catalog or the I-100 Field Installation Handbook for the color code chart. Apply a thin coat of Victaulic Lubricant or silicone lubricant to the gasket sealing lips and exterior.

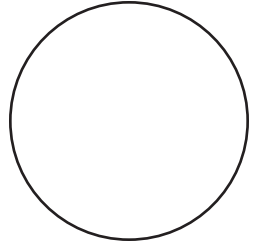


**3. POSITION GASKET:** For ease of installation, position the gasket over the pipe end with the "FITTING" mark facing away from the pipe end. Make sure the gasket does not overhang the pipe end.

**⚠ WARNING**

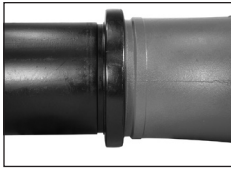
- A compatible lubricant must be used to prevent the gasket from pinching/tearing during installation.

Failure to follow this instruction could cause joint leakage, resulting in property damage.

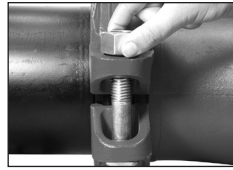


# Flexible Coupling for Joining "XL" Elbows to IPS Carbon Steel Pipe

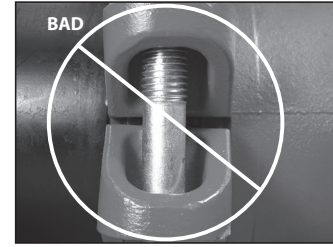
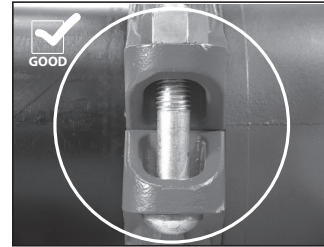
STYLE XL77 FLEXIBLE COUPLING FOR USE WITH XL100 90° ELBOWS AND XL110 45° ELBOWS



**4. JOIN PIPE END AND FITTING:** Align and bring the pipe end together with the fitting. Slide the gasket into position and center it between the groove in the pipe end and the fitting. Make sure no portion of the gasket extends into the groove in either the pipe end or the fitting.



**6. INSTALL BOLTS/NUTS:** Install the bolts, and thread a nut finger-tight onto each bolt. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.



**8.** Visually inspect the bolt pads at each joint to ensure metal-to-metal contact is achieved.

**CAUTION**

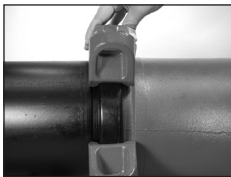
- Make sure the gasket does not become rolled or pinched while installing the housings.

Failure to follow this instruction could cause damage to the gasket, resulting in joint leakage and property damage.

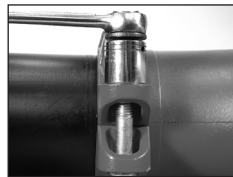
**WARNING**

- Nuts must be tightened evenly by alternating sides until metal-to-metal contact occurs at the bolt pads.
- Keep hands away from coupling openings during tightening.

Failure to follow these instructions could cause joint failure, serious personal injury, and property damage.



**5. INSTALL HOUSINGS:** Install the housings over the gasket. Make sure the "FITTING" marking on each housing faces toward the fitting. Make sure the housings' keys engage the grooves completely on both the pipe end and the fitting.



**7. TIGHTEN NUTS:** Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. Make sure the housings' keys engage the grooves completely. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching.

**STYLE XL77 HELPFUL INFORMATION**

Size	Nut Size	Socket Size
Nominal Size inches/mm	inches/Metric	inches/Metric
3 80	1/2 M12	7/8 22
4 100	5/8 M16	1 1/8 27
5 125	3/4 M20	1 1/4 32
6 150	3/4 M20	1 1/4 32

Size	Nut Size	Socket Size
Nominal Size inches/mm	inches/Metric	inches/Metric
8 200	7/8 M22	1 7/8 22
10 250	1 M24	1 5/8 41
12 300	1 M24	1 5/8 41