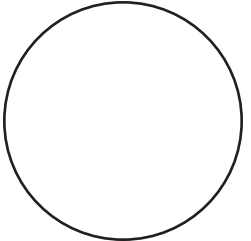
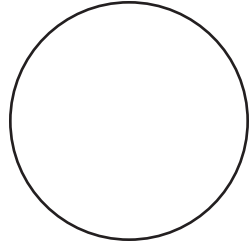


# Flexible Coupling for Joining "XL" Elbows to "XL" Elbows

STYLE XL79 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.

## NOTICE

- The interior rubber lining of XL100 and XL110 Elbows is ¼ inch/6 mm thicker than the adjoining system.
- Style XL79 Couplings must be used ONLY to join two "XL" elbows.

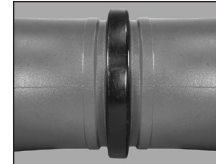
**1. CHECK FITTING ENDS:** The outside surfaces of the fittings, between the groove and the fitting end, must be smooth and free from indentations and projections to ensure a leak-tight seal. All oil, grease, loose paint, and dirt must be removed.



**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.

## ⚠ 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.

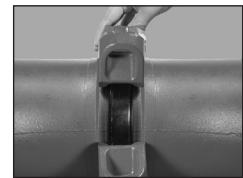


**3. POSITION GASKET:** Position the gasket over the pipe end. Make sure the gasket does not overhang the pipe end.

**3a. JOIN FITTING ENDS:** Align and bring the two fitting ends together. Slide the gasket into position and center it between the groove in each fitting. Make sure no portion of the gasket extends into the groove in either fitting end.

## ⚠ 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.

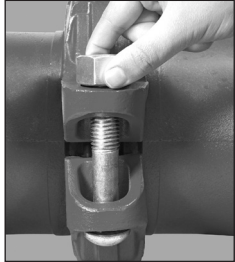
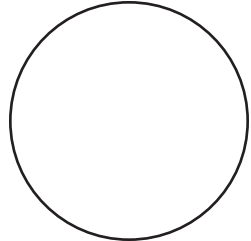


**4. INSTALL HOUSINGS:** Install the housings over the gasket. Make sure the housings' keys engage the grooves completely on both fitting ends.

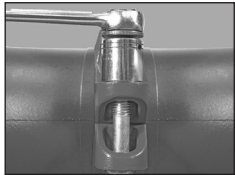


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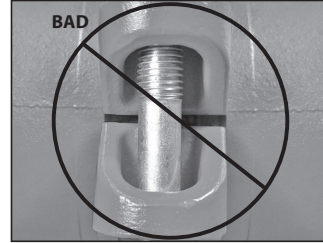
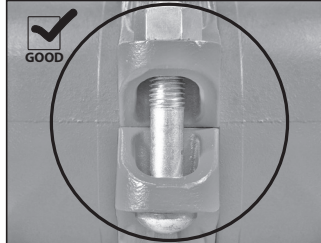
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**5. INSTALL BOLTS/NUTS:** Install the bolts, and thread a nut finger-tight onto each bolt. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt hole.



**6. 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.



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

**⚠ 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.

### STYLE XL79 HELPFUL INFORMATION

Size	Nut Size	Socket Size
Nominal Size inches/mm	inches/ Metric	inches/ Metric
3	1/2	7/8
80	M12	22
4	3/8	1 1/16
100	M16	27
5	3/4	1 1/4
125	M20	32
6	3/4	1 1/4
150	M20	32
8	7/8	1 7/16
200	M22	22
10	1	1 1/2
250	M24	41
12	1	1 1/2
300	M24	41

