

# Victaulic® Rigid Coupling

## Style 89



### 1.0 PRODUCT DESCRIPTION

#### Available Sizes

- 2 – 12"/DN50 – DN300

#### Pipe Material

- Stainless steel
  - Austenitic: 304, 316
  - Super Austenitic: 254SMO, AL6XN
  - Duplex: 2205
  - Super Duplex: 2507, Zeron 100

#### Maximum Working Pressure

- Accommodates pressures ranging from full vacuum (29.9 in Hg/760 mm Hg) up to 1200 psi/8274 kPa
- Working pressure dependent on wall thickness and material and size of pipe

#### Operating Temperature

- Dependent on gasket selection from section 3.0.

#### Function

- Provides a rigid pipe joint designed to restrict axial or angular movement. Contact Victaulic for information on torsional resistance.
- Joins standard roll grooved and cut grooved pipe, as well as grooved fittings, valves and accessories

#### NOTE

- Applications that require NSF 61-approved products should specify the Victaulic Rigid Coupling Style 889 ([publication 17.29](#)).

### 2.0 CERTIFICATION/LISTINGS



Product designed and manufactured under the Victaulic Quality Management System, as certified by LPCB in accordance with ISO-9001:2015.

See [publication 10.01](#) for Fire Protection Certifications/Listings Reference Guide.

**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:**

Standard: Hot dipped galvanized per ASTM A123.

Optional: Contact Victaulic with your requirements for other coatings.

**Gasket: (specify choice)<sup>1</sup>**

**Grade “E” EPDM**

EPDM (Green color code). Temperature range –30°F to +230°F/–34°C to +110°C. May be specified for hot water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.

**Grade “EF” EPDM<sup>2</sup>**

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 W270, UBA Elastomer Guideline, ÖVGW, SVGW, and French ACS 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 “T” Nitrile**

Nitrile (Orange color code). Temperature range –20°F to +180°F/–29°C to +82°C. May be specified for oil related services, including air with oil vapor, this gasket may be specified for temperatures rated up to +180°F/+82°C. For water related services, this gasket may be specified for temperatures rated up to +150°F/+66°C. For oil free, dry air services, this gasket may be specified for temperatures rated up to +140°F/+60°C. NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.

**Grade “O” Fluoroelastomer**

Fluoroelastomer (Blue color code). Temperature range +20°F to + 300°F/–7°C to +149°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.

**Grade “A” White Nitrile**

White nitrile (White gasket). Temperature range +20°F to +180°F/–7°C to +82 °C. No carbon black content. Meets FDA requirements. Conforms to CFR Title 21 Part 177.2600. Not compatible for hot water services over +150°F/+66°C or for hot, dry air over +140°F/+60°C. NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES.

**Others**

For alternate gasket selection, reference [publication 05.01](#): Victaulic Seal Selection Guide.

<sup>1</sup> 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.

<sup>2</sup> Available exclusively in Europe.

**Bolts/Nuts: (specify choice)<sup>3</sup>**

Standard: Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449

Carbon steel heavy hex nuts meeting the mechanical property requirements of ASTM A563 Grade B. Track bolts and heavy hex nuts are zinc electroplated per ASTM B633 FE/ZN5, finish Type III (imperial) or Type II (metric).

Optional:

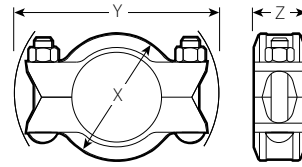
2 – 6": Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM F593, Group 2 (316 stainless steel), condition CW. Stainless steel heavy nuts meeting the mechanical property requirements of ASTM F594, Group 2 (316 stainless steel), condition CW. Bolts and nuts include galling reducing coating.

8 – 12": Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM A193 Grade B8M, Class 2 (316 stainless steel). Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM A194 Grade 8M (316 stainless steel), condition CW, with galling reducing coating.

<sup>3</sup> Optional bolts/nuts in imperial sizes only.

## 4.0 DIMENSIONS

### Style 89 Rigid Coupling



Typical for all sizes

Size		Pipe End Separation <sup>4</sup>	Bolt/Nut <sup>5</sup>		Nut Torque ft-lbs N·m	Dimensions			Weight
Nominal inches DN	Actual Outside Diameter inches mm	Allowable inches mm	Qty.	Size inches		X inches mm	Y inches mm	Z inches mm	Approximate (Each) lb kg
2 DN50	2.375 60.3	0.14 3.6	2	5/8 x 2 3/4	60 – 90 80 – 120	3.50 89	6.68 168	2.00 51	3.1 1.4
2 1/2	2.875 73.0	0.14 3.6	2	5/8 x 3 1/2	60 – 90 80 – 120	4.13 105	7.13 181	2.00 51	4.0 1.8
DN65	3.000 76.1	0.14 3.6	2	5/8 x 3 1/2	60 – 90 80 – 120	4.13 105	7.25 184	2.00 51	4.1 1.9
3 DN80	3.500 88.9	0.14 3.6	2	5/8 x 3 1/2	60 – 90 80 – 120	4.75 121	7.75 197	2.00 51	4.3 2.0
4 DN100	4.500 114.3	0.25 6.4	2	3/4 x 4 1/4	85 – 125 115 – 170	6.00 152	9.63 245	2.13 54	7.5 3.4
DN125 <sup>2</sup>	5.500 139.7	0.25 6.4	2	3/4 x 4 1/4	85 – 125 115 – 170	7.13 181	10.63 270	2.38 60	12.5 5.7
5	5.563 141.3	0.25 6.4	2	3/4 x 4 1/4	85 – 125 115 – 170	7.13 181	10.63 270	2.38 60	12.5 5.7
	6.500 165.1	0.25 6.4	2	7/8 x 5 1/2	175 – 250 237 – 339	8.63 219	12.38 314	2.38 60	15.8 7.2
6 DN150	6.625 168.3	0.25 6.4	2	7/8 x 5 1/2	175 – 250 237 – 339	8.63 219	12.68 321	2.50 64	16.0 7.3
	8.515 216.3	0.25 6.4	2	1 x 5 1/2	200 – 300 271 – 407	11.00 279	15.25 387	2.63 67	25.2 11.4
8 DN200	8.625 219.1	0.25 6.4	2	1 x 5 1/2	500 680	11.00 279	15.25 387	2.75 70	26.1 11.8
	10.528 267.4	0.25 6.4	2	1 x 6 1/2	250 – 350 339 – 475	13.38 340	17.00 432	2.75 70	32.5 14.7
10 DN250	10.750 273.0	0.25 6.4	2	1 x 6 1/2	500 680	13.50 343	17.25 438	2.75 70	32.8 14.9
	12.539 318.5	0.25 6.4	2	1 x 6 1/2	250 – 350 339 – 475	15.63 397	19.63 499	2.88 73	42.0 19.1
12 DN300	12.750 323.9	0.25 6.4	2	1 x 6 1/2	500 680	15.63 397	19.63 499	2.88 73	46.0 20.9

<sup>2</sup> Available exclusively in Europe.

<sup>4</sup> For field installation only. Style 89 couplings when sufficiently pressurized, will allow pipe ends to separate to maximum point shown before joint acts in a fully restrained manner. Style 89 rigid couplings are considered rigid connections and will not accommodate expansion/contraction or angular movement of the piping system. Contact Victaulic for torsional resistance information.

<sup>5</sup> Metric thread size bolts are available (color coded gold) for all coupling sizes upon request. Contact Victaulic for details.

## 5.0 PERFORMANCE

### Performance on ANSI Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling				
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness		Groove Type	Maximum	
		inches mm	ANSI Schedule Number		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
2 DN50	2.375 60.3	0.217 5.5	80S	C	750 5171	3323 14780
		0.154 3.9	40S	Std/C	750 5171	3323 14780
		0.110 2.8	10S	RX	500 3447	2215 9853
		0.067 1.7	5S	RX	325 2241	1440 6405
2½	2.875 73.0	0.276 7.0	80S	C	750 5171	4869 21658
		0.205 5.2	40S	Std/C	750 5171	4869 21658
		0.122 3.1	10S	RX	500 3447	3246 14438
		0.083 2.1	5S	RX	325 2241	2110 9386
3 DN80	3.500 88.9	0.299 7.6	80S	C	750 5171	7216 32098
		0.217 5.5	40S	Std/C	750 5171	7216 32098
		0.122 3.1	10S	RX	500 3447	4814 21415
		0.083 2.1	5S	RX	325 2241	3127 13910
4 DN100	4.500 114.3	0.339 8.6	80S	C	750 5171	11928 53059
		0.236 6.0	40S	Std/C	750 5171	11928 53059
		0.122 3.1	10S	RX	400 2758	6362 28298
		0.083 2.1	5S	RX	250 1724	3979 17700

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

#### NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

## 5.0 PERFORMANCE (CONTINUED)

### Performance on ANSI Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling				
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness		Groove Type	Maximum	
		inches mm	ANSI Schedule Number		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
5	5.563 141.3	0.258 6.6	40S	Std/C	750 5171	18229 81087
		0.134 3.4	10S	RX	400 2758	7280 32381
		0.109 2.8	5S	RX	275 1896	6684 29732
6 DN150	6.625 168.3	0.280 7.1	40S	Std/C	750 5171	25854 115003
		0.134 3.4	10S	RX	400 2758	10324 45925
		0.110 2.8	5S	RX	250 1724	8618 38334
8 DN200	8.625 219.1	0.323 8.2	40S	Std/C	600 4137	35049 155903
		0.188 4.8	N/A	RX	400 2758	21180 94213
		0.148 3.8	10S	RX	300 2068	17499 77838
		0.110 2.8	5S	RX	200 1379	11686 51980
10 DN250	10.750 273.0	0.366 9.3	40S	Std/C	600 4137	54446 242188
		0.165 4.2	10S	RX	300 2068	27184 120918
		0.134 3.4	5S	RX	250 1724	22691 100933
12 DN300	12.750 323.9	0.374 9.5	40S	Std/C	600 4137	76590 340687
		0.181 4.7	10S	RX	300 2068	38239 170097
		0.156 4.0	5S	RX	200 1379	25536 113590

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

#### NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

## 5.0 PERFORMANCE (CONTINUED)

### Performance on ANSI Wall Thickness (Super Austenitic, Duplex, and Super Duplex Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling				
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness		Groove Type	Maximum	
		inches mm	ANSI Schedule Number		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
2 DN50	2.375 60.3	0.154 3.9	40S	C	1200 8274	5320 23676
2½	2.875 73.0	0.203 5.2	40S	C	1200 8274	7800 34712
3 DN80	3.500 88.9	0.216 5.5	40S	C	1200 8274	11560 51444
4 DN100	4.500 114.3	0.237 6.0	40S	C	1200 8274	19100 84996
5	5.563 141.3	0.237 6.0	40S	C	1200 8274	28520 126916
6 DN150	6.625 168.3	0.237 6.0	40S	C	1200 8274	41360 184060
8 DN200	8.625 219.1	0.323 8.2	40S	C	1200 8274	70100 311940
10 DN250	10.750 273.0	0.366 9.3	40S	C	1200 8274	108900 484600
12 DN300	12.750 323.9	0.374 9.5	40S	C	1200 8274	153200 681740

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, cut grooved in accordance with Victaulic specifications.

#### NOTES

- C = Cut groove
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling			
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		inches mm		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
2 DN50	2.375 60.3	0.220 5.6	C	750 5171	3323 14780
		0.157 4.0	Std/C	750 5171	3323 14780
		0.142 3.6	Std	675 4654	2990 13302
		0.126 3.2	Std	600 4137	2658 11824
		0.114 2.9	Std	525 3620	2326 10346
		0.102 2.6	RX	475 3275	2104 9360
		0.091 2.3	RX	425 2930	1883 8375
		0.079 2.0	RX	375 2586	1661 7390
		0.063 1.6	RX	325 2241	1440 6405
		DN65	3.000 76.1	0.280 7.1	C
0.252 6.4	C			750 5171	5301 23582
0.197 5.0	Std/C			650 4482	4595 20438
0.157 4.0	Std			575 3964	4064 18079
0.142 3.6	Std			550 3792	3888 17293
0.122 3.1	Std			500 3447	3537 15733
0.114 2.9	RX			475 3275	3358 14935
0.102 2.6	RX			400 2758	2827 12577
0.091 2.3	RX			350 2413	2474 11005
0.083 2.1	RX			325 2241	2297 10220
0.079 2.0	RX			325 2241	2297 10220

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

## 5.1 PERFORMANCE (CONTINUED)

### Performance on ISO Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling			
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		inches mm		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
3 DN80	3.500 88.9	0.315 8.0	C	750 5171	7216 32098
		0.220 5.6	Std/C	750 5171	7216 32098
		0.157 4.0	Std	600 4137	5773 25678
		0.142 3.6	Std	550 3792	5292 23538
		0.126 3.2	RX	500 3447	4811 21398
		0.114 2.9	RX	475 3275	4570 20328
		0.102 2.6	RX	400 2758	3848 17119
		0.091 2.3	RX	350 2413	3367 14979
		0.079 2.0	RX	325 2241	3127 13910
		4 DN100	4.500 114.3	0.346 8.8	C
0.248 6.3	C			750 5171	11928 53059
0.177 4.5	Std			575 3964	9145 40679
0.142 3.6	Std			650 4482	10338 45985
0.114 2.9	RX			375 2586	5964 26530
0.102 2.6	RX			325 2241	5161 22958
0.079 2.0	RX			232 1600	3691 16417

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

#### NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.



5.1 PERFORMANCE (CONTINUED)

Performance on ISO Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling			
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		inches mm		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
DN125 <sup>2</sup>	5.500 139.7	0.394 10.0	C	750 5171	17819 79261
		0.280 7.1	C	750 5171	17819 79261
		0.260 6.6	Std	750 5171	17819 79261
		0.260 6.6	C	750 5171	17819 79261
		0.248 6.3	Std/C	700 4826	16631 73977
		0.220 5.6	Std/C	625 4309	14255 63409
		0.197 5.0	Std	550 3792	12474 55487
		0.157 4.0	Std	450 3103	8909 39631
		0.134 3.4	RX	400 2758	7280 32381
		0.126 3.2	RX	350 2413	7127 31704
		0.118 3.0	RX	300 2068	6534 29062
		0.110 2.8	RX	275 1896	6534 29062
		0.102 2.6	RX	250 1724	5940 26420
		0.079 2.0	RX	232 1600	5513 24525

<sup>2</sup> Available exclusively in Europe.

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

5.1 PERFORMANCE (CONTINUED)

Performance on ISO Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling			
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		inches mm		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
6 DN150	6.625 168.3	0.433 11.0	C	750 5171	25854 115003
		0.280 7.1	Std	750 5171	25854 115003
		0.280 7.1	C	750 5171	25854 115003
		0.197 5.0	Std	550 3792	17236 76668
		0.177 4.5	Std	500 3447	15512 69002
		0.157 4.0	Std	450 3102	12927 57501
		0.126 3.2	RX	350 2413	9480 42168
		0.118 3.0	RX	300 2068	9480 42168
		0.102 2.6	RX	232 1600	7999 35583
		0.079 2.0	RX	232 1600	7997 35574
		8 DN200	8.625 219.1	0.492 12.5	C
0.315 8.0	Std/C			575 3964	33595 149438
0.256 6.5	Std/C			500 3447	27752 123449
0.248 6.3	Std/C			500 3447	26292 116951
0.197 5.0	Std			425 2930	21910 97459
0.157 4.0	Std			325 2241	18989 84465
0.142 3.6	RX			275 1896	16067 71470
0.126 3.2	RX			250 1724	14607 64973
0.118 3.0	RX			225 1551	13146 58476
0.102 2.6	RX			175 1207	10225 45481
0.079 2.0	RX			150 1034	8746 38984

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

NOTES

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- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

## 5.1 PERFORMANCE (CONTINUED)

### Performance on ISO Wall Thickness (Austenitic Pipe Materials)

Pipe Diameter		Style 89 Rigid Coupling			
Nominal Size inches DN	Actual Outside Diameter inches mm	Pipe Wall Thickness	Groove Type	Maximum	
		inches mm		Working Pressure <sup>6</sup> psi kPa	End Load <sup>6</sup> lb N
10 DN250	10.750 273.0	0.559 14.2	C	600 4137	54446 242188
		0.492 12.5	C	600 4137	54446 242188
		0.394 10.0	C	600 4137	54446 242188
		0.248 6.3	Std/C	450 3103	38574 171585
		0.157 4.0	RX	300 2068	27184 120918
		0.142 3.6	RX	250 1724	22691 100933
		0.126 3.2	RX	232 1600	21062 93690
		0.102 2.6	RX	N/R	
		0.079 2.0	RX		
		12 DN300	12.750 323.8	0.492 12.5	C
0.394 10.0	C			600 4137	76590 340687
0.280 7.1	Std/C			450 3103	57454 255568
0.197 5.0	RX			325 2241	41495 184577
0.177 4.5	RX			300 2068	38739 170097
0.157 4.0	RX			200 1379	25536 113590
0.126 3.2	RX			N/R	
0.102 2.6	RX				

<sup>6</sup> Working Pressure and End Load are total, from all internal and external loads, roll or cut grooved in accordance with Victaulic specifications. Roll grooving shall use Victaulic roll sets.

#### NOTES

- C = Cut groove
- Std = Standard roll set marked with the prefix "R"
- RX = Roll set for light wall stainless steel pipe marked with the prefix "RX"
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

## 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 could result in death or serious personal injury and property damage.

### WARNING

- Victaulic RX roll sets must be used when grooving light-wall/thin-wall stainless steel pipe for use with Victaulic Couplings.

Failure to use Victaulic RX roll sets when grooving light-wall/thin-wall stainless steel pipe may cause joint failure, resulting in serious personal injury and/or property damage.

### NOTICE

- Victaulic RX grooving rolls must be ordered separately. They are identified by a silver color and the designation RX on the front of the roll sets.

- See [publication 24.01](#): Pipe Preparation Tool Specifications for more information pertaining to tools.

## 7.0 REFERENCE MATERIALS

[02.06: Victaulic Potable Water Approvals ANSI/NSF](#)

[05.01: Victaulic Seal Selection Guide](#)

[10.01: Victaulic Certification Reference Guide](#)

[17.01: Victaulic Stainless Steel Pipe End Preparation](#)

[24.01: Victaulic Pipe Preparation Tool Specifications](#)

[26.01: Victaulic Design Data](#)

[29.01: Victaulic Terms and Conditions of Sale](#)

[I-100: Victaulic Field Installation Handbook](#)

[I-ENDCAP: Victaulic End Cap Installation 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, 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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