

# Style 808 High Pressure Coupling



## WARNING

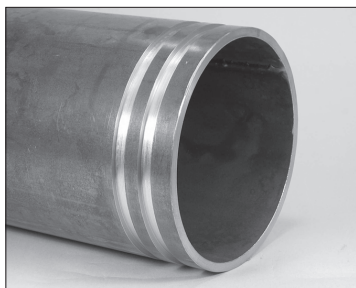


- Read and understand all instructions before attempting to install any Victaulic products.
  - Confirm that any equipment, branch lines, or sections of piping that may have been isolated for/during testing or due to valve closures/positioning are identified, depressurized, and drained immediately prior 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

- A thin coat of a compatible lubricant shall be applied to the gasket sealing lips and exterior to help prevent pinching, rolling, or tearing during installation.
  - DO NOT use excessive lubricant.
- Failure to use a compatible lubricant may cause gasket damage, resulting in joint leakage and property damage.

## INSTALLATION ON STANDARD OR ENDSEAL™ DOUBLE-CUT-GROOVED PIPE



**1. CHECK PIPE ENDS:** The outside surface of the pipe, between the groove and the pipe ends, shall be generally free from indentations, projections, weld seam anomalies, and roll marks to ensure a leak-tight seal. All oil, grease, loose paint, dirt, and cutting particles shall be removed.

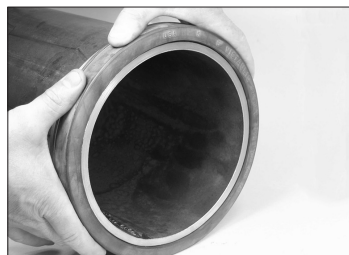
For proper installation of **standard** gaskets, the pipes' outside diameter ("OD") and groove dimensions shall be within the tolerances published in current Victaulic Standard Double Cut Groove specifications, located in publication 25.04, which can be downloaded at [victaulic.com](http://victaulic.com).

For proper installation of **EndSeal™** gaskets, the pipes' outside diameter ("OD") and groove dimensions shall be within the tolerances published in current Victaulic "ES" EndSeal™ Cut Groove specifications, located in publication 25.04, which can be downloaded at [victaulic.com](http://victaulic.com).

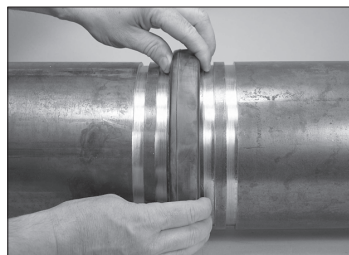
**2. CHECK GASKET:** Check the gasket to verify that it is suitable for the intended service. The color code identifies the material grade. Refer to Victaulic publication 05.01 for the color code chart, which can be downloaded at [victaulic.com](http://victaulic.com).



**3. LUBRICATE GASKET:** Apply a thin coat of compatible lubricant to the gasket sealing lips and exterior.



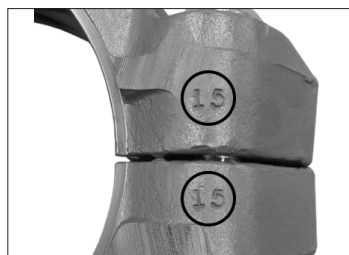
**4a. POSITION STANDARD GASKET:** Position the gasket over the pipe end. Verify that the gasket does not overhang the pipe end to prevent pinching, cutting, or rolling the gasket.



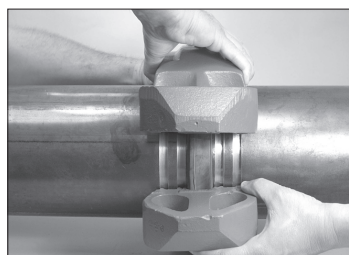
**4b. POSITION ENDSEAL™ GASKET:** Insert the grooved pipe end into the gasket until it contacts the center leg of the gasket.

**5a. JOIN PIPE ENDS WHEN USING STANDARD GASKETS:** Align and bring the two pipe ends together. Slide the gasket into position and center it between the groove in each pipe end. Verify that no portion of the gasket extends into the groove in either pipe end.

**5b. JOIN PIPE ENDS WHEN USING ENDSEAL™ GASKETS:** Align and bring the two pipe ends together. Insert the other pipe end into the gasket until it contacts the center leg of the gasket. Verify that no portion of the gasket extends into the groove in either pipe end.



**6. MATCH HOUSINGS:** The housings are marked with a number/letter combination on each bolt pad. During installation, the housings' bolt pads shall be mated so that the same number/letter combination is matched.



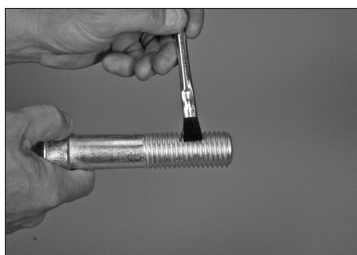
**7. INSTALL HOUSINGS:** Install the housings over the gasket. Verify that the housings' keys engage each groove completely on both pipe ends.

# Style 808 High Pressure Coupling

## CAUTION

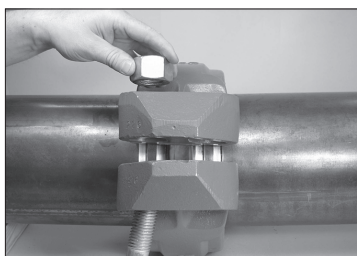
- Verify that the gasket does not become rolled or pinched while installing the housings.

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



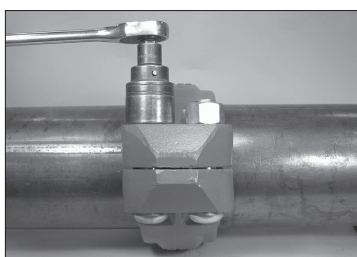
### 8. LUBRICATE BOLT

**THREADS:** Lubricate the bolt threads with a thin coat of compatible lubricant.

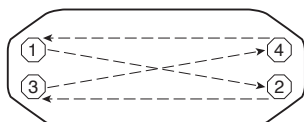


### 9. INSTALL BOLTS AND

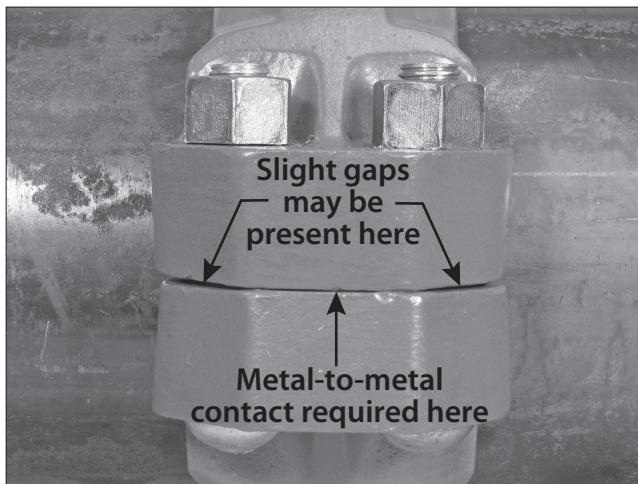
**NUTS:** Install the bolts, and thread a nut finger-tight onto each bolt. Verify that the oval neck of each bolt seats properly in the bolt hole.



**10. TIGHTEN NUTS:** Tighten all nuts evenly by alternating sides (follow the sequence shown to the left). Verify that the housings' keys engage each groove completely on both pipe ends. Continue to tighten the nuts evenly until metal-to-metal contact **AND** the required torque value are achieved at each nut. Refer to the "Style 808 Torque Requirement" table to the right.



**NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching. The use of a torque wrench is strongly recommended for proper assembly of Style 808 Couplings. If anything other than a torque wrench is used, the wrench handle must be long enough to permit effective tightening.



**11. INSPECT BOLT PADS:** Before pressurizing the system, inspect the bolt pads at each joint to ensure proper assembly is achieved.

### STYLE 808 TORQUE REQUIREMENT

Size		Torque Requirement
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	ft-lbs/ N•m
6	6.625 168.3	450 610
8	8.625 219.1	500 678
10	10.750 273.0	500 678
12	12.750 323.9	600 813

### STYLE 808 HELPFUL INFORMATION

Size		Nut Size	Socket Size
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	inches/ Metric	inches/ mm
6	6.625 168.3	1 M24	1 5/8 41
8	8.625 219.1	1 1/8 M27	1 13/16 46
10	10.750 273.0	1 1/8 M27	1 13/16 46
12	12.750 323.9	1 1/4 M30	2 50