

# Style 926 Mechanical-T Spigot Outlet



**⚠ 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.

Failure to follow these instructions could result in death or serious personal injury and property damage.

The following procedures are designed as a guide for proper assembly of the Victaulic Style 926 Mechanical-T Spigot Outlet. Request 11.07 for additional information.

Maximum service life is dependent upon proper gasket selection and installation. Be sure to note the gasket grade being supplied, and make certain that it is suited for the intended service. The following chart provides general service recommendations for this standard Victaulic gasket. For more detailed information, consult the Victaulic Seal Selection Guide (05.01) or call Victaulic.

Grade	Temp. Range	Compound	Color Code	Service Recommendations
<b>E</b>	-30°F to +230°F (-34°C to +110°C)	EPDM	Green Stripe	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. UL Classified in accordance with ANSI/NSF 61 for cold +73°F/+23°C and hot +180°F/+82°C potable water service and ANSI/NSF 372.  NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.
<b>T</b>	-20°F to +180°F (-29°C to +82°C)	Nitrile	Orange Stripe	May be specified for petroleum products, hydrocarbons, air with oil vapors, vegetable and mineral oils within the specified temperature range; not compatible for hot dry air over +140°F/+60°C or water over +150°F/+66°C.  NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.

\*Refer to the VICTAULIC SEAL SELECTION GUIDE (05.01) for specific service recommendations. Services listed are Gasket Service Recommendations only. It should be noted that there are services for which these gaskets are **not** recommended. Reference should always be made to the latest Victaulic Seal Selection Guide for specific gasket service recommendations and for a listing of services that are not recommended.

## PIPE PREPARATION

To prepare the pipe for Victaulic products, a hole must first be cut into the pipe. Proper preparation of the hole is essential for sealing and performance. Ensure that the correct hole saw is used. Refer to the "Helpful Information" table for the proper hole size.

**⚠ WARNING**

- When cutting a hole for the Mechanical-T Spigot Outlet, **DO NOT** cut over a previously fused seam or welded joint. The hole must be cut in a location that has not previously been altered or repaired.

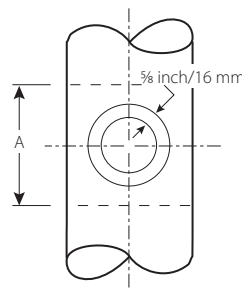
Failure to follow these instructions could cause assembly failure, resulting in death or serious personal injury and property damage.

Holes **MUST** be drilled perpendicular to the centerline of the pipe. Improperly cut holes may prevent complete insertion of the locating collar and interfere with proper sealing.

**NOTICE**

- A Milwaukee ½" Hole-Hawg® Drill 300/1200 RPM or similar hole saw is recommended for proper hole preparation.
- For a 4" outlet in HDPE pipe, the Miyanaga America† 115 mm Galvawood or similar core bit is recommended.
- For a 6" outlet in HDPE pipe, the Miyanaga America 170 mm HDPE or similar core bit is recommended.

Ensure that the pipe surface within 5/8 inch/16 mm of the hole is clean, smooth, and free from indentations and/or projections that could affect the sealing of the o-ring. Refer to the drawing below.



Exaggerated for clarity

Remove any burrs and sharp edges from the hole. Leftover burrs or sharp edges could affect the assembly, seating of the locating collar, flow from the spigot, or sealing of the o-ring.

The pipe around the entire circumference within the "A" dimension must be free of any dirt, scale, or projection that might prevent the strap or outlet from seating fully on the pipe.

## STYLE 926 HELPFUL INFORMATION

Nominal Outlet Size inches/mm	Hole Dimensions inches/mm		Surface Preparation "A" Dimension
	Minimum Hole Diameter/ Hole Saw Size	Maximum Hole Diameter/ Hole Saw Size	inches/ mm
4 100	4 ½ 115	4 ¾ 117	8 203
6 150	6 ¾ 168	6 ¾ 171	10 254

© Milwaukee Hole-Hawg is a registered trademark of Milwaukee Tool  
 † Miyanaga America is a trademark of MIYANAGA Co., Ltd.

## INSTALLATION



**1. INSERT CROSSBAR:** Insert a crossbar into the retaining bracket on both sides of the strap. The flat side of the crossbar should face away from the open end of the strap, as pointed out in the profile view below.

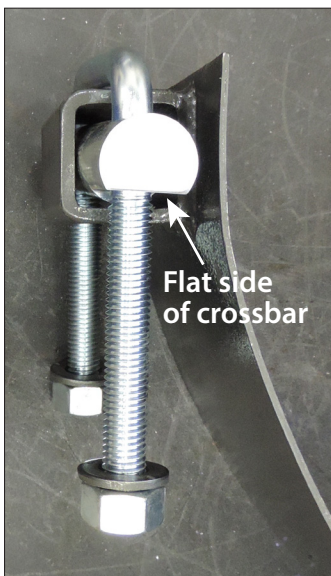


**2. INSERT U-BOLT:** Insert a U-bolt into the crossbar on both sides of the strap. The threaded ends should protrude through the flat sides of the crossbars.



**3. LOOSELY THREAD NUTS:** Place one washer over each end of the U-bolts, then loosely thread a nut over each washer. The nuts should only be tight enough to hold the assembly in place.

**NOTE:** Over-tightening may prevent ease of assembly when placing U-bolts over the housing.



### CAUTION

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

Failure to follow these instructions will cause o-ring degradation, resulting in joint leakage and property damage.

**4. LUBRICATE GROOVE:** Apply a thin coat of Victaulic Lubricant or silicone lubricant only to the o-ring groove on the underside of the spigot housing.



**5. INSTALL O-RING:** Press the o-ring into the groove on the underside of the spigot housing. Do NOT place the o-ring on the pipe and then attempt to push the locating collar through it. This may push the o-ring into the hole, and will prevent proper sealing.



**6. PLACE HOUSING:** Place the housing by inserting the locating collar into the hole in the pipe. Ensure that the o-ring remains in the groove on the housing and does not fall into the hole.



**7. PLACE STRAP:** Push one end of the strap underneath the pipe and hook one U-bolt over the retaining gusset of the spigot housing.



**8. ATTACH STRAP:** On the opposite side of the pipe, pull the second U-bolt up and hook it over the second retaining gusset of the spigot housing.

**NOTE:** If there is inadequate length to perform this step, loosen the nuts on the U-bolts to lengthen the assembly.



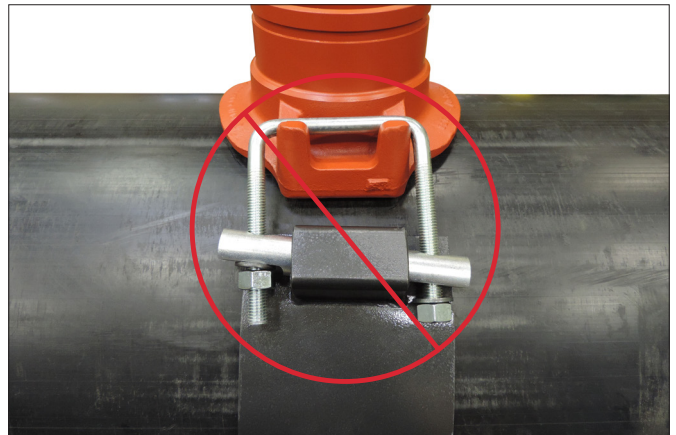
**9. POSITION FOR TIGHTENING:** Position the U-bolts, crossbars, and strap so that a deep well socket can fit around all nuts for tightening.

**10. TIGHTEN HARDWARE:** Using a 1 1/16-inch sized deep-well socket, tighten both nuts on each U-bolt evenly by alternating between them. Drive one nut no more than 1/4 inch/6.4 mm beyond the location of the second nut on a given U bolt. Torque the nuts to 75–100 ft-lbs/ 102–136 N•m, with even spacing between the housing and the strap on both sides.

**NOTE:** Thin-wall HDPE may not allow nut torque value to be achieved. In this case, tightening is complete when 360° of contact between the pipe and housing is achieved.



**NOTE:** Over-tightening one nut can cause damage to the threads and may cause the assembly to shift position, as shown below.



**⚠ WARNING**

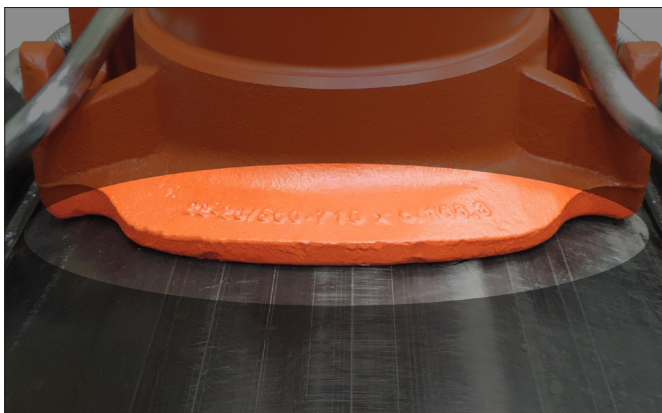
- **DO NOT** exceed 100 ft-lbs/136 N•m of torque on the nuts. Increased bolt torque will not improve sealing and may cause product failure. Failure to torque nuts properly could cause product failure, resulting in serious personal injury and/or property damage.

## Style 926 Mechanical-T Spigot Outlet

**11. INSPECT HARDWARE:** Ensure that the spigot housing is an equal distance from the strap on each side. If the strap hardware does not grip the housing evenly from both sides, the assembly may be pulled out of alignment, causing the housing to angle into the hole and creating improper compression of the o-ring.



**12. INSPECT ASSEMBLY:** The spigot housing must make full contact with the surface of the pipe under the spigot. Typical installation torque is approximately 80 ft-lbs/108 N•m on each nut. If the spigot does not make full contact with the pipe surface, confirm that the assembly meets the guidelines in Step 11, or remove the strap and confirm that the spigot fully inserts into the hole. Do not exceed 100 ft-lbs/136 N•m.



### ⚠ WARNING

- Visual inspection of each assembly is critical.
- Improper set-up of assemblies must be corrected before the system is placed in service.

Failure to follow these instructions could cause assembly failure, resulting in death or serious personal injury and property damage.

### IMPACT WRENCH USAGE GUIDELINES

#### ⚠ WARNING

- It is important to tighten the nuts to the specifications given in step 10.
- DO NOT continue to tighten the nuts after the guidelines described in Step 10 are achieved.

Failure to follow these instructions could cause gasket or assembly damage, resulting in joint failure, serious personal injury, and property damage.

Due to the speed of assembly when using an impact wrench, the installer should take extra care to ensure that the nuts are tightened alternately until proper assembly is complete. Always refer to the specific product installation instructions for complete installation requirements.

Impact wrenches do not provide the installer with direct “wrench feel” or torque to judge nut tightness. Since some impact wrenches are capable of high output, it is important to develop a familiarity with the impact wrench to avoid damaging or fracturing the bolts or the housing’s gussets during installation. **DO NOT continue to tighten the nuts after the given guidelines for the assembly, described in Step 10, are achieved.**

If the battery is drained or if the impact wrench is under-powered, a new impact wrench or a new battery pack must be used to ensure that the visual installation guidelines for the assembly are achieved.

Perform trial assemblies with the impact wrench and check the assemblies with socket or torque wrenches to help determine the capability of the impact wrench. Using the same method, periodically check additional nuts throughout the system installation.

For safe and proper use of impact wrenches, always refer to the impact wrench manufacturer’s operating instructions. In addition, verify that proper impact grade sockets are being used for fitting installation.

### ⚠ WARNING

Failure to follow instructions for tightening fitting hardware could result in:

- Personal injury or death
- Housing fractures
- Damaged or broken gussets
- Assembly leakage