

## Pipe Preparation Instructions for Victaulic® QuickVic™ SD Installation-Ready™ System Products

### ⚠ WARNING



- Read and understand all instructions before attempting to install any Victaulic products.
- Wear safety glasses, hardhat, and foot protection.
- Wear tight-fitting, cut-resistant gloves when preparing pipe for use with Victaulic® QuickVic™ SD Installation-Ready™ System Products.

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

- Burrs and sharp edges shall be removed from the pipe ends in accordance with the instructions listed in this document.

Failure to remove burrs and sharp edges from the pipe ends will result in joint leakage or failure and property damage.

### INTRODUCTION

Regardless of the method chosen for cutting the pipe to length, there are two methods to prepare pipe ends for use with Victaulic QuickVic SD Installation-Ready System Products: power drive pipe preparation method and manual pipe preparation method. The end result shall comply with the "GOOD" pipe end images shown below.



OD

PIPE WALL

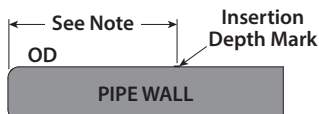
ID



OD

PIPE WALL

ID



NOTE: This area of the pipe, between the pipe end and the insertion depth mark, 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.



### DO NOT USE PIPE IF ANY OF THE FOLLOWING CONDITIONS EXIST



Use of pipe ends that contain any of the following conditions may cause rolled or cut seals, resulting in joint leakage or failure.



OD

PIPE WALL

ID



OD

PIPE WALL

ID



OD

PIPE WALL

ID



OD

PIPE WALL

ID



OD

PIPE WALL

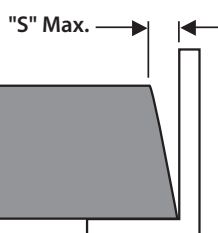
ID



OD

PIPE WALL

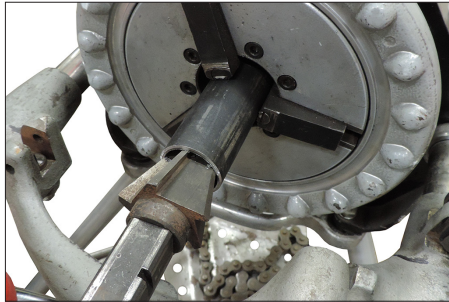
ID



Before proceeding with the instructions on the following page, verify that the pipe is square cut to within 0.030 inch/0.8 mm ("S" dimension shown).

## POWER DRIVE PIPE PREPARATION METHOD

The following power drive pipe preparation method shall be used only for pipe nipples that are 6 inches/152 mm or longer. For pipe nipples shorter than 6 inches/152 mm, the manual pipe preparation method shall be followed to prevent jaw marks on the gasket sealing surface of the pipe end. For complete setup and operation requirements, always reference the power drive manufacturer's instructions.



1. Install pipe into power drive. Verify that a minimum of 2 inches/51 mm is exposed in order to prevent jaw marks on the gasket sealing surface of the pipe end.
2. Ream the pipe's interior diameter (ID), if not completed previously.



3. Turn power drive on. Using a flat-mill file, remove all sharp edges and burrs while creating the rounded-over pipe end detail that is shown on page 1. **NOTE:** The file shall remain perpendicular to the pipe during this operation. Once completed, the pipe end shall not contain sharp edges or burrs (refer to photo of good pipe end below). For additional clarification, scan the QR code on the following page to access the pipe preparation video.



DO NOT hold the file at an angle, as shown. This will push burrs toward the pipe end, resulting in an unacceptable condition. For additional clarification, scan the QR code on the following page to access the pipe preparation video.



4. While the power drive is running, use an abrasive pad or emery cloth to refine the rounded-over portion of the pipe end. Turn power drive off and inspect pipe end per the requirements shown on page 1.

5. If the pipe has not been marked for insertion depth, follow the "Pipe Marking Requirements" section in the I-P100 Field Installation Handbook, which can be downloaded by scanning the QR code on the following page. **NOTE:** If the PC3110 Cut and Mark Tool was used, an additional insertion depth mark is not required.



## MANUAL PIPE PREPARATION METHOD



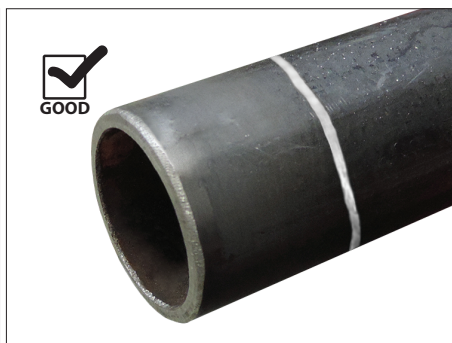
1. Clamp the pipe to a stable surface
2. Ream the pipe's interior diameter (ID) using an appropriate metal removal technique



3. Using a flat-mill file, remove all sharp edges and burrs while creating the rounded-over pipe end detail that is shown on page 1. Once completed, the pipe end shall not contain sharp edges or burrs (refer to photo of good pipe below). For additional clarification, scan the QR code below to access the pipe preparation video.



DO NOT file toward the pipe end. This will push burrs toward the pipe end, resulting in an unacceptable condition. For additional clarification, scan the QR code below to access the pipe preparation video.



4. Using an abrasive pad or emery cloth, refine the rounded-over portion of the pipe end. Inspect pipe end per the requirements shown on page 1.
5. If the pipe has not been marked for insertion depth, follow the "Pipe Marking Requirements" section in the I-P100 Field Installation Handbook, which can be downloaded by scanning the QR code below. **NOTE:** If the PC3110 Cut and Mark Tool was used, an additional insertion depth mark is not required.



SCAN QR CODE ABOVE FOR THE  
I-P100 FIELD INSTALLATION HANDBOOK



SCAN QR CODE ABOVE FOR THE  
TM-PC3110 OPERATING MANUAL



SCAN QR CODE ABOVE FOR THE  
PIPE PREPARATION REFERENCE VIDEO

---

## Pipe Preparation Instructions for Victaulic® QuickVic™ SD Installation-Ready™ System Products

---