

# Split Repair Gasket for Victaulic® Couplings

## ⚠ WARNING



- Read and understand all instructions before attempting to install any Victaulic products.
- Always verify that the piping system has been completely 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.

## IMPORTANT INFORMATION

- The following instructions are a guide for proper installation of Victaulic couplings with split repair gaskets. Standard molded gaskets are recommended for positive sealing and shall be used whenever possible. Split repair gaskets should be used ONLY when circumstances make it impossible to replace the standard molded gasket. Split repair gaskets shall be special ordered and supplied only by Victaulic.
- Verify that the split repair gasket material grade is suitable for the intended service. Maximum gasket life is dependent upon proper gasket grade selection and installation. To determine gasket material grade recommendations for each application, reference shall be made to Victaulic publication 05.01, which can be downloaded at victaulic.com.
- The outside surface of the mating components, between the groove and the mating component 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.
- **The mating components' outside diameter ("OD"), groove dimensions, and maximum allowable flare diameter shall be within the tolerances published within current Victaulic specifications.**
- Lubrication of the gasket is required to prevent the gasket from pinching, rolling, or tearing during installation. Refer to the instructions on the following page for lubricant requirements.
- Split repair gaskets that are 18-inch/DN450 and smaller in size are a special angle cut and do not require bonding. Refer to the instructions on the following page.
- Split repair gaskets that are 20-inch/DN500 and larger in size are square cut and shall be bonded with a light coating of adhesive (not provided). Refer to the table below and the instructions on the following page for adhesive requirements. **NOTE: Only Grades "E", "T", "S", and "L" can be bonded.**

## ADHESIVE REQUIREMENTS FOR BONDING 20-INCH/DN500 AND LARGER SPLIT REPAIR GASKETS

Gasket Grade	Color Code/Description	Primer	Adhesive
E – EPDM	Green Stripe/Standard Gasket for IPS Couplings	Not Needed	3M™ Scotch-Weld™ Instant Adhesive CA40H or CA40
T – Nitrile	Orange Stripe/Standard Gasket for IPS Couplings	Not Needed	3M™ Scotch-Weld™ Instant Adhesive CA40H or CA40
S – Nitrile	Orange Stripe/Gasket for AWWA Couplings	Not Needed	3M™ Scotch-Weld™ Instant Adhesive CA40H or CA40
L – Silicone	Red Gasket/Special Gasket for IPS Couplings	Hernon® EF® Adhesion Promoter 42	Hernon® Quantum® 124

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## ⚠ CAUTION

- A thin coat of a compatible lubricant shall be used to prevent the gasket from pinching, rolling, or tearing during installation.
- DO NOT use petroleum-based lubricants on Grade "E" and Grade "L" gaskets.

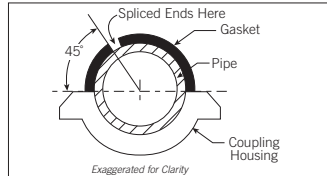
Failure to use a compatible lubricant may cause gasket damage, resulting in joint leakage and property damage.

# Split Repair Gasket for Victaulic® Couplings

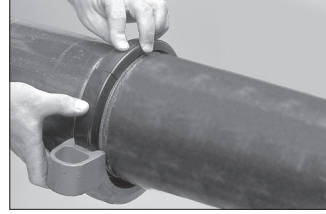
## INSTRUCTIONS FOR INSTALLING 18-INCH/DN450 AND SMALLER SPLIT REPAIR GASKETS



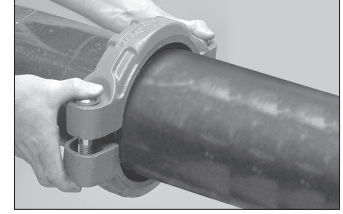
1. Apply a thin coat of a compatible lubricant, such as Victaulic Lubricant, to the gasket sealing lips and exterior.



2. Wrap the split repair gasket around the mating component ends. Verify that the gasket is not twisted and that the angled ends are mated properly. Center the gasket between the groove in each mating component end. Verify that no portion of the gasket extends into the groove of either mating component. Position the spliced ends of the gasket at a 45° angle with the horizontal. The spliced ends shall be positioned away from the coupling bolt pads.

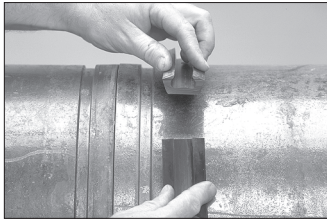


3. Place the lower coupling housing in position over the gasket/mating component ends. **NOTE:** For 14 – 18-inch/DN350 – DN450 size couplings that are cast in multiple segments, assemble the segments loosely into two equal halves. Allow clearance between the segments to ease assembly onto the mating components. Verify that the gasket remains centered between the groove in each mating component end during coupling assembly.

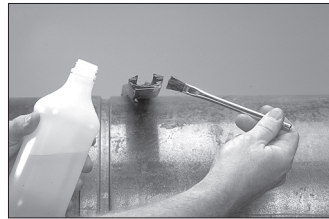


4. Place the upper coupling housing (or segment assembly) in position over the gasket/mating component ends. Finish the installation by referring to the instructions in the Victaulic I-100 Field Installation Handbook, which can be downloaded at victaulic.com.

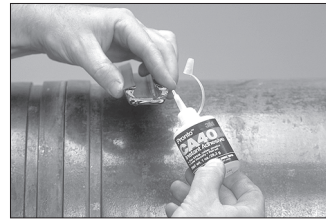
## INSTRUCTIONS FOR BONDING 20-INCH/DN500 AND LARGER SPLIT REPAIR GASKETS



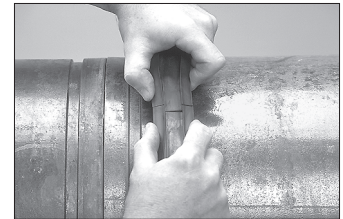
1. Wrap the split repair gasket around the mating component end with the sealing lips facing outward, as shown above. Verify that the gasket is not twisted.



2. Check the spliced surfaces to verify that they are dry and free of any debris. Brush each end with rubbing alcohol and allow to dry completely.



3. Refer to the “Adhesive Requirements” table on the previous page. Apply primer (if applicable) and/or adhesive to the spliced end(s) of the split repair gasket in accordance with the adhesive manufacturer’s instructions; these instructions shall be referenced for complete application and curing information.



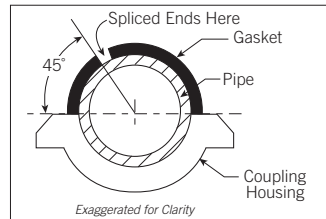
4. Immediately bring the spliced ends together after the adhesive is applied. Verify that the mating lips are aligned. **NOTE:** Realignment may not be possible after contact is made between the two spliced ends.



5. Allow the bonded area to dry completely, then lightly buff the bonded area using a fine grade sand paper (100 grit maximum). Be careful not to gouge the gasket surface.



6. Apply a thin coat of a compatible lubricant, such as Victaulic Lubricant, to the gasket sealing lips, then roll the gasket into position and center it between the groove in each mating component end. Verify that no portion of the gasket extends into the groove of either mating component. Apply a thin coat of compatible lubricant to the gasket exterior, as shown above.



6a. Position the bonded area of the gasket at a 45° angle with the horizontal. The bonded area shall be positioned away from the coupling bolt pads.



7. Install the coupling housings per the instructions in the Victaulic I-100 Field Installation Handbook. **NOTE:** For 20-inch/DN500 size couplings that are cast in multiple segments, assemble the segments loosely into two equal halves. Allow clearance between the segments to ease assembly onto the mating components. Verify that the gasket remains centered between the groove in each mating component end during coupling assembly.

For complete contact information, visit [victaulic.com](http://victaulic.com)