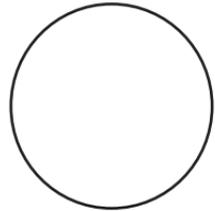
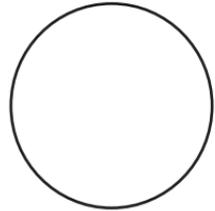


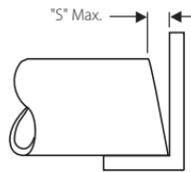
Style SC998 Transition Coupling for Plain-End HDPE Pipe to Shouldered Steel Pipe



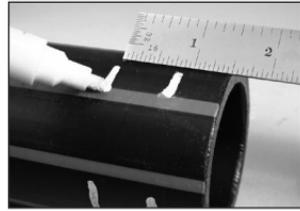
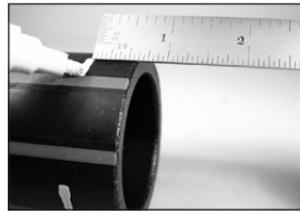
⚠ WARNING

- Read and understand all instructions before attempting to install any Victaulic piping products.
- Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.
- Wear gloves while handling coupling housings. The teeth machined into the housings are sharp and can cause injury.
- Wear safety glasses, hardhat, and foot protection.

Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.



1. Square-cut the HDPE pipe end ("S" dimension shown) within 1/8 inch/3 mm.
 - 1a. Make sure the HDPE pipe end is clean and free from damage and scratches within 1 inch/25 mm from the ends. Remove cutting particles.
 - 1b. The outside surface of the shouldered pipe end must be smooth and free from indentations and projections to ensure a leak-tight seal. All oil, grease, and dirt must be removed.



2. Refer to the "Gasket Reference Mark" column in the table to the right. Using a measuring tape and a bright-colored pencil or paint stick, mark the HDPE pipe end at the measurement listed in this table. This mark will be used for reference in centering the gasket during installation. Make at least four of these marks equally-spaced around the circumference of the pipe end.

3. Refer to the "Pipe Insertion Depth" column in the table to the right. Using a measuring tape and a bright-colored pencil or paint stick, mark the HDPE pipe end at the measurement listed in this table. This mark will be used for visual inspection to ensure the HDPE pipe is inserted properly in the coupling. Make at least four of these marks equally-spaced around the circumference of the pipe end.

Lubricant Compatibility for Gaskets

Lubricant	Compatibility with Grade "T" Nitrile Gaskets
Soap-Based Solutions, Glycerin, Silicone Oil, or Silicone Release Agent	Good
Corn Oil, Soybean Oil, Hydrocarbon-Based Oils, or Petroleum-Based Greases	Good

Due to variations in HDPE pipe, always consult with the pipe manufacturer for lubricant compatibility requirements. **DO NOT USE VICTAULIC LUBRICANT ON HDPE PIPE.**

Gasket Reference Mark and Insertion Depth Requirements for HDPE Pipe

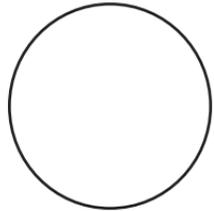
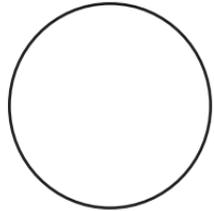
HDPE Pipe Size Actual Pipe Outside Diameter inches/mm	Gasket Reference Mark inches/mm	Pipe Insertion Depth inches/mm
2.480 63.0	5/8 16	1 1/2 40
4.330 110.0	5/8 16	2 3/4 69



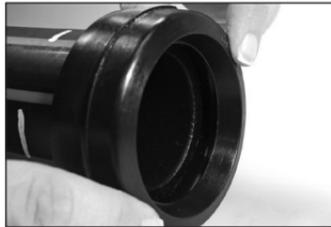
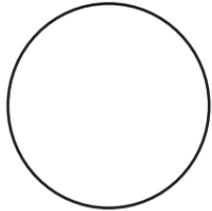
4. Check the gasket to make sure it is suitable for the intended service. The color code identifies the gasket grade. Lubricate the gasket in accordance with the "Lubricant Compatibility for Gaskets" table. **DO NOT use Victaulic lubricant on HDPE pipe.** Always consult with the pipe manufacturer for lubricant compatibility requirements.

⚠ CAUTION

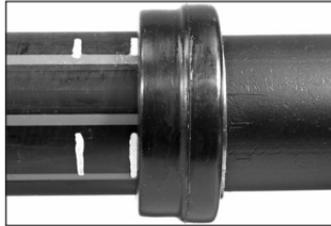
- A compatible lubricant must be used to prevent the gasket from pinching/tearing during installation. Always consult with the pipe manufacturer for lubricant compatibility.
- Failure to follow these instructions could cause joint leakage, resulting in property damage.



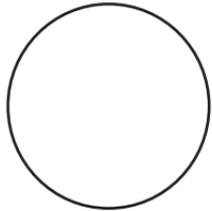
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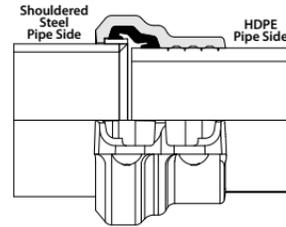
5. Install the smaller opening of the gasket over the HDPE pipe end. **NOTE:** The gasket is marked with "HDPE" on one side and "IPS" on the other side. The "HDPE" side of the gasket must face the HDPE pipe.



6. Align and bring the HDPE and shouldered steel pipe ends together. Slide the gasket into position by centering it between the mark on the HDPE pipe and the shouldered steel pipe end. Make sure no portion of the gasket extends over the shouldered pipe end. **NOTE:** The space between the pipe ends must never exceed 1/4 inch/6 mm.



7. Wear gloves while handling coupling housings. The teeth machined into the housings are sharp and can cause injury. Install the housings, making sure the teeth are facing toward the HDPE pipe. The key section of the housings must engage with the shouldered steel pipe end. Make sure the gasket remains positioned properly and that the mark on the HDPE pipe indicates full insertion into the coupling.



⚠ WARNING

- Housings must be installed with the teeth facing the HDPE pipe and the key section engaged with the shouldered steel pipe end.
- Bolts must be tightened evenly by alternating sides to achieve metal-to-metal contact at the bolt pads.

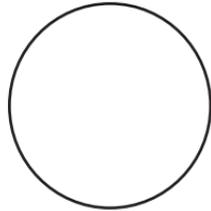
Failure to follow these instructions could cause joint separation, resulting in serious personal injury and/or property damage.



8. Insert the bolts. Thread a nut onto each bolt finger-tight. **NOTE:** Make sure the oval neck of each bolt seats properly in the bolt holes.

Style SC998 Helpful Information

Nominal Size inches	Shouldered Steel Pipe Size		Nut Size inches/Metric	Socket Size inches/Metric
	Actual Steel Pipe Outside Diameter inches/mm	Actual Shoulder Outside Diameter inches/mm		
2	2.375 60.3	2.618 66.5	3/8 M10	1 1/16 17
4	4.500 114.3	4.803 122.0	1/2 M12	3/8 22



9. Tighten all nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. **NOTE:** It is important to tighten all nuts evenly to prevent gasket pinching.

