Style 905 Refuse-to-Fuse™ Coupling for Plain-End, High-Density Polyethylene (HDPE) Pipe

I-905.METRIC
I-905.Metric
INSTALLATION INSTRUCTIONS
REV_E

Style 905 Refuse-to-Fuse™ Couplings are designed so that the installer does not need to remove the bolts and nuts for installation. This design facilitates installation by allowing the installer to directly insert HDPE pipe ends into the coupling.

1b. Remove all packaging (cardboard sleeves, zip ties, installation instructions, etc.) from the coupling. NOTE: The cardboard sleeve can be used as a guide for marking the pipe ends in step 3.

1c. Check the gasket to ensure that it is suitable for the intended service. The color code identifies the gasket grade. Refer to Victaulic publication 05.01 in the G-100 General Catalog for the color code chart, which can be downloaded at victaulic.com.

2a. PIPE END PREPARATION: Square-cut the HDPE pipe ends ("S" dimension shown) within 1/8 inch/3 mm.

2b. Ensure that the pipe ends are clean and free from damage and scratches within 2 1/4 inches/64 mm from the ends. All oil, grease, dirt, and cutting particles must be removed.

3. MARK PIPE: Using a ruler, measuring tape, or the cardboard sleeve and a paint stick, place a mark from each HDPE pipe end around the full circumference:
   - 48 mm/1 3/8 inches for 63 – 90-mm pipe sizes
   - 57 mm/2 1/4 inches for 110 – 225-mm pipe sizes
   This mark will be used for visual inspection to ensure the HDPE pipe is inserted properly in the coupling. If a full circumferential mark cannot be achieved, make at least four marks equally-spaced around the circumference of each HDPE pipe end.

4. LUBRICATE PIPE ENDS: Lubricate each pipe end in accordance with the "Lubricant Compatibility" table. Always consult with the pipe manufacturer for lubricant compatibility requirements.

   Lubricant Compatibility

<table>
<thead>
<tr>
<th>Lubricant</th>
<th>Compatibility with Grade “T” Nitrile Gaskets</th>
<th>Compatibility with Grade “E” EPDM Gaskets</th>
</tr>
</thead>
<tbody>
<tr>
<td>Victaulic Lubricant, Soap-Based Solutions, Glycerin, Silicone Oil, or Silicone Release Agent</td>
<td>Good</td>
<td>Good</td>
</tr>
<tr>
<td>Corn Oil, Soybean Oil, Hydrocarbon-Based Oils, or Petroleum-Based Greases</td>
<td>Good</td>
<td>Not Recommended</td>
</tr>
</tbody>
</table>

WARNING

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

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

CAUTION

- A compatible lubricant must be used to prevent the gasket from pinching/tearing during installation.
- Due to variations in HDPE pipe, always consult with the pipe manufacturer for lubricant compatibility requirements.

Failure to follow these instructions will void the Victaulic warranty and may cause joint leakage, resulting in property damage.
5. INSTALL COUPLING: Wear gloves while handling coupling housings. Retainer teeth are sharp and may cause injury. Assemble the joint by inserting the marked HDPE pipe end into each opening of the coupling. The HDPE pipe ends must be inserted into the coupling until (1) contact with the center leg of the gasket occurs AND (2) the mark on the HDPE pipe ends indicate full insertion into the coupling, as shown above. NOTE: The distance from the edge of the coupling housings to the pipe insertion marks must not exceed \( \frac{3}{16} \) inch/5 mm at any point around the circumference of the pipe ends.

6. TIGHTEN NUTS: Tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. Couplings with four bolts shall be tightened in a crossing pattern, as shown. Ensure that the oval neck of each bolt seats properly in the bolt hole. NOTE: Even tightening is important to prevent gasket pinching. An impact wrench or deep-well socket wrench can be used to obtain metal-to-metal contact.

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