**IPS ALUMINUM PIPE GROOVED COUPLINGS**

**21.02**

**Style 78A Snap-Joint® Aluminum Coupling**

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**PRODUCT DESCRIPTION**

Style 78A Snap-Joint coupling provides a quick disconnect joint. Mated housings are hinged with an attached locking handle for assembly.

Providing a flexible connection, Style 78A is cast of an aluminum alloy prepared for strength and durability with minimum weight, and is available in 2" (50 mm) and 10" (250 mm) sizes only.

The 2" (50 mm) size is supplied with a cast handle (steel link-type handle available on request). The 10" (250 mm) size is supplied with a cast handle only.

When aluminum alloys 6061-T4 or 6063-T4 are used, Schedule 80 must be cut grooved, Schedule 40 may be cut or roll grooved, Schedule 30 (8, 10, and 12")/200, 250, and 300 mm) may be cut or roll grooved. Aluminum pipe ratings are based on: alloy 6061-T4/6063-T4 – Schedule 80 cut grooved, Schedule 40 roll or cut grooved, Schedule 30 – 8, 10 & 12" roll or cut grooved, Schedule 5, 10 & 20 roll grooved ONLY, or alloy 6061-T6/6063-T6 – Schedule 40/80 cut groove ONLY, Schedule 30 – 8, 10 & 12" cut groove ONLY, Schedule 5, 10 & 20 grooving is NOT RECOMMENDED.

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**DIMENSIONS**

<table>
<thead>
<tr>
<th>Pipe Size</th>
<th>Partially Assembled</th>
<th>Fully Extended</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal Size</td>
<td>Partially Assembled</td>
<td>Fully Extended</td>
</tr>
<tr>
<td>2</td>
<td>2.375</td>
<td>2.50</td>
</tr>
<tr>
<td>10</td>
<td>10.750</td>
<td>11.00</td>
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</tbody>
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*Many aluminum pipe manufacturers (extruders) roll groove alloys 6061-T4 or 6063-T4 at the point of manufacture. Roll grooving is done successfully prior to the final T6 tempering of the pipe. Often pipe in the T6 tempered state will crack when roll grooved, depending upon the pipe’s mechanical properties, which vary from pipe to pipe. Victaulic has no control over these varying properties and cannot assure that the T6 tempered grades can be successfully roll grooved.

Pressure Ratings and End Loads for cut grooved pipe are based upon tests on pipe prepared in accordance with Victaulic specifications. Use of other equipment may adversely affect joint performance.

Aluminum pipe ratings are based on: alloy 6061-T4/6063-T4 – Schedule 80 cut grooved, Schedule 40 roll or cut grooved, Schedule 30 – 8, 10 & 12" roll or cut grooved, Schedule 5, 10 & 20 roll grooved ONLY, or alloy 6061-T6/6063-T6 – Schedule 40/80 cut groove ONLY, Schedule 30 – 8, 10 & 12" cut groove ONLY, Schedule 5, 10 & 20 grooving is NOT RECOMMENDED.

† Allowable Pipe End Separation and Deflection figures show the maximum nominal range of movement available at each joint for standard roll grooved pipe. Figures for standard cut grooved pipe may be doubled. These figures are maximums; for design and installation purposes these figures should be reduced by: 50% for 2" (50 mm); 25% for 10" (250 mm).
**PERFORMANCE**

**WARNING SAFETY CAUTION CONCRETE PUMPING SERVICE**

When used in concrete pumping, Style 78A couplings must be used within the design parameters listed. It is important to note that Maximum Joint Working Pressure must include shockload. Style 78A couplings and pipe used in concrete pumping must always be in functional condition and be free of concrete and foreign material in the pipe grooves and the keys and gasket cavity of the couplings. It should never be necessary to close coupling by hammering. If this is necessary, the coupling and grooved pipe ends should be reinspected for damage or dirty components which stop normal closure.

**MATERIAL SPECIFICATIONS**

**Housing:** Aluminum ASTM B-26, alloy 356-T6.

**Housing Coating:** None

**Standard Gaskets:** (Specify carbons, lubricants, hydraulic fluids, organic liquids and air choice*)

- **Grade “E” EPDM**
  - EPDM (Green color code).
  - Temperature range -30°F to +230°F (-34°C to +110°C).
  - Recommended 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 +86°F (+30°C) and hot +180°F (+82°C) potable water services. NOT RECOMMENDED FOR PETROLEUM SERVICES.

- **Grade “T” nitrile**
  - Nitrile (Orange color code).
  - Temperature range -20°F to +180°F (-29°C to +82°C).
  - Recommended for petroleum products, air with oil vapors, vegetable and mineral oils within the specified temperature range. Not recommended for hot water services over +150°F (+66°C) or for hot dry air over +140°F (+60°C).

**Optional Gaskets:** (Specify carbons, lubricants, hydraulic fluids, organic liquids and air choice*)

- **Grade “O” fluoroelastomer**
  - Fluoroelastomer (Blue color code).
  - Temperature range +20°F to +300°F (-7°C to +149°C). Recommended for many oxidizing acids, petroleum oils, halogenated hydrocarbons, lubricants, hydraulic fluids, organic liquids and air with hydrocarbons to +300°F (+149°C).

- **Grade “V” neoprene**
  - Neoprene (Yellow color code).
  - Temperature range +30°F to +180°F (-1°C to +82°C). Recommended for hot lubricating oils and certain chemicals. Good oxidation resistance. Will not support combustion.

- **Grade “L” silicone**
  - Silicone (Red gasket).
  - Temperature range -30°F to +350°F (-34°C to +177°C) air (without hydrocarbons) and certain chemical services. NOT RECOMMENDED FOR HOT WATER.

- **Grade “A” white nitrile**
  - White nitrile (White gasket).
  - Temperature range +20°F to +180°F (-7°C to +82°C). No carbon black content. May be used for food services. Meets FDA requirements and conforms to CFR Title 21, Part 177.2600.

- **Grade “M-2” epichlorohydrin**
  - Epichlorohydrin (White color code).
  - Temperature range -40°F to +160°F (-40°C to +71°C). Specially compounded to provide superior service for common aromatic fuels at low temperatures. Also suitable for certain ambient temperature water services.

- **Grade “O” fluoroelastomer**
  - Fluoroelastomer (Blue color code).
  - Temperature range -40°F to +160°F (-40°C to +71°C). Specially compounded to provide superior service for common aromatic fuels at low temperatures. Also suitable for certain ambient temperature water services.

**COUPLINGS ARE NOT DESIGNED FOR ECCENTRIC LOADINGS**

Style 78A couplings are not recommended for use at the end of concrete pumping booms, or on vertical risers above 30 feet. Sound anchoring and lashing practices should always be employed.

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This product shall be manufactured by Victaulic Company. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.