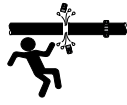


Expansion Joint Coupling

STYLE 152A

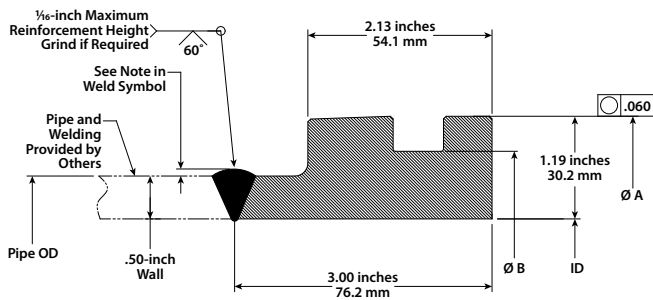
WARNING



- Read and understand all instructions before attempting to install any Victaulic piping products. A trained installer must install these products in accordance with all instructions.
- Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.
- 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.

VIC-RING WELD DETAIL



NOTICE

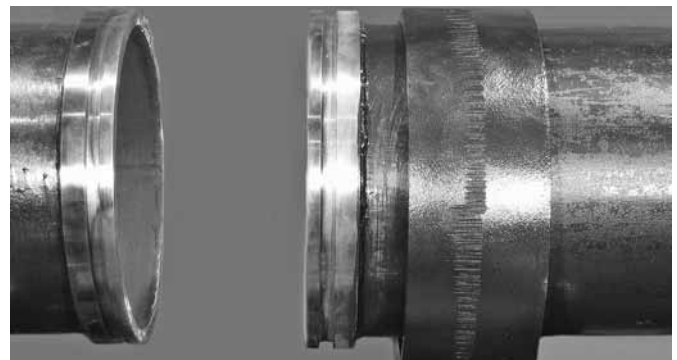
- It is the welder's responsibility to ensure Vic-Rings are welded correctly to the pipe, in accordance with proper welding practices and in conformance with the Vic-Ring Weldment detail provided with the specific project.

1. Weld Vic-Rings to the pipe end (refer to the drawing on this page). Always refer to the Vic-Ring Weldment detail provided with the specific project.
- 1a. After welding is complete, measure the "B" o-ring groove diameter dimension. This dimension must not be less than what is specified in the "B" Minimum O-Ring Groove Diameter After Welding" column in the table on this page.

Size		Dimensions – inches/mm		
Nominal Size inches or mm	Actual Outside Dia. inches/mm	"ID"	"A"	"B" Minimum O-Ring Groove Diameter After Welding
10 250	10.750 273.0	9.75 247.7	12.13 308.1	11.29 286.8
12 300	12.750 323.9	11.75 298.5	14.13 358.9	13.29 337.6
14 350	14.000 355.6	13.00 330.2	15.38 390.7	14.54 369.3
46 400	16.000 406.4	15.00 381.0	17.38 441.5	16.54 420.1
18 450	18.000 457.2	17.00 431.8	19.38 492.3	18.54 470.9
480 mm	18.898 480.0	17.90 454.7	20.28 515.1	19.44 493.8
20 500	20.000 508.0	19.00 482.6	21.38 543.1	20.54 521.7
530 mm	20.866 530.0	19.87 504.7	22.25 565.2	21.41 543.8
22 550	22.000 559.0	21.00 533.4	23.38 593.9	22.54 572.5
580 mm	22.835 580.0	21.84 554.7	24.22 615.2	23.38 593.9
24 600	24.000 609.6	23.00 584.2	25.38 644.7	24.54 623.3
630 mm	24.803 630.0	23.80 604.5	26.18 665.0	25.34 643.6
26 600	26.000 660.4	25.00 635.0	27.38 695.5	26.54 674.1
680 mm	26.772 680.0	25.77 654.6	28.15 715.0	27.31 693.7
28 700	28.000 711.2	27.00 685.8	29.38 746.3	28.54 724.9
30 760	30.000 762.0	29.00 736.6	31.38 797.1	30.54 775.7
780 mm	30.709 780.0	29.71 754.6	32.09 815.1	31.25 793.8



2. Support both sides of the pipe securely. Allow enough clearance to pass the coupling housing between the two pipe ends. **NOTE:** Pipe support must be maintained throughout the entire installation procedure, until instructed otherwise.



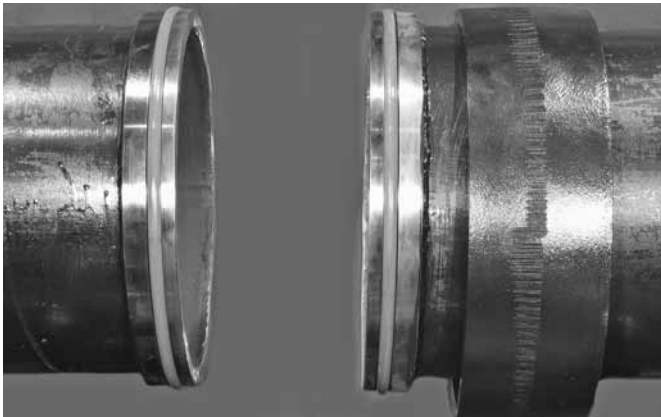
3. Slide the coupling housing past the Vic-Ring on one pipe end, as shown above. Be careful not to scratch the inside surface of the coupling housing. Clean the o-ring grooves in the Vic-Rings to remove any foreign material, weld spatter, etc.

Expansion Joint Coupling

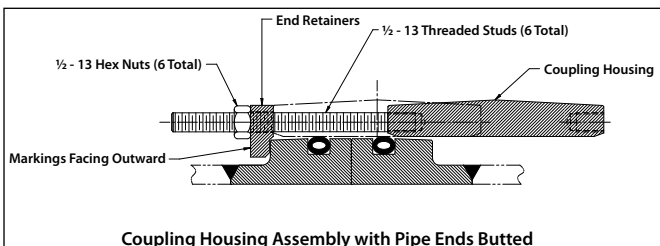
STYLE 152A



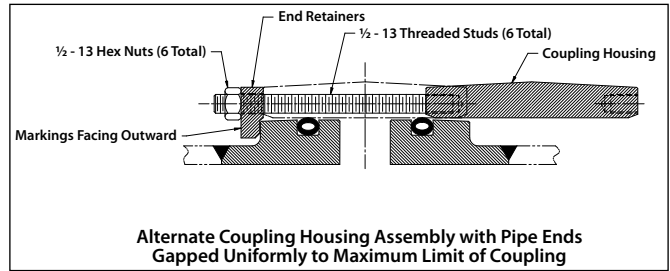
4. Lubricate the o-rings thoroughly with Seal-Lube™ O-Ring Lubricant* supplied by Victaulic. Prevent dirt and debris from contacting lubricated o-rings.



5. Install an o-ring into the groove in each Vic-Ring, as shown above.



6. Align and bring the pipe ends into the butted position, as shown above. Pipe ends must be aligned squarely to ease assembly.



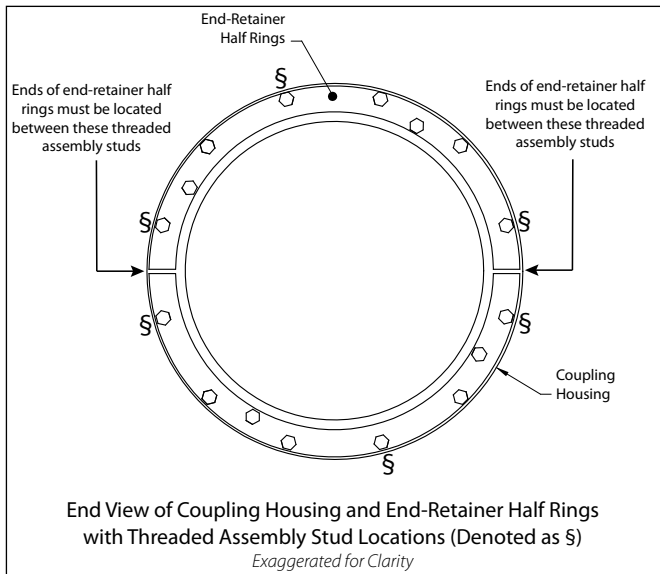
- 6a. An alternative is to gap the pipe ends uniformly to the maximum limit of the coupling, as shown above, and restrain the pipes to maintain that position.



7. On the side of the coupling housing away from the Vic-Rings, install two end-retainer half rings. Make sure the markings on the end-retainer half rings are facing out. Thread 1/2 - 13 x 1 1/2-inch long Grade 8 hex-head cap screws through each outside hole in the end-retainer half rings and into the coupling housing, as shown above. Tighten the hex-head cap screws completely.

Expansion Joint Coupling

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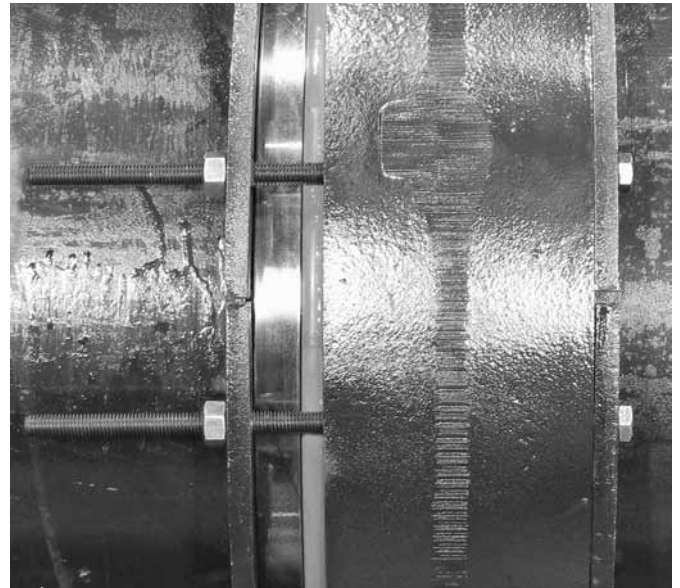


8. On the opposite side of the coupling housing, thread six ½ - 13 threaded assembly studs into the coupling housing at the locations shown in the drawing above (denoted as \$).

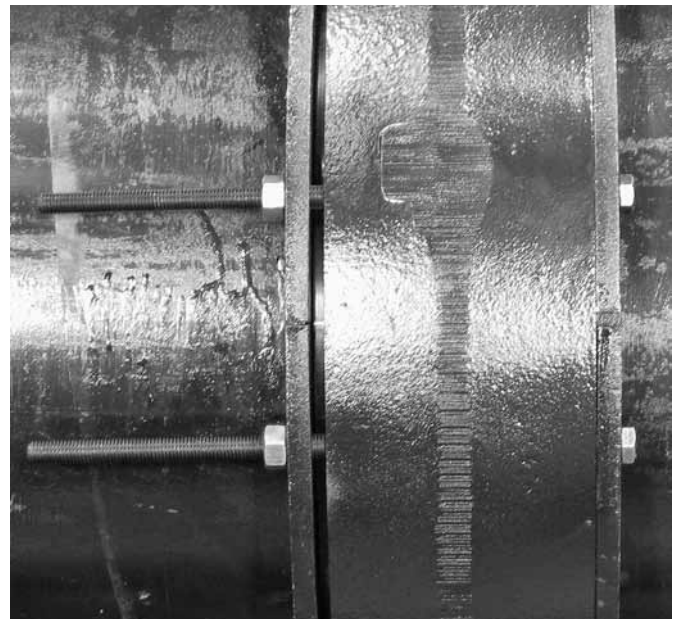


9. Place two end-retainer half rings over the threaded studs so that they contact the Vic-Ring. Make sure the markings on the end-retainer half rings are facing out. **NOTE:** Refer to the drawing above step 8 on the previous page for proper placement of the end-retainer half rings. Thread a nut onto the end of each stud.

9a. Begin tightening the nuts evenly in a crossing pattern to bring the coupling housing into contact with the first o-ring. Make sure the coupling housing contacts the o-ring evenly around the entire circumference. **NOTE:** It is important to tighten the nuts evenly to prevent the o-ring from pinching between the coupling housing and o-ring.



9b. Continue to tighten the nuts evenly in a crossing pattern until the coupling housing passes over the first o-ring completely. Make sure the coupling housing is pulled over the first o-ring uniformly to prevent o-ring damage.



9c. Repeat steps 9a and 9b to finish pulling the coupling housing over the second o-ring. Continue to tighten the nuts until the coupling housing meets the end-retainer half rings.

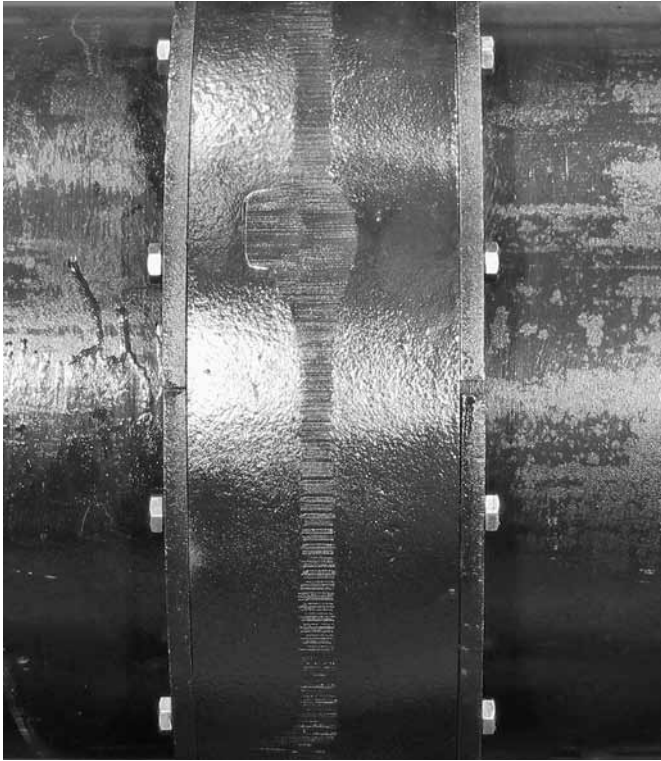
9d. On the side of the coupling where the threaded studs are located, install ½ - 13 x 1½-inch long Grade 8 hex-head bolts into the outside holes that do not contain threaded studs. **DO NOT** tighten the hex-head bolts completely, until instructed in Step 9f.

9e. Remove the nuts and threaded studs. Save these components for assembling additional Style 152 Expansion Joint Couplings.

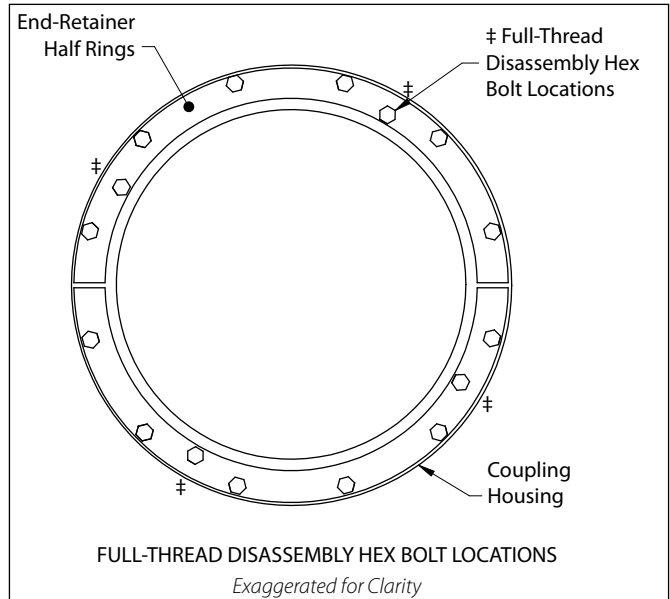
9f. Install ½ - 13 x 1½-inch long Grade 8 hex-head bolts into the holes where the threaded studs were located previously. Tighten all hex-head bolts completely.

Expansion Joint Coupling

STYLE 152A



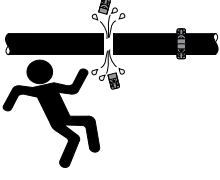
10. Style 152 installation is now complete.



2. Thread the full-thread disassembly hex bolts into the holes on one side of the coupling assembly that are closest to the pipe (denoted as ‡). **NOTE:** These holes normally do not have any bolts installed in them.

DISASSEMBLY INSTRUCTIONS

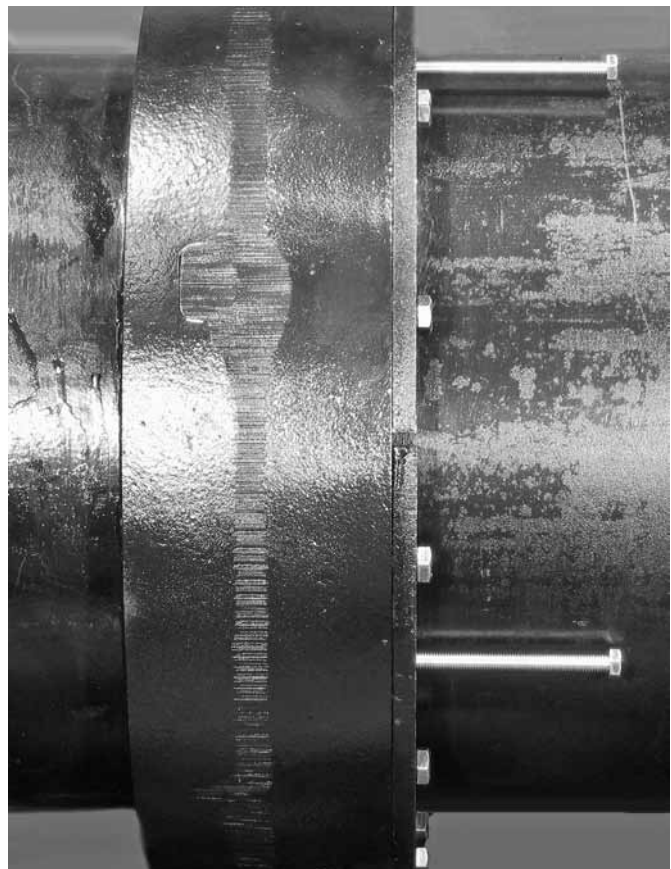
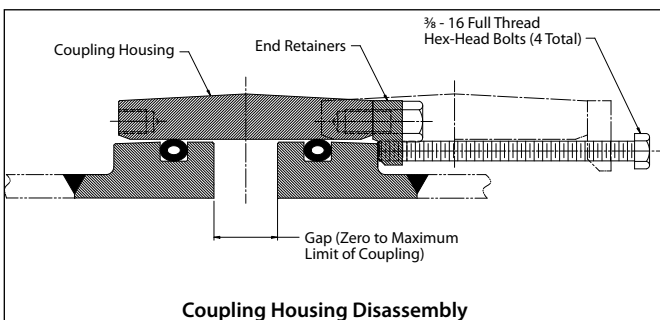
⚠ WARNING



- Depressurize and drain the piping system before attempting to disassemble any Victaulic piping products.
- Support both pipe lengths securely before attempting to disassemble this Victaulic coupling.

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

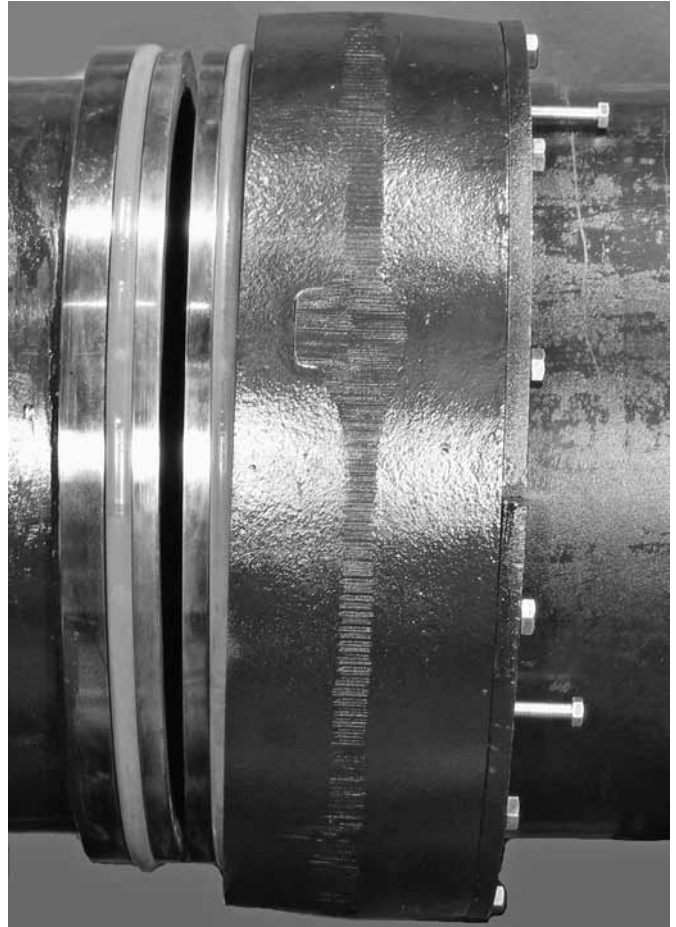
1. Support both pipe lengths securely. If pipes shift during disassembly, damage to the coupling housing and o-rings can occur. Make sure there is ample space around the pipe to remove the coupling housing.



3. Remove the 1/2 - 13 x 1 1/2-inch long Grade 8 hex-head bolts and end-retainer half rings from the side opposite where the disassembly bolts were installed in the previous step.

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- 3a. Begin tightening the $\frac{3}{8}$ - 16 disassembly bolts evenly in a crossing pattern to pull the coupling housing over the first o-ring. Make sure the coupling housing is being pulled over the o-ring uniformly around the entire circumference. Continue this procedure until the coupling housing passes over the second o-ring completely.
4. Remove all bolts from the entire assembly to permit removal of the end-retainer half rings.
5. Slide the coupling housing completely off the Vic-Rings. Be careful not to scratch the inside surface of the coupling housing.
6. Remove the o-rings from the Vic-Rings.
7. Separate the pipe ends sufficiently to remove the coupling housing. Be careful not to scratch the inside surface of the coupling housing.
8. The disassembly procedure is now complete.

Expansion Joint Coupling

STYLE 152A

For complete contact information, visit www.victaulic.com

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