

Large Diameter Pipe Coupling

STYLE 770

Style 770 couplings are designed to provide a strong reliable component for joining large diameter piping systems. Style 770 provides a joint with limited flexibility to accommodate settlement and alignment. Ranging in size from 26"/650 mm to 42"/1050 mm, Style 770 is ideal for roll grooved IPS black or galvanized steel and stainless steel systems up to 435 psi/2999 kPa depending on pipe size, pipe material and wall thickness as shown in the table on page 2.

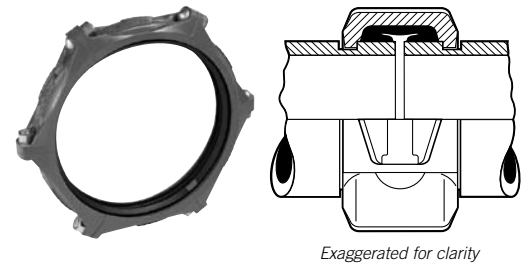
Roll Grooved

Beveled or square cut pipe of 0.250" to 0.500"/6.4 to 12.7 mm wall thickness can be roll grooved with special Vic-Easy® roll grooving tools. Grooving must be performed by personnel trained by Victaulic. Contact Victaulic for details on other wall thicknesses.

Cut Grooved

Cut Grooving may be used for pipe wall thickness 0.625"/15.9 mm or thicker.

NOTE: Nuts must be torqued to listed specifications during installation. This product requires special roll grooving equipment, pipe specifications, and mandatory installation training. Refer to I-770 for product installation instructions.



MATERIAL SPECIFICATIONS

Housing: Ductile iron conforming to ASTM A-536, grade 65-45-12. Ductile iron conforming to ASTM A-395, grade 65-45-15, is available upon special request.

Paint: Orange enamel

- **Optional:** Hot dipped galvanized and others

Coupling Gasket: (specify 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 service. 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.

* Services listed are General Service Recommendations only. It should be noted that there are services for which these gaskets are not recommended. Reference should always be made to the latest Victaulic Gasket Selection Guide for specific gasket service recommendations and for a listing of services which are not recommended.

Bolts/Nuts: Heat-treated plated carbon steel, trackhead meeting the physical and chemical requirements of ASTM A-449 and physical requirements of ASTM A-183.

JOB/OWNER

System No. _____

Location _____

CONTRACTOR

Submitted By _____

Date _____

ENGINEER

Spec Sect _____ Para _____

Approved _____

Date _____

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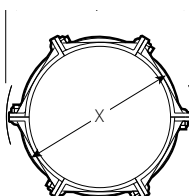
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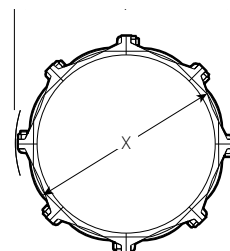
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DIMENSIONS



26 - 36" SIZES



42" SIZE

Pipe Size		Max. Work Press.	Max. End Load	Bolt/Nut * No. - Size	Required Bolt Torque	Coupling Dimensions Inches/mm			Nominal Range of Linear Movement ‡ Inches/mm		Nominal Deflection C _L ‡		Approx. Wgt. Each
Nominal Out. Dia. In./mm	Actual Out. Dia. In./mm	PSI * kPa	Lbs. * N	Inches	Ft. Lbs. N • m	X	Y	Z	Min.	Max.	Degrees	In./Ft. mm/m	Lbs. kg
26 650	26.000 660.4	375 2580	199099 885990	6 - 1¼ x 3½	600 815	29.75 756	34.25 870	5.00 127	0 0	0.38 9.7	0° - 50°	0.17 14.2	150.0 68.0
28 700	28.000 711.0	330 2270	203199 904236	6 - 1¼ x 3½	600 815	31.75 807	36.33 923	5.00 127	0 0	0.38 9.7	0° - 46°	0.16 13.3	175.0 78.0
30 750	30.000 762.0	300 2065	212058 943658	6 - 1¼ x 3½	600 815	33.75 857	38.32 973	5.00 127	0 0	0.38 9.7	0° - 43°	0.15 12.5	200.0 90.7
32 800	32.000 813.0	260 1790	209105 930517	6 - 1¼ x 3½	600 815	35.75 908	40.43 1027	5.00 127	0 0	0.38 9.7	0° - 40°	0.14 11.7	225.0 102.1
36 900	36.000 914.0	200 1380	203575 905909	6 - 1¼ x 3½	600 815	39.75 1010	44.33 1126	5.00 127	0 0	0.38 9.7	0° - 36°	0.12 10.0	250.0 113.4
42 1050	42.000 1067.0	145 1000	200890 893961	8 - 1½ x 4½	600 815	45.75 1162	51.56 1310	5.76 146	0.31 7.9	0.69 17.5	0° - 31°	0.11 9.0	400.0 181.4

* Refer to notes on page 3.

‡ Nominal Linear Movement and Deflection are dependent upon pipe properly roll or cut grooved to Victaulic specifications.

Maximum allowable linear movement is the difference between minimum and maximum pipe end separation subject to tolerances (request 26.01).

WORKING PRESSURES

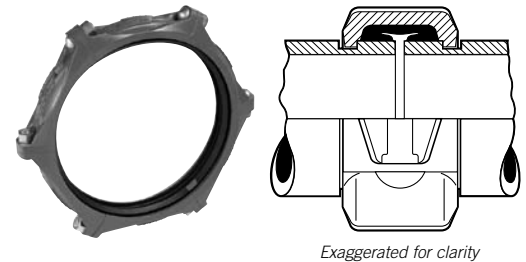
Pipe	SIZE Nominal Inches/ mm					
	26 650	28 700	30 750	32 800	36 900	42 1050
Thickness & Material	Working Pressure – PSI/kPa					
½" Wall Carbon Steel ^	435 2999	380 2620	348 2399	300 2065	232 1599	165 1138
¾" Wall Carbon Steel ^	375 2580	330 2270	300 2065	260 1792	200 1380	145 1000
¼" Wall Carbon Steel ^	150 1034	130 896	120 827	105 724	80 552	55 379
¼" Wall Stainless Steel ^	125 862	110 758	100 689	85 586	75 517	50 345
⅝" Wall Carbon Steel §	375 2580	330 2270	300 2065	260 1792	200 1380	145 1000

§ ⅝" wall pipe must be cut grooved.

^ ¼", ¾" and ½" wall pipe must be roll grooved. ¼" wall carbon steel and stainless steel must be roll grooved using Victaulic Rx rolls.

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GENERAL NOTES

* Working Pressure and End Load are total, from all internal and external loads, based on standard weight (ANSI) (0.375"/9.5 mm) steel pipe, roll grooved in accordance with Victaulic® specifications and with bolts fully torqued to listed specifications. See Working Pressures chart for performance on other pipe.

WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

‡ Linear Movement and Deflection figures show the nominal range of movement available at each joint for standard roll grooved pipe.

@ Number of bolts required equals number of housing segments.

Metric thread size bolts are available (color coded gold) for all coupling sizes upon request. Contact Victaulic for details.

WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

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WARRANTY

Refer to the Warranty section of the current Price List or contact Victaulic for details.

NOTE

This product shall be manufactured by Victaulic or to Victaulic specifications. 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.

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