

# Style 707-IJ NPS-to-JIS Transition Coupling

## PRODUCT DESCRIPTION



Patented



Assembly lug indicator

Victaulic® Style 707-IJ Transition coupling provides a direct, single coupling connection for grooved end NPS steel pipe, valves or fittings to grooved end Japanese Industrial Standard pipe, valves or fittings of the same nominal size. The housings will join JIS to NPS pipe cut or roll grooved to Victaulic standards.

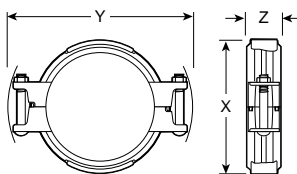
The housing fully encloses the synthetic rubber gasket. Housing keys engage into the grooves rolled or cut into the mating pipes. Track head bolts (metric) engage into housing recesses allowing tightening from one side.

Coupling bolt pads should be assembled securely metal-to-metal. The flat bolt pad design allows con-

trolled expansion/contraction and deflection as noted in the dimension chart.

Style 707-IJ housings also have assembly lugs by each bolt pad to aid proper positioning of JIS and NPS sides of the housings. These lugs **MUST** be properly engaged and housings bolted securely together to complete proper assembly.

## DIMENSIONS



Pipe mm/ <i>inches</i>			Max. Work. Press.* kPa PSI	Max. End Load* N Lbs.	Total Axial Move.† mm Inches	Angular Movement †		Bolt/Nut No. - Size mm	Dimensions mm/ <i>inches</i>			Aprx. Wgt. Each kg Lbs.
Nom. Size	NPS O.D.	JIS O.D. +1.6 mm -0.8 mm				Degrees Per Cplg.	Pipe mm/m In./Ft.		X	Y	Z	
200A 8	219.1 8.625	216.3 8.515	2500 363	94300 21200	0 - 0.13 0 - 3.2	0° - 50°	15 0.18	2-M20 x 127	257 10.12	356 14.02	62 2.44	6.3 13.8
250A 10	273.0 10.750	267.4 10.528	2500 363	146600 32900	0 - 0.13 0 - 3.2	0° - 40°	12 0.14	2-M22 x 165	314 12.36	422 16.61	62 2.44	9.1 20.0
300A 12	323.9 12.750	318.5 12.539	2500 363	206200 46300	0 - 0.13 0 - 3.2	0° - 34°	10 0.12	2-M22 x 165	367 14.45	475 18.70	62 2.44	10.6 23.3

Refer to notes on page 2.

06.16-1A

## MATERIAL SPECIFICATIONS

**Housing:** Ductile iron conforming to ASTM A-536.

**Housing Coating:** Green enamel

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

**Coupling Gasket:** (specify choice\*)

☐ **Grade "E" EPDM**

EPDM (Green color code). Temperature range  $-34^{\circ}\text{C}$  to  $+110^{\circ}\text{C}$  ( $-30^{\circ}\text{F}$  to  $+230^{\circ}\text{F}$ ). Recommended for cold and 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  $+30^{\circ}\text{C}$  ( $+86^{\circ}\text{F}$ ) and

hot  $+180^{\circ}\text{F}$  ( $+82^{\circ}\text{C}$ ) potable water service. NOT RECOMMENDED FOR PETROLEUM SERVICES.

☐ **Grade "T" nitrile**

Nitrile (Orange color code). Temperature range  $-29^{\circ}\text{C}$  to  $+82^{\circ}\text{C}$  ( $-20^{\circ}\text{F}$  to  $+180^{\circ}\text{F}$ ). Recommended for petroleum products, air with oil vapors, vegetable and mineral oils within the specified temperature range. Not recommended for hot water services over  $+66^{\circ}\text{C}$  ( $+150^{\circ}\text{F}$ ) or for hot dry air over  $+60^{\circ}\text{C}$  ( $+140^{\circ}\text{F}$ ).

\*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:** Metric – Heat treated carbon steel, zinc electroplated to ASTM B633 (gold chromate color coded), track head conforming to physical properties of ASTM A-183 minimum tensile 758340 kPa (110,000 PSI).

☐ **Optional:** Type 316 stainless steel, Grade B-8M, Class 2.

☐ **Optional:** U.S. Standard bolts, as above.

### NOTES

\* Working Pressure and End Load are total, from all internal and external loads, based on standard weight steel pipe, standard **roll** or **cut** grooved in accordance with Victaulic specifications. Contact Victaulic for performance on other pipe.

WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to  $1\frac{1}{2}$  times the figures shown.

† Allowable Pipe End Separation and deflection figures show the maximum nominal range of movement available at each joint with JIS **roll** grooved pipe. Figures for JIS **cut** grooved pipe may be doubled. These figures are maximums; for design and installation purposes these figures should be reduced by 25% for 100 mm (4") and larger.

@ Number of bolts required equals number of housing segments.

WARNING: Piping systems must always be depressurized and drained before attempting disassembly and removal of any Victaulic piping products.

This product shall be manufactured by Victaulic Company. All products shall 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.