

Style 995N Coupling for Plain-End HDPE Pipe

IT-995N

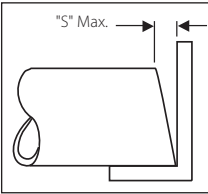
ALWAYS REFER TO THE I-900 FIELD INSTALLATION HANDBOOK
FOR ADDITIONAL INFORMATION

! WARNING



- Read and understand all instructions before attempting to install any Victaulic products.
- Always verify that the piping system has been completely depressurized and drained immediately prior to installation, removal, adjustment, or maintenance of any Victaulic products.
- Confirm that any equipment, branch lines, or sections of piping that may have been isolated for/during testing or due to valve closures/positioning are identified, depressurized, and drained immediately prior to installation, removal, adjustment, or maintenance of any Victaulic products.
- Wear safety glasses, hardhat, and foot protection.
- Wear gloves while handling coupling housings. The teeth machined into the housings are sharp and can cause injury.

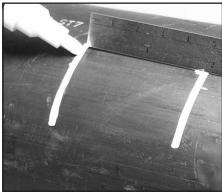
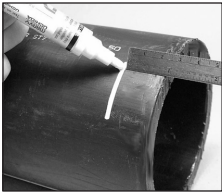
Failure to follow these instructions could result in death or serious personal injury and property damage.



- 1a. PIPE END PREPARATION:** Square-cut the HDPE pipe ends ("S" dimension shown) within 1/8-inch/3 mm for 2–4-inch/50–100-mm sizes and 1/4-inch/6.4-mm for 5-inch/125-mm and larger sizes.
- 1b.** Verify that the pipe ends are clean and free from damage and scratches within 1 inch/25 mm from the ends. Remove cutting particles.

! CAUTION

- Square-cut pipe shall be used for installation. If pipe is not square, re-cut the end to square.
- Failure to follow these instructions may cause joint leakage, resulting in property damage.



2. MARK PIPE FOR GASKET: Refer to the "Gasket Reference Mark" column in the table to the right. Using a measuring tape and a bright-colored pencil or paint stick, place a mark on the pipe ends at the measurement listed in this table. This mark will be used for reference in centering the gasket during installation. Draw at least four marks, equally spaced around the circumference of the pipe ends.

3. MARK PIPE FOR COUPLING: Refer to the "Pipe Insertion Depth" column in the table to the right. Using a measuring tape and a bright-colored pencil or paint stick, place an additional mark from the pipe ends at the measurement listed in this table. This mark will be used for visual inspection to ensure that the pipe ends are inserted properly into the coupling. Draw at least four marks, equally spaced around the circumference of the pipe ends.

Gasket Reference Mark and Insertion Depth Requirements for Imperial-Size HDPE Pipe

Nominal Size inches	Gasket Reference Mark inches/mm	Pipe Insertion Depth inches/mm
2	15/16 24	1 7/8 48
3	15/16 24	2 1/4 58
4	15/16 24	2 7/8 73
5 – 6	15/16 24	3 77
8	15/16 24	3 77
10	15/16 24	3 1/4 83
12	15/16 24	3 1/2 89
14	1 3/16 30	4 1/8 105
16	1 7/16 37	4 1/2 115
18	1 7/16 37	4 3/4 121
20	1 7/16 37	5 127

Gasket Reference Mark and Insertion Depth Requirements for Metric-Size HDPE Pipe

Nominal Size mm	Gasket Reference Mark mm	Pipe Insertion Depth mm
90	24	58
110	24	73
125	24	73
140	24	75
160	24	75
200	24	76
225	24	76
250	24	83
280	24	83
315	24	89
355	30	109
400	37	114
450	37	121
500	37	127



4. LUBRICATE GASKET: Check the gasket to make sure it is suitable for the intended service. The color code identifies the gasket grade. Lubricate the gasket in accordance with the "Lubricant Compatibility for Gaskets" table below. Apply a thin film of lubricant to all exterior surfaces and lips as shown.

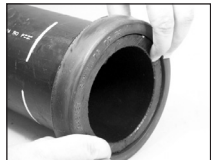
CAUTION

- A compatible lubricant shall 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.

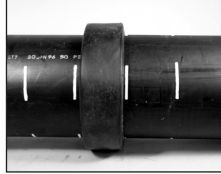
Failure to follow these instructions will void the Victaulic warranty and may cause joint leakage, resulting in property damage.

Lubricant Compatibility for Gaskets

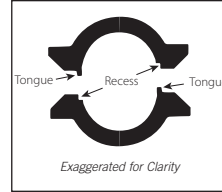
Lubricant	Compatibility with Grade "T" Nitrile Gaskets	Compatibility with Grade "E" EPDM Gaskets
Soap-Based Solutions, Glycerin, Silicone Oil, or Silicone Release Agent	Good	Good
Corn Oil, Soybean Oil, Hydrocarbon-Based Oils, or Petroleum-Based Greases	Good	Not Recommended



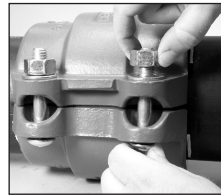
5. INSTALL GASKET: Install the gasket over the pipe end. Verify that the gasket does not overhang the pipe end.



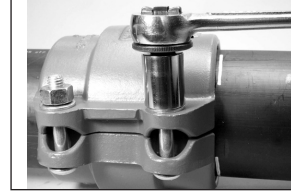
6. ALIGN GASKET: Align and bring the pipe ends together. Slide the gasket into position by centering it between the first set of pipe marks. **NOTE:** The space between the pipe ends shall never exceed 1/4-inch/6-mm for 2–4-inch/50–100-mm sizes and 3/16-inch/8-mm for 5-inch/125-mm and larger sizes.



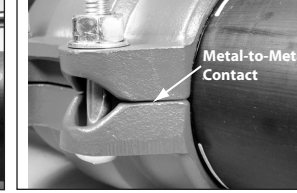
7. INSTALL HOUSINGS: Wear gloves while handling couplings. The teeth machined into the housings are sharp and can cause injury. Install the housings over the gasket. Verify that the tongue-and-recess features mate properly (tongue in recess) and that the housings are centered between the second set of pipe marks. **NOTE:** The second set of marks on the pipe shall indicate full insertion into the coupling.



8. INSTALL HARDWARE: Insert the bolts. Install a washer onto the end of each bolt. Thread a nut finger-tight onto each bolt. **NOTE:** Verify that the oval neck of the bolts seat properly in the bolt holes.

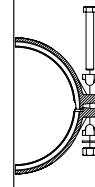


9. TIGHTEN NUTS: Tighten the nuts evenly by alternating sides, maintaining nearly uniform bolt pad gaps, until metal-to-metal contact occurs at the bolt pads. **Larger coupling sizes with four bolts shall be tightened in a crossing pattern, as shown.**



NOTE: Even tightening is important to prevent gasket pinching. The use of a geared torque multiplier is recommended, since a high level of torque may be required to achieve metal-to-metal contact at the bolt pads (especially in colder temperatures).

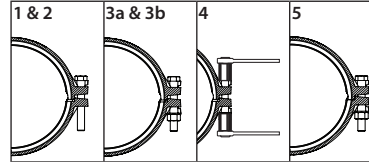
NOTICE



SCAN CODE TO ACCESS THE I-900 ON VICTAULIC.COM

- Style 995N Couplings in 14-inch and larger sizes contain hex bolts, rocker washers, flat washers, and nuts that require special instructions for tightening. Refer to the information below for the proper tightening sequence.
- Always reference the I-900 Field Installation Handbook for additional information. This handbook can be downloaded by scanning the QR provided.

Installing Special Hardware for 14-inch/ 355.6-mm and Larger Style 995N Couplings



1. Follow steps 1–7 of the Style 995N installation instructions in the I-900 Field Installation Handbook, which can be downloaded by scanning the QR code provided above. For carbon steel fasteners, coat bolt threads with Victaulic Lubricant or other suitable thread lubricant. For stainless steel fasteners, coat bolt threads with a suitable anti-seize compound. **2.** Insert a hex bolt with rocker washer into each bolt hole in the housings. The curved surface of the rocker washer shall face the bolt pad of the housing, as shown to the left. **3a.** Install a rocker washer onto the end of each hex bolt. The curved surface of the rocker washer shall face the bolt pad of the housing, as shown to the left. **3b.** Install flat washers (one for carbon steel fasteners, two for stainless steel fasteners) onto the end of each hex bolt, then thread a nut onto the end of each hex bolt until the rocker washer contacts the coupling housing. **4.** Tighten all nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads. **NOTE:** It is important to tighten the nuts evenly to prevent gasket pinching. **5.** Inspect the finished assembly to verify that the bolt pads are in metal-to-metal contact. Verify that the rocker washers are engaged in the recesses of the coupling housings.

For complete contact information, visit victaulic.com

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