

# Vic-Boltless<sup>®</sup> Coupling



SEE VICTAULIC PUBLICATION 10.01 FOR DETAILS

## STYLE 791

Vic-Boltless Style 791 coupling is a one-piece hinged coupling that features locking pin installation with a separate tool (Style 792) design for assembly and disassembly. The Style 791 coupling provides a secure, tamper resistant, low profile joint.

Utilized on standard Victaulic<sup>®</sup> roll or cut grooved pipe, the one-piece housing surrounds the standard gasket and engages into the grooves. A separate lever-type assembly tool mates the open housing ends and aligns the pin holes. A single notched drive pin is set with a hammer completing installation. The assembly tool is removed.

The new pin-locking design provides pressure ratings up to 700 psi/4826 kPa (depending on size.) The notched, tapered steel pin creates a wedge-like seat in the ductile housing and resists removal without re-application of the assembly tool. Removal and re-use however, can easily be achieved with the assembly tool and a drive pin punch.

Performance data presented in this document is based on use with standard wall, carbon steel pipe. For use with stainless steel pipe, please reference document 17.09 for pressure ratings and end loads. When used on light wall stainless steel pipe, the Victaulic RX roll set must be used to roll groove the pipe. For further information regarding roll grooving stainless steel, refer to document 17.01.



### MATERIAL SPECIFICATIONS

**Housing:** Ductile iron conforming to ASTM A-395, grade 65-45-15, and ASTM A-536, grade 65-45-12.

**Housing Coating:** Orange enamel

- Optional: Hot dipped galvanized 4"/100mm and up only 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 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 +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.

**Hinge Pin/Locking Pin:** Cold rolled steel conforming to AISI-1212, zinc electroplated.



**JOB OWNER**

System No. \_\_\_\_\_  
Location \_\_\_\_\_

**CONTRACTOR**

Submitted By \_\_\_\_\_  
Date \_\_\_\_\_

**ENGINEER**

Spec Sect \_\_\_\_\_ Para \_\_\_\_\_  
Approved \_\_\_\_\_  
Date \_\_\_\_\_

www.victaulic.com

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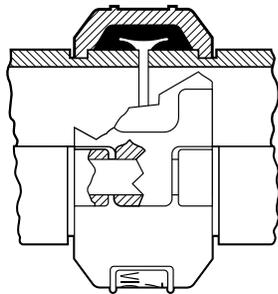
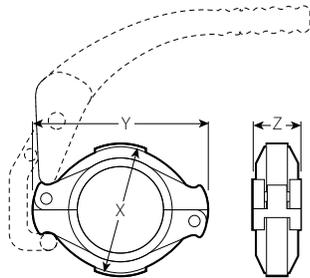
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STYLE 791

## DIMENSIONS



Exaggerated for clarity

Size		Max. Work Pressure *	Max. End Load *	Allow. Pipe End Sep. *	Deflect. Fr. CL †	Locking Pin Size	Dimensions Inches/mm			Approx. Wgt. Each	
Nominal Size Inches/mm	Actual Outside Dia. Inches/mm	psi/kPa	Lbs./N	Inches/mm	Per Cplg. Deg.		Pipe In./Ft. mm/m	Di. x Length Inches	X	Y	Z
2 50	2.375 60.3	700 4825	3,100 13795	0 – 0.06 0 – 1.6	1° - 31'	0.32 26	5/16 x 1 1/8	3.56 90	4.71 120	1.84 47	1.8 0.8
2 1/2 65	2.875 73.0	700 4825	4,540 20205	0 – 0.06 0 – 1.6	1° - 15'	0.26 22	3/8 x 1 1/8	4.09 104	5.48 139	1.84 47	2.7 1.2
3 80	3.500 88.9	700 4825	6,730 29950	0 – 0.06 0 – 1.6	1° - 2'	0.22 18	3/8 x 1 1/8	4.72 120	6.15 156	1.84 47	2.6 1.2
4 100	4.500 114.3	700 4825	11,130 49530	0 – 0.13 0 – 3.2	1° - 36'	0.34 28	7/16 x 2	6.06 154	7.62 194	1.93 49	4.8 2.2
6 150	6.625 168.3	600 4135	20,675 92005	0 – 0.13 0 – 3.2	1° - 5'	0.23 18	1/2 x 2 1/8	8.24 209	10.18 259	2.06 51	6.3 2.9
8 200	8.625 219.1	500 3450	29,200 129940	0 – 0.13 0 – 3.2	0° - 50'	0.18 14	1/2 x 2 3/8	10.52 267	12.50 318	2.31 59	12.0 5.4

Complete coupling includes one-piece hinged housing, gasket and locking pin only. Assembly Tool Style 792 is required for assembly (one tool fits all size couplings).

\* **Working Pressure** and **End Load** are total, from all internal and external loads, based on standard weight (ANSI) 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 1/2 times the figures shown.

\* **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 3/4 – 3 1/2"/20 – 90mm; 25% for 4"/100mm and larger.

Number of bolts required equals number of housing segments.

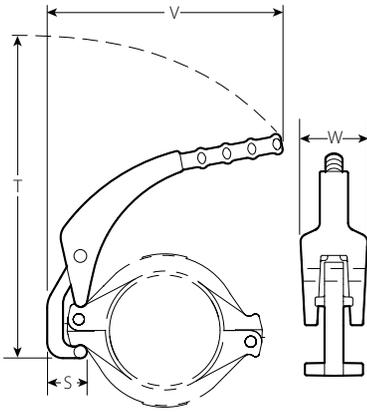
Metric thread size bolts are available (color coded gold) for all coupling sizes upon request. Contact Victaulic for details.

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

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## DIMENSIONS



Size		Style 792 Tool Dimensions – Inches/mm			
Nominal Size Inches mm	Actual Outside Dia. Inches mm	S	T	V	W
2 50	2.375 60.3	1.55 40	13.05 332	9.24 235	2.63 67
2½ 65	2.875 73.0	1.55 40	13.05 332	9.24 235	2.63 67
3 80	3.500 88.9	1.55 40	13.05 332	9.24 235	2.63 67
4 100	4.500 114.3	1.55 40	13.05 332	9.24 235	2.63 67
6 150	6.625 168.3	1.55 40	13.05 332	9.24 235	2.63 67
8 200	8.625 219.1	1.55 40	13.05 332	9.24 235	2.63 67

Complete coupling includes one-piece hinged housing, gasket and locking pin only. Assembly Tool Style 792 is required for assembly (one tool fits all size couplings).

## 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.

For complete contact information, visit [www.victaulic.com](http://www.victaulic.com)

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