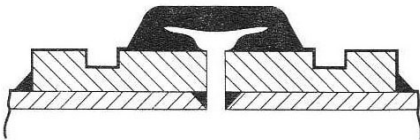


Installation and Assembly

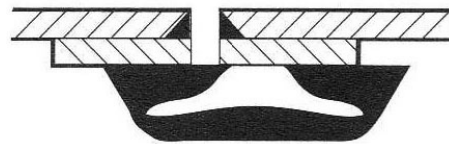
1. CHECK PIPE ENDS: Installed Vic-Ring adapter or shouldered ends must be free from loose coatings, mill scale, rust, indentations or projections on exterior along the gasket seat, to assure a leak-tight seal for the gasket.

2. CHECK GASKET AND LUBRICATE: Check gasket supplied to be certain it is suited for intended service. Color code identifies gasket grade. Apply a thin coat of Victaulic lubricant or silicone lubricant to gasket lips and outside of gasket.

3. INSTALL GASKET: Place gasket over Vic-Ring adapter, being sure gasket lip does not overhang seating area. To ease gasket installation, the gasket may be rolled over the Vic-Rings such that the sealing lips are on the outside of the gasket.



4. JOIN PIPE ENDS: Align and bring two pipe ends together and slide (or roll) the gasket into position centered between both the Vic-Ring grooves or shouldered ends.



INCORRECT GASKET POSITION

The above illustrates an example of **IMPROPER** positioning of the gasket. The gasket sealing lips should be in firm contact with the Vic-Ring adapter surface. No portion of the gasket should extend beyond the gasket seating surface or into the grooves.

NOTE: If visual confirmation cannot be made 360° around the gasket, use hand to confirm gasket is properly seated on the Vic-Ring/shoulder sealing surfaces.

5. APPLY HOUSING: Place housings over gasket, being sure the housing keys engage into the grooves or over shoulders. To ease installation, first preassemble the segments loosely into pairs, allowing slight clearance between segments. Install "pairs" over the gasket, again checking that the housing keys engage into the grooves. As the coupling "pairs" are put in place, insert the bolts and apply the nuts finger-tight.

6. TIGHTEN NUTS: Tighten nuts alternately and equally until housing bolt pads are firmly together -- metal to metal. Be sure coupling fully engages in grooves when tightening.

WARNING

Piping systems must always be depressurized and drained before attempting disassembly and removal of any Victaulic piping products or installation or removal of valve.

Failure to do so could result in serious personal injury, property damage, joint leakage or joint separation.