Victaulic® Coupling for Plain End Polyethylene Pipe
Style 905

19.07

1.0 PRODUCT DESCRIPTION

Available Sizes

- 2 – 14" IPS pipe size
- 63 – 355 mm ISO pipe sizes

Pipe Material

- HDPE pipe conforming to ASTM D3035 and ASTM F714 or ISO 4427-2 (SDR 7 – 26)
- PE-RT pipe conforming to ASTM D3350, cell class PE445574C, ASTM F2619, and ASTM F714 (SDR 7 – 26)
- See publication 36.01 for information on cross-linked polyethylene (PE-Xa) pipe.
- Contact Victaulic for other pipe materials

Maximum Working Pressure

- Meets or exceeds the pressure rating of the HDPE or PE-RT pipe

Operating Temperature

- Dependent upon pipe manufacturer rating and gasket selection
- Reference section 3.0 for gasket performance options
- Consult pipe manufacturer for pipe material performance limitations

Function

- Joins plain end polyethylene pipe
- Utilizes patented Installation-Ready™ technology to eliminate loose parts

Pipe Preparation

- For use on plain end HDPE or PE-RT pipe

NOTE

- All references to HDPE within this document are inclusive of PE-RT

2.0 CERTIFICATION/LISTINGS

NOTE

- See Publication 10.01: Victaulic Fire Protection Approval Reference Guide for details.
- See Publication 02.06: Victaulic Approvals for Potable Water Products – ANSI/NSF 61 and ANSI/NSF 372 if applicable.
- WaterMark™ certification only applies to fusion bonded epoxy-coated couplings with Grade “E” EPDM gaskets. Contact Victaulic for further details.

ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

3.0 SPECIFICATIONS – MATERIAL

Housing: Ductile iron conforming to ASTM A536, Grade 65-45-12.

Housing Coating: (specify choice)

- ☐ Orange coating for IPS sizes
- ☐ Black coating for ISO sizes and 5" IPS
- ☐ Liquid bonded epoxy
- ☐ Fusion bonded epoxy, galvanized and other coatings are available. Contact Victaulic for details.

Retaining Ring: Type 316 stainless steel.

Coupling Gasket: (specify choice[1])

☐ **Grade "T" Nitrile (Standard or Flush-Seal™)**

Nitrile (Orange color code). Temperature range –20ºF to +180ºF/–29ºC to +82ºC. May be specified for oil related services, including air with oil vapor, this gasket may be specified for temperatures rated up to +180°F/+82°C. For water related services, this gasket may be specified for temperatures rated up to +150°F/+66°C. For oil free, dry air services, this gasket may be specified for temperatures rated up to +140°F/+60°C. NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.

☐ **Grade "E" EPDM (Standard or Flush-Seal™)**

EPDM (Green color code). Temperature range –30ºF to +230ºF/–34ºC to +110ºC. May be specified 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 NSF/ANSI/CAN 61 for cold +73°F/+23°C potable water service and NSF/ANSI/CAN 372. NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.

☐ **Grade "EF" EPDM**

EPDM (Green "X" color code). Temperature range –30ºF to +230ºF/–34ºC to +110ºC. May be specified for hot and cold water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. Also meets hot and cold potable water requirements per DVGW, KTW, ÖVGW, SVGW, and French ACS (Crecep), approved for W534, approved for EN681-1 Type WA cold potable, and Type WB hot potable water service. NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.

☐ **Grade "O" Fluoroelastomer**

Fluoroelastomer (Blue stripe color code). Temperature range +20ºF to +300ºF/-7ºC to +149ºC. May be specified for many oxidizing acids, petroleum oils, halogenated hydrocarbons, lubricants, hydraulic fluids, organic liquids and air with hydrocarbons. NOT COMPATIBLE FOR USE WITH HOT WATER SERVICES OR STEAM SERVICES.

[1] Services listed are General Service Guidelines only. It should be noted that there are services for which these gaskets are not compatible. Reference should always be made to the latest Victaulic Gasket Selection Guide for specific gasket service guidelines and for a listing of services which are not compatible.

NOTE

- The maximum temperature ratings shown exceed the temperature ratings for HDPE pipe. Consult individual pipe manufacturers for specific temperature limits.

Hardware:

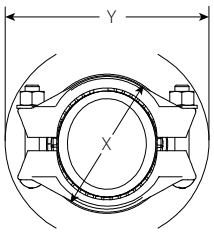
Bolts/Nuts: (specify choice[2])

- ☐ Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449 (imperial) and ISO 898-1 Class 9.8 (M10-M16) Class 8.8 (M20 and greater). Carbon steel hex nuts meeting the mechanical property requirements of ASTM A563 Grade B (imperial - heavy hex nuts) and ASTM A563M Class 9 (metric - hex nuts). Track bolts and hex nuts are zinc electroplated per ASTM B633 ZN/FE5, finish Type III (imperial) or Type II (metric), with blue (imperial) or black (metric) fluoropolymer top coat. Hardened steel washers conforming to ASTM F436 Type 3 (weathering steel).
- ☐ 2 – 4", 63 – 110 mm: Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM F593, Group 2 (316 stainless steel), condition CW. Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM F594, Group 2 (316 stainless steel), condition CW, with galling reducing coating. Stainless steel washers conforming to ASME B18.21.1 and ASTM A666, Type 316, Annealed.
- ☐ 5 – 14", 125 – 355 mm: Stainless steel oval neck track bolts meeting the mechanical property requirements of ASTM A193, Class 2 (316 stainless steel), Grade B8M. Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM A194 Grade 8M Heavy Hex, with galling reducing coating. Stainless steel washers conforming to ASME B18.21.1 and ASTM A666, Type 316, Annealed.

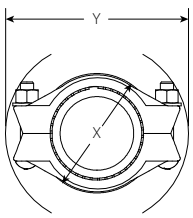
[2] Stainless steel bolts/nuts available in imperial size only

4.0 DIMENSIONS

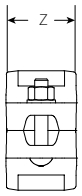
Style 905 – IPS Standard

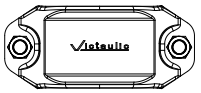


Style 905 Pre-Assembled (Installation-Ready Condition)

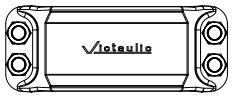


Style 905 Joint Assembled



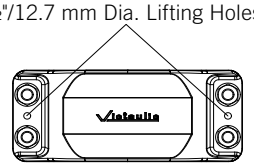


2 – 6" IPS



8" IPS

½"/12.7 mm Dia. Lifting Holes[3]



10 – 14" IPS

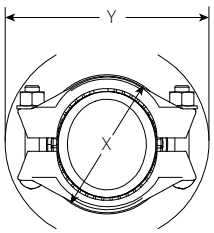
Size		Pipe End Separation[4]	Bolt/Nut		Dimensions					Weight
					Pre-assembled (Installation-Ready™ Condition)		Joint Assembled			
Nominal inches	Actual Outside Diameter inches mm	Allowable inches mm	Qty.	Size inches	X inches mm	Y inches mm	X inches mm	Y inches mm	Z inches mm	Approx. (Each) lb kg
2	2.375 60.3	0.25 6.4	2	½ x 3 ¼	3.88 99	6.38 162	3.50 89	6.63 168	4.13 105	5.5 2.5
3	3.500 88.9	0.25 6.4	2	⅝ x 3 ½	5.13 130	8.13 207	4.63 118	8.13 207	4.13 105	8.5 3.9
4	4.500 114.3	0.25 6.4	2	⅝ x 4 ¼	6.50 165	9.25 235	6.00 152	9.38 238	4.75 121	13.1 5.9
5	5.563 141.3	0.25 6.4	2	¾ x 4 ¼	7.63 194	10.88 276	6.88 175	11.25 286	4.88 124	18.7 8.5
6	6.625 168.3	0.25 6.4	2	¾ x 5	8.88 226	12.13 308	8.13 207	12.63 321	4.75 121	19.4 8.8
8	8.625 219.1	0.40 10.2	4	¾ x 6 ¼	11.00 279	14.50 368	10.00 254	14.88 378	5.00 127	28.0 12.7
10	10.750 273.0	0.40 10.2	4	⅞ x 6 ½	13.73 349	17.75 451	12.73 323	18.25 464	7.09 180	73.5 33.3
12	12.750 323.9	0.40 10.2	4	⅞ x 6 ½	15.83 402	19.63 499	14.83 377	20.07 510	7.11 181	86.5 39.2
14	14.000 355.6	0.40 10.2	4	1 ⅛ x 7	17.67 449	21.38 543	16.42 417	21.89 556	8.42 214	112.6 51.1

[3] Unthreaded through holes for appropriately sized lifting eyes or hooks.

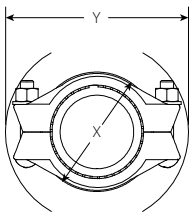
[4] Style 905 couplings when sufficiently pressurized will allow pipe ends to separate to maximum value shown.

4.1 DIMENSIONS

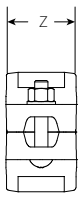
Style 905 – ISO Standard

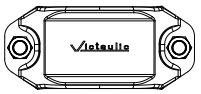


Style 905 Pre-Assembled (Installation-Ready Condition)



Style 905 Joint Assembled

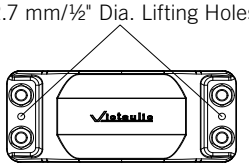




63 – 160 mm ISO

180 – 225 mm ISO

12.7 mm/½" Dia. Lifting Holes[5]



250 – 355 mm ISO

Size	Pipe End Separation[7]	Bolt/Nut		Dimensions					Weight
				Pre-assembled (Installation-Ready™ Condition)		Joint Assembled			
Nominal mm	Allowable mm inches	Qty.	Size[6] mm inches	X mm inches	Y mm inches	X mm inches	Y mm inches	Z mm inches	Approx. (Each) kg lb
63	6.4 0.25	2	M12 x 83 ½ x 3 ¼	99 3.88	152 6.00	89 3.50	168 6.63	105 4.13	2.5 5.5
75	6.4 0.25	2	M16 x 83 ⅝ x 3 ¼	114 4.50	184 7.25	102 4.00	194 7.63	105 4.13	3.7 8.1
90	6.4 0.25	2	M16 x 102 ⅝ x 4	130 5.13	195 7.68	118 4.63	210 8.25	105 4.13	3.9 8.5
110	6.4 0.25	2	M16 x 102 ⅝ x 4	159 6.25	219 8.63	146 5.75	232 9.13	121 4.75	5.9 13.0
125	6.4 0.25	2	M20 x 108 ¾ x 4 ¼	175 6.88	264 10.38	159 6.25	273 10.75	124 4.88	7.8 17.3
140	6.4 0.25	2	M20 x 108 ¾ x 4 ¼	194 7.63	276 10.88	175 6.88	286 11.25	124 4.88	8.5 18.7
160	6.4 0.25	2	M20 x 127 ¾ x 5	210 8.25	292 11.50	194 7.63	305 12.00	121 4.75	8.8 19.3
180	10.2 0.40	4	M20 x 159 ¾ x 6 ¼	248 9.75	337 13.25	219 8.63	353 13.88	127 5.00	11.5 25.4
200	10.2 0.40	4	M20 x 159 ¾ x 6 ¼	267 10.50	353 13.88	238 9.38	368 14.50	127 5.00	12.2 26.8
225	10.2 0.40	4	M20 x 159 ¾ x 6 ¼	295 11.63	373 14.68	267 10.50	387 15.25	127 5.00	13.0 28.7
250	10.2 0.40	4	M22 x 165 ⅞ x 6 ½	326 12.84	427 16.83	301 11.84	441 17.35	180 7.09	30.9 68.1
280	10.2 0.40	4	M22 x 165 ⅞ x 6 ½	359 14.14	458 18.03	334 13.14	470 18.50	180 7.09	35.4 78.0
315	10.2 0.40	4	M22 x 165 ⅞ x 6 ½	394 15.50	489 19.25	368 14.50	500 19.69	180 7.09	38.1 83.9
355	10.2 0.40	4	M27 x 178 1 ⅛ x 7	449 17.67	543 21.38	417 16.42	556 21.89	214 8.42	51.1 112.6

5 Unthreaded through holes for appropriately sized lifting eyes or hooks.
6 Metric bolts/nuts standard, with the exception of North America, South America, and Australian configurations, where imperial sizes are standard.
7 Style 905 couplings when sufficiently pressurized will allow pipe ends to separate to maximum value shown.

5.0 PERFORMANCE

Style 905 – IPS Standard

Pressure Rating: joints made with Style 905 Couplings meet the pressure rating of the HDPE pipe.

IPS Size		PE4710 HDPE Pipe DR[8]													
		7		9		11		13.5		17		21		26	
Nominal Size	Actual O.D.	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load	Max. Joint Work. Press.	Max. Permiss. End Load
inches	inches mm	psi kPa	lb N	psi kPa	lb N	psi kPa	lb N	psi kPa	lb N	psi kPa	lb N	psi kPa	lb N	psi kPa	lb N
2	2.375 60.3	333 2295	1475 6560	250 1725	1110 4940	200 1380	885 3935	160 1100	710 3160	125 860	555 2470	100 690	445 1980	–	–
3	3.500 88.9	333 2295	3205 14255	250 1725	2405 10700	200 1380	1925 8565	160 1100	1540 6850	125 860	1205 5360	100 690	960 4270	–	–
4	4.5 114.3	333 2295	5295 23555	250 1725	3975 17680	200 1380	3180 14145	160 1100	2545 11320	125 860	1990 8850	100 690	1590 7075	–	–
5	5.563 141.3	333 2295	8095 36010	250 1725	6075 27025	200 1380	4860 21620	160 1100	3890 17305	125 860	3040 13525	100 690	2430 10810	–	–
6	6.625 168.3	333 2295	11480 51065	250 1725	8620 38345	200 1380	6895 30670	160 1100	5515 24530	125 860	4310 19170	100 690	3445 15325	80 550	2760 12275
8	8.625 219.1	333 2295	19455 86540	250 1725	14605 64965	200 1380	11685 51975	160 1100	9350 41590	125 860	7305 32495	100 690	5845 26000	80 550	4675 20795
10	10.750 273	333 2295	30225 134450	250 1725	22690 100930	200 1380	18155 80755	160 1100	14520 64590	125 860	11345 50465	100 690	9075 40370	80 550	7260 32295
12	12.750 323.9	333 2295	42515 189115	250 1725	31920 141985	200 1380	25535 113585	160 1100	20430 90875	125 860	15960 70995	100 690	12770 56805	80 550	10215 45440
14	14.000 355.6	333 2295	51260 228015	250 1725	38485 171190	200 1380	30790 136960	160 1100	24630 109560	125 860	19240 85585	100 690	15395 68480	80 550	12315 54780

[8] HDPE pipe conforming to ASTM D3035 and F714 at 73°F/23°C. Reference plastic pipe manufacturer data for derating factors at other temperatures

NOTE

- Victaulic coupling gaskets have been demonstrated to seal under full (29" of Hg/3.4 kPa [absolute]) vacuum requirements. Consult the specific HDPE pipe manufacturer for their recommended limitations regarding maximum vacuum, as well as the effects of temperature and pipe ovality.
- Contact Victaulic for other pipe materials.

5.1 PERFORMANCE

Style 905 – ISO Standard

Pressure Rating: joints made with Style 905 Couplings meet the pressure rating of the HDPE pipe.

ISO Size	PE100 HDPE Pipe SDR[9]													
	7.4		9		11		13.6		17		21		26	
Nominal Size mm	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb	Max. Joint Work. Press. Bar kPa psi	Max. Permiss. End Load N lb
63	25 2500 363	7875 1770	20 2000 290	6295 1415	16 1600 232	5025 1130	12.5 1250 182	3960 890	10 1000 145	3135 705	8 800 116	2515 565	–	–
75	25 2500 363	11165 2510	20 2000 290	8920 2005	16 1600 232	7140 1605	12.5 1250 182	5605 1260	10 1000 145	4450 1000	8 800 116	3560 800	–	–
90	25 2500 363	16080 3615	20 2000 290	12855 2890	16 1600 232	10275 2310	12.5 1250 182	8075 1815	10 1000 145	6430 1445	8 800 116	5140 1155	–	–
110	25 2500 363	24000 5395	20 2000 290	19170 4310	16 1600 232	15345 3450	12.5 1250 182	12030 2705	10 1000 145	9585 2155	8 800 116	7675 1725	–	–
125	25 2500 363	31005 6970	20 2000 290	24775 5570	16 1600 232	19815 4455	12.5 1250 182	15545 3495	10 1000 145	12390 2785	8 800 116	9920 2230	–	–
140	25 2500 363	38875 8740	20 2000 290	31070 6985	16 1600 232	24845 5585	12.5 1250 182	19505 4385	10 1000 145	15525 3490	8 800 116	12435 2795	–	–
160	25 2500 363	50800 11420	20 2000 290	40590 9125	16 1600 232	32470 7300	12.5 1250 182	25465 5725	10 1000 145	20285 4560	8 800 116	16235 3650	6 600 87	12165 2735
180	25 2500 363	64300 14455	20 2000 290	51355 11545	16 1600 232	41080 9235	12.5 1250 182	32225 7245	10 1000 145	25690 5775	8 800 116	20550 4620	6 600 87	15415 3465
200	25 2500 363	79335 17835	20 2000 290	63385 14250	16 1600 232	50710 11400	12.5 1250 182	39765 8940	10 1000 145	31695 7125	8 800 116	25355 5700	6 600 87	19015 4275
225	25 2500 363	100440 22580	20 2000 290	80245 18040	16 1600 232	64190 14430	12.5 1250 182	50355 11320	10 1000 145	40125 9020	8 800 116	32095 7215	6 600 87	24065 5410
250	25 2500 363	123995 27875	20 2000 290	99060 22270	16 1600 232	79245 17815	12.5 1250 182	62165 13975	10 1000 145	49530 11135	8 800 116	39610 8905	6 600 87	29715 6680
280	25 2500 363	155555 34970	20 2000 290	124260 27935	16 1600 232	99420 22350	12.5 1250 182	77975 17530	10 1000 145	62140 13970	8 800 116	49710 11175	6 600 87	37275 8380
315	25 2500 363	196855 44255	20 2000 290	157265 35355	16 1600 232	125820 28285	12.5 1250 182	98685 22185	10 1000 145	78620 17675	8 800 116	62900 14140	6 600 87	47175 10605
355	25 2500 363	249970 56195	20 2000 290	199705 44895	16 1600 232	159760 35915	12.5 1250 182	125330 28175	10 1000 145	99840 22445	8 800 116	79870 17955	6 600 87	59920 13470

[9] HDPE pipe conforming to ISO 4427-2 at 68°F/20°C. Reference plastic pipe manufacturer data for derating factors at other temperatures

NOTES

- Victaulic coupling gaskets have been demonstrated to seal under full (29" of Hg/3.4 kPa [absolute]) vacuum requirements. Consult the specific HDPE pipe manufacturer for their recommended limitations regarding maximum vacuum, as well as the effects of temperature and pipe ovality.
- Contact Victaulic for other pipe materials.

5.2 PERFORMANCE

Style 905 – IPS Standard

Allowable Tensile Load (ATL): joints made with Style 905 Couplings can sustain tensile loads noted below.

IPS Size	Allowable Tensile Load[10] DR						
Nominal Size inches	**7** lb N	**9** lb N	**11** lb N	**13.5** lb N	**17** lb N	**21** lb N	**26** lb N
2	2369 10540	1911 8501	1599 7114	1327 5904	1071 4765	878 3906	–
3	5146 22890	4151 18463	3473 15449	2882 12821	2327 10349	1906 8478	–
4	8507 37839	6861 30520	5741 25539	4765 21195	3846 17108	3151 14016	–
5	12292 54678	10388 46208	8692 38664	7165 31872	5823 25902	4815 21418	–
6	18437 82013	14871 66151	12444 55353	10327 45938	8336 37081	6829 30377	5568 24768
8	31200 138784	25200 112095	21100 93857	17500 77844	14100 62720	11574 51484	9438 41982
10	48500 215738	39100 173926	32800 145901	27200 120991	21900 97416	17900 79623	14662 65220
12	68300 303814	55100 245096	46100 205062	38300 170366	30900 137449	25200 112095	20625 91745
14	72000 320270	64000 284686	55600 247320	46100 205062	37200 165473	30400 135226	24867 110614

[10] Allowable tensile loads (ATL) shown are for straight pulling of unpressurized assembled pipe sections for a maximum period of one half hour at 68°F/20°C. Consult pipe manufacturer's recommendation for ATL reduction factors at elevated temperatures.

5.3 PERFORMANCE

Style 905 – ISO Standard

Allowable Tensile Load (ATL): joints made with Style 905 Couplings can sustain tensile loads noted below.

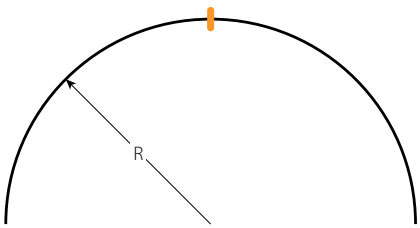
ISO Size	Allowable Tensile Load[11] SDR						
Nominal Size	**7.4**	**9**	**11**	**13.6**	**17**	**21**	**26**
mm	N lb	N lb	N lb	N lb	N lb	N lb	N lb
63	11076 2490	9360 2104	7832 1761	6456 1451	5247 1179	4297 966	–
75	15702 3530	13269 2983	11103 2496	9150 2057	7437 1672	6094 1370	–
90	22616 5084	19112 4297	15992 3595	13182 2864	10713 2408	8776 1973	–
110	33748 7587	28519 6411	23864 5365	19671 4422	15987 3594	13096 2944	–
125	43610 9804	36854 8285	30840 6933	25422 5715	20658 4644	16921 3804	–
140	54678 12292	46208 10388	38664 8692	31872 7165	25902 5823	21218 4770	–
160	71440 16061	60372 13572	50517 11357	41641 9361	33841 7608	27721 6232	22606 5082
180	90415 20326	76407 17177	63934 14373	52698 11847	42827 9628	35083 7887	28611 6432
200	111561 25080	94276 21194	78889 17735	65029 14619	52849 11881	43290 9732	35301 7936
225	141271 31759	119381 26838	99898 22458	82345 18512	66919 15044	54820 12324	44705 10050
250	173925 39100	146791 33000	122770 27600	101419 22800	82292 18500	67613 15200	54713 12300
280	218408 49100	184601 41500	154576 34750	127219 28600	103421 23250	84516 19000	68947 15500
315	276679 62200	233531 52500	195721 44000	161025 36200	130777 29400	107202 24100	87185 19600
355	351410 79000	296695 66700	248565 55880	204617 46000	166363 37400	136116 30600	110761 24900

[11] Allowable tensile loads (ATL) shown are for straight pulling of unpressurized assembled pipe sections for a maximum period of one half hour at 68°F/20°C. Consult pipe manufacturer's recommendation for ATL reduction factors at elevated temperatures.

5.4 PERFORMANCE

Style 905 – IPS Standard

Bend Radius: joints made with Style 905 Couplings can sustain a radius as recommended by the Plastic Pipe Institute (PPI) in the Handbook of PE Pipe (2nd ed, Chapter 7, Table 4).

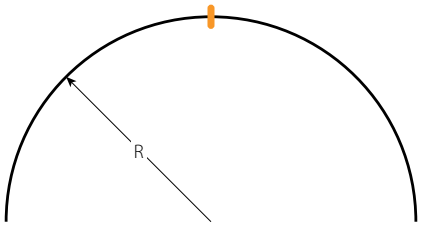


IPS Size	Minimum Recommended Bend Radius DR						
Nominal Size inches	**7** inches mm	**9** inches mm	**11** inches mm	**13.5** inches mm	**17** inches mm	**21** inches mm	**26** inches mm
2	48 1207	48 1207	59 1508	59 1508	64 1629	155 3937	–
3	70 1778	70 1778	88 2223	88 2223	95 2400	95 2400	–
4	90 2286	90 2286	113 2858	113 2858	122 3086	122 3086	–
5	111 2813	111 2813	138 3516	138 3516	149 3797	149 3797	–
6	133 3366	133 3366	166 4207	166 4207	179 4543	179 4543	225 5715
8	173 4382	173 4382	216 5477	216 5477	233 5915	233 5915	293 7442
10	215 5461	215 5461	269 6826	269 6826	290 7372	290 7372	366 9296
12	255 6477	255 6477	319 8096	319 8096	344 8744	344 8744	434 11024
14	280 7112	280 7112	350 8890	350 8890	378 9601	378 9601	476 12090

5.5 PERFORMANCE

Style 905 – ISO Standard

Bend Radius: joints made with Style 905 Couplings can sustain a bending radius as recommended by the Plastic Pipe Institute (PPI) in the Handbook of PE Pipe (2nd ed, Chapter 7, Table 4).



ISO Size	Minimum Recommended Bend Radius SDR						
Nominal Size mm	**7.4** mm inches	**9** mm inches	**11** mm inches	**13.6** mm inches	**17** mm inches	**21** mm inches	**26** mm inches
63	1266 50	1266 50	1582 62	1582 62	1709 67	4090 161	–
75	1507 59	1507 59	1884 74	1884 74	2035 80	4877 192	–
90	1809 71	1809 71	2261 89	2261 89	2442 96	2442 96	–
110	2210 87	2210 87	2762 109	2762 109	2983 117	2983 117	–
125	2512 99	2512 99	3140 124	3140 124	3391 134	3391 134	–
140	2813 111	2813 111	3516 138	3516 138	3797 149	3797 149	–
160	3215 127	3215 127	4019 158	4019 158	4340 171	4340 171	5461 215
180	3617 142	3617 142	4521 178	4521 178	4883 192	4883 192	6147 242
200	4018 158	4018 158	5022 198	5022 198	5424 214	5424 214	6833 269
225	4521 178	4521 178	5652 223	5652 223	6104 240	6104 240	7671 302
250	5000 197	5000 197	6250 246	6250 246	6750 266	6750 266	8534 336
280	5600 220	5600 220	7000 276	7000 276	7560 298	7560 298	9550 376
315	6300 248	6300 248	7875 310	7875 310	8505 335	8505 335	10744 423
355	7100 280	7100 280	8875 349	8875 349	9585 377	9585 377	12116 477

6.0 NOTIFICATIONS

⚠ 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, foot protection, and hearing protection.**

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

7.0 REFERENCE MATERIALS

I-900: HDPE Products Installation and Assembly Manual
I-905.REUSE: Victaulic Style 905 Reuse Instructions
IT-905: Style 905 Installation Tag
IT-905.FS: Style 905 with Flush-Seal™ Gasket Installation Instructions
05.01: Gasket Selection Guide
19.09: Style 908 Coupling for Double Grooved HDPE pipe
19.10: Style 907 Transition Coupling for HDPE-to-Steel
19.11: HDPE Plain End Fittings
19.12: Style 904 Flange Adapter for HDPE-to-Flanged Pipe
29.01: Terms and Conditions/Warranty
I-ENDCAP: Victaulic End Caps Installation Instructions

