

Roust-A-Bout Coupling for Plain End Pipe

Style 99



1 – 12"/DN25 – DN300 sizes



14 – 18"/DN350 – DN450 sizes

1.0 PRODUCT DESCRIPTION

Available Sizes:

- 1 – 18"/DN25 – DN450

Application:

- Joins plain and beveled end pipe and Victaulic plain end fittings
- Pipe is secured together by heavy jaws, which are set into the housing

Pipe Materials:

- Carbon steel
- Stainless steel
- Aluminum

NOTE:

- Roust-A-Bout Style 99 couplings are not designed for use on plastic pipe, pipe with brittle linings, cast or ductile iron pipe, nor any pipe with a surface hardness greater than 150 Brinell.

2.0 CERTIFICATION/LISTINGS



- Download [publication 10.01](#) for Fire Protection Certifications/Listings Reference Guide.

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

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

3.0 SPECIFICATIONS – MATERIAL

Housing: Ductile iron conforming to ASTM A536, Grade 65-45-12. Ductile iron conforming to ASTM A395, Grade 65-45-15, is available upon special request.

Housing Coating:

Orange enamel.

Optional: Hot dipped galvanized.

Optional: Contact Victaulic with your requirements for other coatings.

Jaws:

Carbon steel, case hardened, electroplated, except sizes 1"/DN25, DN65 and DN125, which utilize stainless steel, Type 416, hardened.

Gaskets: (specify choice¹)

Grade “E” EPDM

EPDM (Green color code). Temperature range –30°F to +230°F/–34°C to +110°C. 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 ANSI/NSF 61 for cold +73°F/+23°C and hot +180°F/+82°C potable water service and ANSI/NSF 372. **NOT COMPATIBLE FOR USE WITH PETROLEUM SERVICES OR STEAM SERVICES.**

Grade “T” Nitrile

Nitrile (Orange color code). Temperature range –20°F to +180°F/–29°C to +82°C. 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.**

Others

For alternate gasket selection, reference [publication 05.01](#): Victaulic Seal Selection Guide.

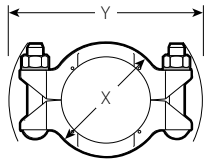
¹ Services listed are General Service Recommendations only. It should be noted that there are services for which these gaskets are not recommended. Reference should always be made to the latest [Victaulic Seal Selection Guide](#) for specific gasket service recommendations and for a listing of services which are not recommended.

Bolts/Nuts:

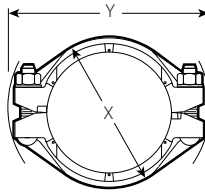
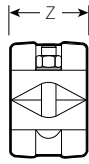
Standard: Carbon steel oval neck track bolts meeting the mechanical property requirements of ASTM A449 (imperial) and ISO 898-1 (metric) Class 9.8 (M10-M16) and Class 8.8 (M20 and greater). Carbon steel hex nuts meeting the mechanical property requirements of ASTM A563 Grade B (imperial – heavy hex nuts) 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).

Washers (sizes 6"/DN150 and larger): Hardened steel washers meeting ASTM F436 Type 3 (weathering steel).

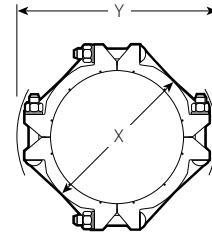
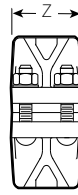
4.0 DIMENSIONS



1 – 6"/DN25 – DN150 sizes



8 – 12"/DN200 – DN300 sizes



14 – 18"/DN350 – DN450 sizes



Size		Bolt/Nut ²		Dimensions			Aprox. Weight lb kg
Nominal inches DN	Actual Outside Diameter inches mm	Qty.	Size inches	X inches mm	Y inches mm	Z inches mm	
1 DN25	1.315 33.7	2	3/8 x 2	2.63 67	4.25 108	2.25 57	1.7 0.8
1 1/2 DN40	1.900 48.3	2	1/2 x 2 1/2	3.25 83	5.50 140	2.88 73	3.6 1.6
2 DN50	2.375 60.3	2	5/8 x 3 1/4	3.75 95	6.75 171	3.38 86	5.3 2.4
2 1/2	2.875 73.0	2	5/8 x 3 1/4	4.25 108	7.13 181	3.38 86	5.7 2.5
DN65	3.000 76.1	2	1/2 x 2 3/4	4.75 121	6.25 159	2.75 70	4.4 2.0
3 DN80	3.500 88.9	2	3/4 x 4 1/4	5.00 127	8.50 216	3.38 86	8.7 3.9
3 1/2 DN90	4.000 101.6	2	3/4 x 4 1/4	5.50 140	9.25 235	3.63 92	10.6 4.8
4 DN100	4.500 114.3	2	3/4 x 4 1/4	6.13 156	10.00 254	4.00 102	12.8 5.8
DN125	5.500 139.7	2	3/4 x 5	7.88 200	10.75 260	3.25 83	9.0 4.1
5	5.563 141.3	2	7/8 x 5	7.25 184	11.38 289	4.38 111	17.3 7.8
6 DN150	6.625 168.3	2	1 x 6 ³	8.50 216	13.38 340	4.38 111	23.2 10.5
	6.500 165.1	2	1 x 6 ³	8.38 213	13.25 337	4.38 111	22.2 10.1
8 DN200	8.625 219.1	4	7/8 x 5 ³	10.88 276	14.38 365	5.00 127	37.2 16.9
10 DN250	10.750 273.0	4	7/8 x 5 ³	13.38 340	16.38 416	5.00 127	48.2 21.9
12 DN300	12.750 323.9	4	1 x 6 1/2 ³	15.50 394	19.63 499	5.13 130	60.0 27.2
14 DN350	14.000 355.6	8	1 x 6 1/2 ³	16.75 425	20.75 527	5.38 137	89.0 40.4
16 DN400	16.000 406.4	8	1 x 6 1/2 ³	19.00 483	22.63 575	5.38 137	105.0 47.6
18 DN450	18.000 457.0	8	1 x 6 1/2 ³	21.00 533	23.50 597	5.38 137	125.0 56.7

² Metric thread size bolts (plated) are available (color coded) for all coupling sizes upon request. Contact Victaulic for details.

³ Supplied with flat washers.

5.0 PERFORMANCE

Pressure Ratings and End Loads Carbon Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
1 DN25	1.315 33.7	0.179 4.55	80	35 48	—	—
		0.133 3.38	40		600 4137	800 3560
		0.109 2.77	10		600 4137	800 3560
		0.065 1.65	5		400 2758	550 2450
1½ DN40	1.900 48.3	0.200 5.08	80	60 81	750 5171	2100 9345
		0.145 3.68	40		750 5171	2100 9345
		0.109 2.77	10		600 4137	1700 7565
		0.065 1.65	5		400 2758	1100 4895
2 DN50	2.375 60.3	0.218 5.54	80	150 203	750 5171	3300 14685
		0.154 3.91	40		750 5171	3300 14685
		0.109 2.77	10		400 2758	1800 8010
		0.065 1.65	5		200 1379	900 4005
2½	2.875 73.0	0.276 7.01	80	150 203	600 4137	3890 17310
		0.203 5.16	40		600 4137	3890 17310
		0.120 3.05	10		300 2068	1900 8455
		0.083 2.11	5		150 1034	1000 4450
3 DN80	3.500 88.9	0.300 7.62	80	200 271	600 4137	5770 25675
		0.216 5.49	40		600 4137	5770 25675
		0.120 3.05	10		225 1551	2160 9610
		0.083 2.11	5		125 862	1200 5340

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.0 PERFORMANCE (Continued)

Pressure Ratings and End Loads Carbon Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
3½ DN90	4.000 101.6	0.318 8.08	80	200 271	500 3447	6280 27945
		0.226 5.74	40		500 3447	6280 27945
		0.120 3.05	10		200 1379	2500 11125
		0.083 2.11	5		100 689	1250 5565
4 DN100	4.500 114.3	0.337 8.56	80	200 271	450 3103	7155 31840
		0.237 6.02	40		450 3103	7155 31840
		0.120 3.05	10		175 1207	2800 12460
		0.083 2.11	5		60 414	950 4230
5	5.563 141.3	0.375 9.53	80	250 339	350 2413	8500 37825
		0.258 6.55	40		350 2413	8500 37825
		0.134 3.40	10		150 1034	3600 16020
		0.109 2.77	5		75 517	1800 8010
6 DN150	6.625 168.3	0.432 10.97	80	250 339	300 2068	10340 46015
		0.280 7.11	40		300 2068	10340 46015
		0.134 3.40	10		100 689	3500 15575
		0.109 2.77	5		75 517	2600 11570
6.500 165.1	6.500 165.1	0.250 6.35	—	250 339	300 2068	9955 44300
		0.200 5.08	—		175 1207	6000 26700
		0.150 3.81	—		100 689	3500 15575

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

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- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.0 PERFORMANCE (Continued)

Pressure Ratings and End Loads Carbon Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
8 DN200	8.625 219.1	0.322 8.18	40	250 339	250 1724	14600 64970
		0.277 7.04	30		200 1379	11700 52065
		0.148 3.76	10		100 689	6000 26700
		0.109 2.77	5		50 345	3000 13350
10 DN250	10.750 273.0	0.365 9.27	40	300 407	250 1724	22700 101015
		0.307 7.80	30		175 1207	15900 70755
		0.165 4.19	10		75 517	6800 30260
		0.134 3.40	5		50 345	4500 20025
12 DN300	12.750 323.9	0.375 9.53	STD	350 475	250 1724	31900 141955
		0.330 8.38	30		150 1034	19100 84995
		0.180 4.57	10		100 689	12700 56515
		0.165 4.19	5		75 517	9500 42275
14 DN350	14.000 355.6	0.375 9.53	STD	350 475	200 1379	30800 137060
16 DN400	16.000 406.4	0.375 9.53	STD	350 475	150 1034	30200 134390
18 DN450	18.000 457.2	0.375 9.53	STD	+	+	+

+ Contact Victaulic for more details.

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.1 PERFORMANCE

Pressure Ratings and End Loads Stainless Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
1 DN25	1.315 33.7	0.133 3.38	40	35 48	600 4137	800 3560
		0.109 2.77	10		400 2758	550 2450
		0.065 1.65	5		250 1724	350 1555
1½ DN40	1.900 48.3	0.145 3.56	40	60 81	500 3447	1400 6230
		0.109 2.77	10		400 2758	1100 4895
		0.065 1.65	5	N/R	N/R	N/R
2 DN50	2.375 60.3	0.154 3.91	40	150 203	500 3447	2200 9790
		0.109 2.77	10		400 2758	1800 8010
		0.065 1.65	5	N/R	N/R	N/R
2½	2.875 73.0	0.203 5.16	40	150 203	400 2758	2500 11125
		0.120 5.16	10		250 1724	1500 6675
		0.083 2.11	5	N/R	N/R	N/R
3 DN80	3.500 88.9	0.216 5.49	40	200 271	400 2758	3800 16910
		0.120 3.05	10		200 1379	1900 8455
		0.083 2.11	5	N/R	N/R	N/R

N/R = Not recommended

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.19.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.1 PERFORMANCE (Continued)

Pressure Ratings and End Loads Stainless Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
3½ DN90	4.000 101.6	0.226 5.74	40	200 271	300 2068	3700 16465
		0.120 3.05	10		150 1034	1900 8455
		0.083 2.11	5	N/R	N/R	N/R
4 DN100	4.500 114.3	0.237 6.02	40	200 271	250 1724	3900 17355
		0.120 3.05	10		80 552	1300 5785
		0.083 2.11	5	N/R	N/R	N/R
5	5.563 141.3	0.258 6.55	40	250 339	200 1379	4800 21360
		0.134 3.40	10		75 517	1800 8010
		0.109 2.77	5	N/R	N/R	N/R
6 DN150	6.625 168.3	0.280 7.11	40	250 339	200 1379	6800 30260
		0.134 3.40	10		75 517	2600 11570
		0.109 2.77	5	N/R	N/R	N/R
	6.500 165.1	0.280 7.11	40	250 339	200 1379	6800 30260
		0.134 3.40	10		75 517	2600 11570
		0.109 2.77	5	N/R	N/R	N/R

N/R = Not recommended

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.19.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.1 PERFORMANCE (Continued)

Pressure Ratings and End Loads Stainless Steel Pipe

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
8 DN200	8.625 219.1	0.322 8.18	40	250 339	200 1379	11000 48950
		0.148 3.76	10		75 517	4400 19580
		0.109 2.77	5		25 172	1460 6495
10 DN250	10.750 273.0	0.365 9.27	40	300 407	100 689	9000 40050
		0.165 4.19	10		50 345	4500 20025
		0.134 3.40	5		25 172	2250 10010
12 DN300	12.750 323.9	0.406 10.31	40	350 475	100 689	12750 56735
		0.180 4.67	10		50 345	6400 28480
		0.156 3.96	5		25 172	3200 14240

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.19.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

NOTES

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- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.2 PERFORMANCE

Pressure Ratings and End Loads Aluminum Pipe⁷

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
1 DN25	1.315 33.7	0.179 4.55	80	N/R	N/R	N/R
		0.133 3.38	40	35 48	600 4137	800 3560
		0.109 2.77	10		300 2068	400 1780
		0.065 1.65	5	100 689	135 601	
1½ DN40	1.900 48.3	0.200 5.08	80	60 81	500 3447	1400 6230
		0.145 3.56	40		400 2758	1100 4895
		0.109 2.77	10		300 2068	825 3671
		0.065 1.65	5	N/R	N/R	N/R
2 DN50	2.375 60.3	0.218 5.54	80	150 203	400 2758	1800 8010
		0.154 3.91	40		300 2068	1300 5785
		0.109 2.77	10		200 1379	900 4005
		0.065 1.65	5	N/R	N/R	N/R
2½	2.875 73.0	0.276 7.01	80	150 203	350 2413	2200 9790
		0.203 5.16	40		275 1896	1725 7676
		0.120 5.16	10		150 1034	1000 4450
		0.083 2.11	5	N/R	N/R	N/R

N/R = Not recommended

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

⁷ Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

NOTES

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5.2 PERFORMANCE (Continued)

Pressure Ratings and End Loads Aluminum Pipe⁷

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
3 DN80	3.500 88.9	0.300 7.62	80	200 271	300 2068	2880 12816
		0.216 5.49	40		200 1379	1920 8544
		0.120 3.05	10		100 689	960 4272
		0.083 2.11	5	N/R	N/R	N/R
3½ DN90	4.000 101.6	0.318 8.08	80	200 271	250 1724	3100 13795
		0.226 5.74	40		200 1379	2500 11125
		0.120 3.05	10		100 689	1250 5563
		0.083 2.11	5	N/R	N/R	N/R
4 DN100	4.500 114.3	0.337 8.56	80	200 271	200 1379	3200 14240
		0.237 6.02	40		150 1034	2400 10680
		0.120 3.05	10		50 345	800 3560
		0.083 2.11	5	N/R	N/R	N/R
5	5.563 141.3	0.375 9.53	80	250 339	150 1034	3600 16020
		0.258 6.55	40		100 689	2400 10680
		0.134 3.40	10		50 345	1200 5340
		0.109 2.77	5	N/R	N/R	N/R

N/R = Not recommended

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

⁷ Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

5.2 PERFORMANCE (Continued)

Pressure Ratings and End Loads Aluminum Pipe⁷

Size		Pipe Wall Thickness ⁴		Required Bolt Torque ⁵ Lb • Ft. N • m	Maximum	
Nominal inches DN	Actual Outside Diameter inches mm	inches mm	Schedule Number		Working Pressure ⁶ psi kPa	End Load ⁶ lb N
6 DN150	6.625 168.3	0.432 10.97	80	250 339	150 1034	5200 23140
		0.280 7.11	40		100 689	3500 15575
		0.134 3.40	10		50 345	1750 7788
		0.109 2.77	5		35 241	1225 5451
8 DN200	8.625 219.1	0.322 8.18	40	250 339	150 1034	9000 40050
		0.277 7.04	30		100 689	6000 26700
		0.250 6.35	20		75 517	4500 20025
		0.148 3.76	10		50 345	3000 13350
10 DN250	10.750 273.0	0.356 9.27	40	300 407	100 698	9000 40050
		0.307 7.80	30		75 517	6300 28035
		0.250 6.35	20		50 345	4500 20025
		0.165 4.19	10		25 172	2250 10013
12 DN300	12.750 323.9	0.406 10.31	40	300 407	100 689	12800 56960
		0.330 8.38	30		75 517	9500 42275
		0.250 6.35	20		50 345	6000 26700
		0.180 4.67	10		25 172	3150 14018

⁴ Pipe wall thickness schedule as established in ASME/ANSI B36.10.

⁵ Bolt torque required for installing Victaulic plain end couplings to achieve Maximum Working Pressure and Maximum End Loads listed.

⁶ Working Pressure and End Load are total, from all internal and external loads, based on coupling properly assembled, with bolts fully torqued to listed specifications, on plain end or beveled end standard weight (ANSI) steel pipe and Victaulic plain end fittings. Couplings are designed to be used with plain end pipe and Victaulic plain end fittings only.

⁷ Aluminum Pipe – Alloy 6063-T6 or 6061-T6 in Schedule 80 and 40; Alloy 6063-T6 in Schedule 30, 20, 10 and 5.

NOTES

- Torque ratings must be applied at installation.
- *Roust-A-Bout* couplings, when sufficiently pressurized, will allow pipe to separate slightly as grips set into pipe. For properly assembled and torqued couplings, this separation should not exceed ¼" / 6.4 mm. This should be considered for installations in tightly confined areas. Style 99 couplings are not designed to provide linear or angular movement.
- *Roust-A-Bout* Style 99 couplings are designed for use with plain end or beveled end pipe and Victaulic plain end fittings only.
- WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1½ times the figures shown.

6.0 NOTIFICATIONS

⚠ WARNING

- Style 99 *Roust-A-Bout* couplings must be assembled with nuts tightened to full torque specifications.

⚠ WARNING



- Read and understand all instructions before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Depressurize and drain the piping system before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Wear safety glasses, hardhat, and foot protection.

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

7.0 REFERENCE MATERIALS

[05.01: Victaulic Seal Selection Guide](#)

[26.01: Victaulic Design Data](#)

[29.01: Victaulic Terms and Conditions/Warranty](#)

[I-100: Victaulic Field Installation Handbook](#)

User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, and the applicable building codes and related regulations as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company's standard conditions of sale, installation guide, or this disclaimer.

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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.

Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of the product you are installing. Handbooks are included with each shipment of Victaulic products, providing complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

Warranty

Refer to the Warranty section of the current Price List or contact Victaulic for details.

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