




1.0 PRODUCT DESCRIPTION

Available Sizes

- AGS Coupling: 14 – 50"/DN350 – DN1250, Style W77 (nominal pipe size – 12" thru 48")
- AGS Coupling: 52 – 100"/DN1350 – DN2500, Style W77B (nominal pipe size – 50" thru 96")
- AGS Rings: 14 – 100"/DN350 – DN2500

Coupling Maximum Allowable Working Pressure (For Carbon Steel Pipe)

- 14 – 24"/DN350 – DN600: 350 psi/2413 kPa
- 26 – 42"/DN650 – DN1050: 300 psi/2068 kPa
- 44 – 50"/DN1100 – DN1250: 232 psi/1599 kPa
- 52 – 100"/DN1300 – DN2500: 250 psi/1724 kPa

Application

- Provide limited linear and angular pipe movement at the pipe joint that can be used to compensate for thermal growth of piping systems, vibration attenuation, seismic, differential settlement and other applications requiring flexibility.

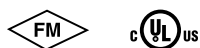
Function

- Unique wedge-shaped key profile increases allowable pipe end separation, resulting in easier assembly.
- Sizes 26" and above feature lifting lugs integrated onto the housings to promote ease handling during installation of the coupling housing.

NOTES

- Style W77 AGS couplings are provided with FlushSeal® gaskets for a variety of services. Please specify gasket grade when ordering. Please refer to [publication 05.01](#) for gasket service ratings.
- Style W77 AGS Flexible Couplings can also be used on direct roll groove pipe. See [publication 20.03](#).
- Optional ring configurations available. Contact Victaulic for additional information.

2.0 CERTIFICATION/LISTINGS



NOTES

- See [publication 02.06](#): Victaulic Potable Water Approvals ANSI/NSF for potable water approvals if applicable.
- Refer to [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.

3.0 SPECIFICATIONS – MATERIAL

Vic-Rings: Victaulic Type "D" Vic-Rings.

Material:

- ☐ Standard: Carbon Steel to ASTM A 105 or equivalent.
- ☐ Optional: ASTM A105N (Specify at time of order).
- ☐ Optional: Other materials available upon request contact Victaulic for details.

Housing: (specify choice)

- ☐ Standard: Ductile iron conforming to ASTM A536, Grade 65-45-12.
- ☐ Optional: Ductile iron conforming to ASTM A395, Grade 65-45-15.

Housing Coating: (specify choice)

- ☐ Standard: Orange enamel.
- ☐ Optional: Hot dipped galvanized.
- ☐ Optional: Liquid Epoxy conforming with AWWA C210.

NOTE

- For additional coating options contact Victaulic.

Coupling Gasket: (specify choice¹)

☐ Victaulic Grade "E" FlushSeal™ EPDM

EPDM (Green stripe 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.

☐ Victaulic Grade "T" FlushSeal™ 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.

☐ Victaulic Grade "L" FlushSeal™ Silicone

Silicone (Red color code). Temperature range –30°F to +350°F/–34°C to +177°C. May be specified for dry heat, air without hydrocarbons to +350°F/+177°C and certain chemical services.

☐ Others

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

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 Seal Selection Guide](#) for specific gasket service guidelines and for a listing of services which are not compatible.

3.0 SPECIFICATIONS – MATERIAL (CONTINUED)

Bolts/Nuts: (specify choice²)

- ☐ Standard: 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). Sizes 52 – 100" use A193 Grade B7 studs. 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 FE/ZN5, finish Type III (imperial) or Type II (metric).
- ☐ Optional (14 – 50"): Stainless steel oval neck track bolts or studs meeting the mechanical property requirements of ASTM A193 Grade B8M, Class 2 (316 stainless steel). Stainless steel heavy hex nuts meeting the mechanical property requirements of ASTM A194 Grade 8M (316 stainless steel) with galling reducing coating.
- ☐ Optional (all sizes): Super duplex stainless steel studs per ASTM A1082 UNS 32750. Super duplex stainless steel heavy hex nuts per ASTM A1082 UNS 32750.

² Optional bolts/nuts are available in imperial sizes only

Washers For 26 – 100"/DN650 – DN2500 sizes:

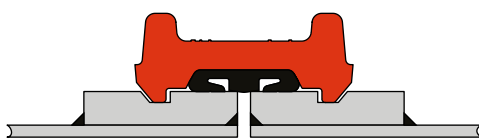
- ☐ Standard: Plated carbon steel, flat. SAE high strength conforming to ASTM F436 or high strength stainless steel.
- ☐ Optional(14 – 50"): High strength 316 stainless steel
- ☐ Optional (all sizes): Super duplex stainless steel

NOTES

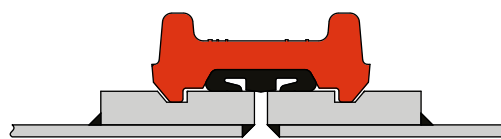
- For alternate hardware specifications not listed, contact Victaulic
- For sizes 52" and larger, couplings are supplied with studs. For couplings supplied with studs double the quantity shown for required number of nuts and washers.

3.1 SPECIFICATIONS – LINING OPTIONS

Unlined Services*



Flush

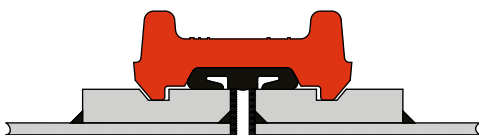


Overhung

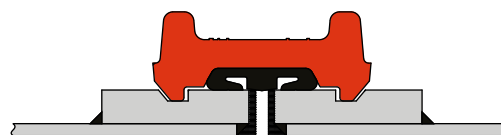
NOTE

- Type D Vic-Ring Configuration Shown

Abrasion Services



Rubber-Lined Flush



Rubber-Lined Overhung



Rubber Lined with Protective Bumper- Flush



Rubber Lined with Protective Bumper- Overhung



Chromium Carbide Overlay (CCO)- Overhung

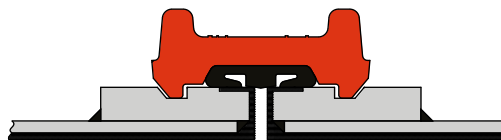
NOTE

- Type D Vic-Ring Configuration Shown

Abbrasion and Corrosion Services



Rubber-Lined Flush



Rubber lined- Overhung

NOTE

- Type D Vic-Ring Configuration Shown

* Suitable for use on abrasive and non-abrasive services.

Alternate Configurations Available Upon Request



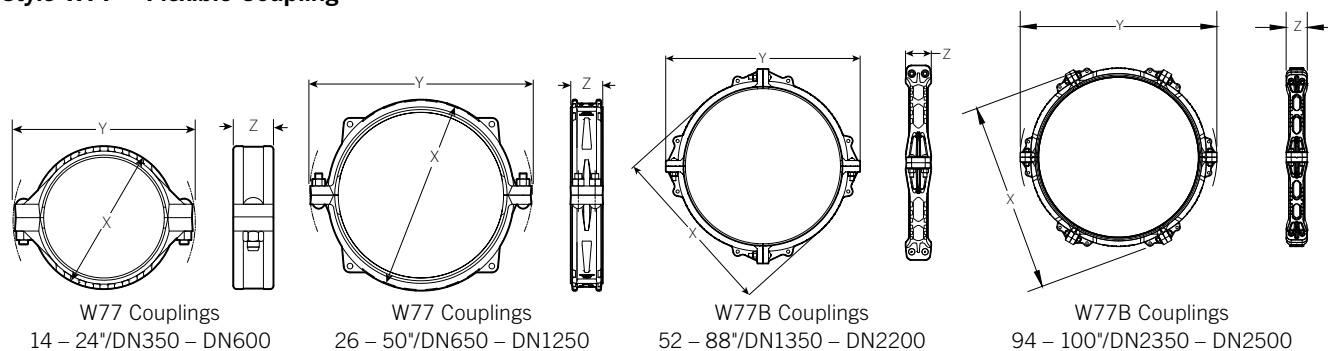
Unlined Type B

NOTE

- Type B Vic-Ring Configuration Shown

4.0 DIMENSIONS

Style W77 – Flexible Coupling



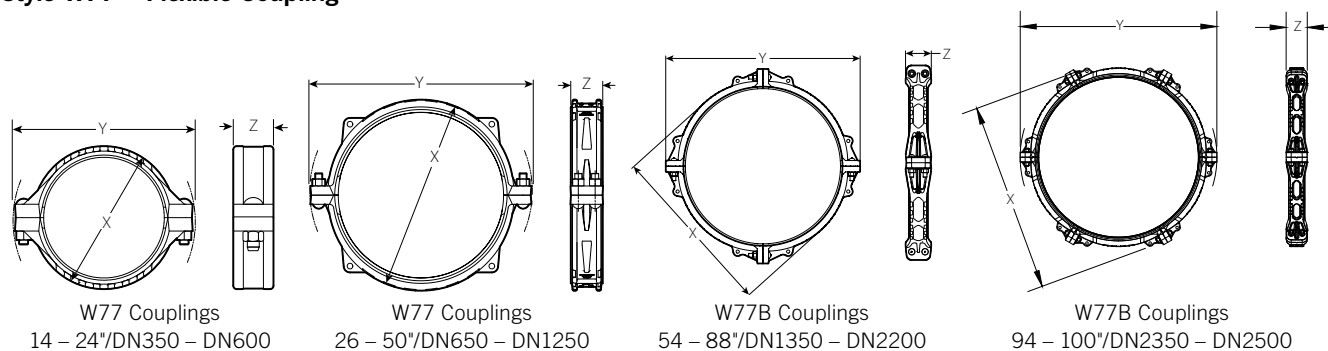
Size		Pipe End Separation	Deflection from Centerline		Bolt/Nut		Dimensions			Coupling Weight
Nominal Pipe Size inches DN	Vic-Ring/ Coupling Size inches mm	Nominal inches mm	Per Coupling Degrees	Pipe in/ft mm/m	Required Qty.	Size inches mm	X inches mm	Y inches mm	Z inches mm	Approx. (Each) lb kg
12 DN300	14.000 355.6	0.13 – 0.31 3.3 – 7.9	0.73	0.154 12.86	2	1 x 5 1/2	16.25 412	20.88 530	4.75 120	52.0 23.5
14 DN350	16.000 406.4	0.13 – 0.31 3.3 – 7.9	0.64	0.135 11.25	2	1 x 5 1/2	18.50 470	22.88 582	4.88 124	62.0 28.0
16 DN400	18.000 457.2	0.13 – 0.31 3.3 – 7.9	0.57	0.120 10.00	2	1 x 5 1/2	20.63 524	24.88 632	4.88 124	67.0 30.5
18 DN450	20.000 508.0	0.13 – 0.31 3.3 – 7.9	0.51	0.108 9.00	2	1 1/8 x 5 1/2	22.88 582	28.00 712	4.88 124	88.0 40.0
20 DN500	22.000 558.8	0.13 – 0.31 3.3 – 7.9	0.46	0.098 8.18	2	1 1/8 x 6	25.00 636	30.50 774	4.88 124	102.0 46.5
22 DN550	24.000 609.6	0.13 – 0.31 3.3 – 7.9	0.42	0.090 7.50	2	1 1/8 x 5 1/2	27.50 698	32.25 820	4.88 124	115.0 52.0
24 DN600	26.000 660.4	0.15 – 0.53 3.8 – 13.5	0.83	0.175 14.62	4	1 1/8 x 6	30.75 782	35.75 908	6.00 152	215.0 97.5
26 DN650	28.000 711.2	0.15 – 0.53 3.8 – 13.5	0.77	0.163 13.57	4	1 1/8 x 6	32.75 832	37.75 958	6.00 152	230.0 104.5
28 DN700	30.000 762.0	0.15 – 0.53 3.8 – 13.5	0.72	0.152 12.67	4	1 1/4 x 7	34.50 876	40.25 1022	6.00 152	240.0 109.0
30 DN750	32.000 812.8	0.15 – 0.53 3.8 – 13.5	0.68	0.143 11.87	4	1 1/4 x 7	36.75 934	42.25 1074	6.00 152	255.0 115.5
32 DN800	34.000 863.6	0.15 – 0.53 3.8 – 13.5	0.64	0.134 11.18	4	1 1/4 x 7	38.75 984	44.25 1124	6.00 152	275.0 124.5
34 DN850	36.000 914.4	0.15 – 0.53 3.8 – 13.5	0.60	0.127 10.56	4	1 1/4 x 7	40.75 1036	46.25 1174	6.00 152	300.0 136.0
36 DN900	38.000 965.2	0.15 – 0.53 3.8 – 13.5	0.57	0.120 10.00	4	1 1/4 x 7	42.75 1086	48.25 1226	6.00 152	325.0 147.5
38 DN950	40.000 1016.0	0.21 – 0.59 5.3 – 15.0	0.54	0.114 9.50	4	1 1/2 x 8	44.50 1130	51.50 1308	6.75 172	375.0 170.0
40 DN1000	42.000 1066.8	0.21 – 0.59 5.3 – 15.0	0.51	0.109 9.05	4	1 1/2 x 8	46.50 1182	53.00 1346	6.75 172	375.0 170.0
42 DN1050	44.000 1117.6	0.21 – 0.59 5.3 – 15.0	0.49	0.104 8.64	4	1 1/2 x 8	49.00 1244	55.00 1398	6.75 172	425.0 193.0
44 DN1100	46.000 1168.4	0.21 – 0.59 5.3 – 15.0	0.47	0.099 8.26	4	1 1/2 x 8	51.00 1296	57.00 1448	6.75 172	450.0 204.0

NOTES

- The Style W77 AGS Vic-Ring system is available for pipe sizes ranging from 12 – 72"/DN300 – DN1800. The coupling used to join these pipes will always be the next largest size (ex: 12"/DN300 pipe requires the use of 14"/DN350 coupling). For pipe sizes ranging from 74 – 96"/DN1850 – DN2500, the coupling used to join these pipe sizes will always be 4" larger than the nominal pipe diameter. (ex: 84"/DN2100 requires the use of 88"/DN2200 coupling.) The larger size is needed to allow for the extra outside pipe diameter the AGS ring adds to the pipe.
- For pipe sizes larger than 96"/DN2400, contact Victaulic.

4.0 DIMENSIONS (CONTINUED)

Style W77 – Flexible Coupling



Size		Pipe End Separation	Deflection from Centerline		Bolt/Nut		Dimensions			Coupling Weight
Nominal Pipe Size inches DN	Vic-Ring/ Coupling Size inches mm	Nominal inches mm	Per Coupling Degrees	Pipe in/ft mm/m	Required Qty.	Size inches mm	X inches mm	Y inches mm	Z inches mm	Approx. (Each) lb kg
46 DN1150	48.000 1219.2	0.21 – 0.59 5.3 – 5.0	0.45	0.095 7.92	4	1 ½ x 8	53.00 1346	59.00 1498	6.75 172	450.0 204.0
48 DN1200	50.000 1270.0	0.21 – .59 5.3 – 15.0	0.43	0.091 7.60	4	1 ½ x 8	55.50 1410	61.50 1562	10.25 260	575.0 261.0
50 DN1250	52.000 1320.8	0.28 – 0.66 7.1 – 16.8	0.41	0.088 7.31	8	1 ½ x 9 ½	58.50 1486	67.50 1714	10.25 260	975.0 442.5
52 DN1300	54.000 1371.6	0.28 – 0.66 7.1 – 16.8	0.40	0.084 7.04	8	1 ½ x 9 ½	60.50 1536	69.50 1766	10.25 260	1000.0 453.5
54 DN1350	56.000 1422.4	0.28 – 0.66 7.1 – 16.8	0.38	0.081 6.79	8	1 ½ x 9 ½	62.50 1588	71.50 1816	10.25 260	1025.0 465.0
56 DN1400	58.000 1473.2	0.28 – 0.66 7.1 – 16.8	0.37	0.079 6.55	8	1 ½ x 9 ½	64.50 1638	73.50 1866	10.25 260	1050.0 476.5
58 DN1450	60.000 1524.0	0.28 – 0.66 7.1 – 16.8	0.36	0.076 6.33	8	1 ½ x 9 ½	66.50 1690	75.50 1918	10.25 260	1075.0 487.5
60 DN1500	62.000 1574.8	0.28 – 0.66 7.1 – 16.8	0.35	0.074 6.13	8	1 ½ x 9 ½	69.00 1752	78.50 1994	10.50 266	1150.0 521.5
62 DN1550	64.000 1625.6	0.28 – 0.66 7.1 – 16.8	0.34	0.071 5.94	8	1 ½ x 9 ½	71.00 1804	80.50 2044	10.50 266	1175.0 533.0
64 DN1600	66.000 1676.4	0.28 – 0.66 7.1 – 16.8	0.33	0.069 5.76	8	1 ½ x 9 ½	73.00 1854	82.50 2096	10.50 266	1200.0 544.5
66 DN1650	68.000 1727.2	0.28 – 0.66 7.1 – 16.8	0.32	0.067 5.59	8	1 ½ x 9 ½	75.50 1918	84.50 2146	10.50 266	1275.0 578.5
68 DN1700	70.000 1778.0	0.28 – 0.66 7.1 – 16.8	0.31	0.065 5.43	8	1 ½ x 9 ½	78.00 1982	87.50 2222	10.50 266	1350.0 612.5
70 DN1750	72.000 1828.8	0.28 – 0.66 7.1 – 16.8	0.30	0.063 5.28	8	1 ½ x 9 ½	80.00 2032	89.50 2274	10.50 266	1425.0 646.5
72 DN1800	74.000 1879.6	0.28 – 0.66 7.1 – 16.8	0.29	0.062 5.14	8	1 ½ x 9 ½	83.50 2120	92.00 2336	10.38 264	1750.0 794.0
74 DN1850	78.000 1981.2	0.28 – 0.66 7.1 – 16.8	0.27	0.058 4.87	8	1 ¾ x 12	86.00 2184	97.50 2476	12.00 304	1900.0 862.0
80 DN2000	84.000 2133.6	0.28 – 0.66 7.1 – 16.8	0.25	0.054 4.52	8	1 ¾ x 12	92.50 2350	103.50 2628	12.50 318	2400.0 1088.5
84 DN2100	88.000 2235.2	0.28 – 0.66 7.1 – 16.8	0.24	0.052 4.32	8	1 ¾ x 12	96.50 2452	107.50 2730	12.25 312	2175.0 986.5
90 DN2250	94.000 2387.6	0.00 – 0.90 0.0 – 22.9	0.54	0.115 9.57	12	1 ¾ x 12	104.50 2654	115.50 2934	13.25 336	3775.0 1712.5
96 DN2400	100.000 2540.0	0.00 – 0.90 0.0 – 22.9	0.51	0.108 9.00	12	1 ¾ x 12	110.50 2806	121.50 3086	13.25 336	3925.0 1780.5

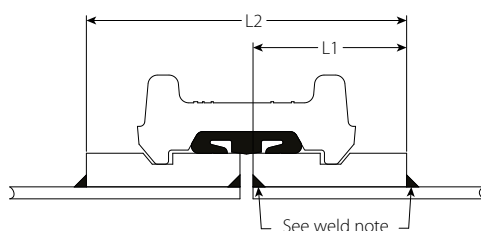
For coupling sizes larger than 100"/DN2500, contact Victaulic.

NOTES

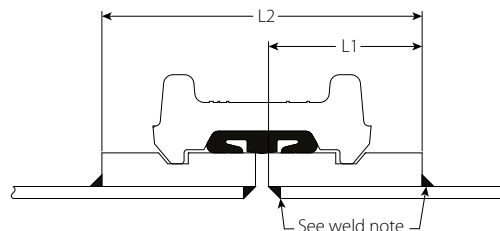
- The Style W77 AGS Vic-Ring system is available for pipe sizes ranging from 12 – 72"/DN300 – DN1800. The coupling used to join these pipes will always be the next largest size (ex: 12"/DN300 pipe requires the use of 14"/DN350 coupling). For pipe sizes ranging from 74 – 96"/DN1850 – DN2500, the coupling used to join these pipe sizes will always be 4" larger than the nominal pipe diameter. (ex: 84"/DN2100 requires the use of 88"/DN2200 coupling.) The larger size is needed to allow for the extra outside pipe diameter the AGS ring adds to the pipe.
- For pipe sizes larger than 96"/DN2400, contact Victaulic.

4.1 DIMENSIONS

All Service Options



Flush



Overhung

Size			AGS Vic-Ring		
Nominal Pipe Size inches DN	Coupling Size inches mm	O.D. Ring inches mm	L1 inches mm	L2 Nominal Range inches mm	Ring Weight Approx. (Each) lb kg
12 DN300	14.000 355.6	14.000 355.6	3.00 77	6.13 – 6.31 155.8 – 160.2	20.0 9.0
14 DN350	16.000 406.4	16.000 406.4	3.00 77	6.13 – 6.31 155.8 – 160.2	39.0 17.5
16 DN400	18.000 457.2	18.000 457.2	3.00 77	6.13 – 6.31 155.8 – 160.2	43.0 19.5
18 DN450	20.000 508.0	20.000 508.0	3.00 77	6.13 – 6.31 155.8 – 160.2	48.0 22.0
20 DN500	22.000 558.8	22.000 558.8	3.00 77	6.13 – 6.31 155.8 – 160.2	53.0 24.0
22 DN550	24.000 609.6	24.000 609.6	3.00 77	6.13 – 6.31 155.8 – 160.2	58.0 26.5
24 DN600	26.000 660.4	26.000 660.4	4.00 102	8.15 – 8.53 207.1 – 216.6	84.0 38.0
26 DN650	28.000 711.2	28.000 711.2	4.00 102	8.15 – 8.53 207.1 – 216.6	90.0 41.0
28 DN700	30.000 762.0	30.000 762.0	4.00 102	8.15 – 8.53 207.1 – 216.6	97.0 44.0
30 DN750	32.000 812.8	32.000 812.8	4.00 102	8.15 – 8.53 207.1 – 216.6	105.0 47.5
32 DN800	34.000 863.6	34.000 863.6	4.00 102	8.15 – 8.53 207.1 – 216.6	115.0 52.0
34 DN850	36.000 914.4	36.000 914.4	4.00 102	8.15 – 8.53 207.1 – 216.6	120.0 54.5
36 DN900	38.000 965.2	38.000 965.2	4.00 102	8.15 – 8.53 207.1 – 216.6	125.0 56.5
38 DN950	40.000 1016.0	40.000 1016.0	4.25 108	8.71 – 9.09 221.3 – 230.8	140.0 63.5
40 DN1000	42.000 1066.8	42.000 1066.8	4.25 108	8.71 – 9.09 221.3 – 230.8	145.0 66.0
42 DN1050	44.000 1117.6	44.000 1117.6	4.25 108	8.71 – 9.09 221.3 – 230.8	155.0 70.5
44 DN1100	46.000 1168.4	46.000 1168.4	4.25 108	8.71 – 9.09 221.3 – 230.8	160.0 72.5
46 DN1150	48.000 1219.2	48.000 1219.2	4.25 108	8.71 – 9.09 221.3 – 230.8	165.0 75.0
48 DN1200	50.000 1270.0	50.000 1270.0	4.25 108	8.71 – 9.09 221.3 – 230.8	195.0 88.5
50 DN1250	52.000 1320.8	52.000 1320.8	5.00 127	10.28 – 10.66 261.2 – 270.7	210.0 95.5
52 DN1300	54.000 1371.6	54.000 1371.6	5.00 127	10.28 – 10.66 261.2 – 270.7	225.0 102.0

³ For allowable pipe end separation see dimensional table on page 4.

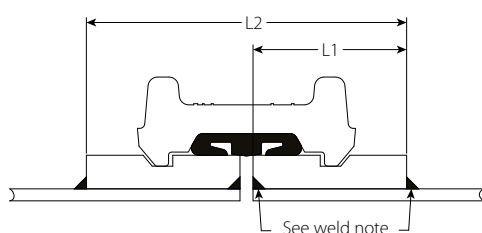
⁴ "L1" dimension is from inside face to end of ring for all lined and un-lined configurations.

WELD NOTES

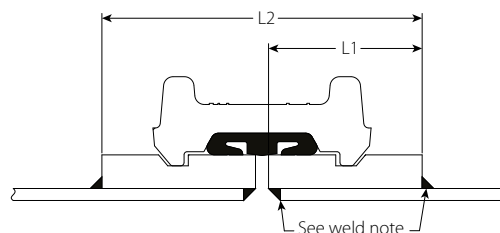
- 12"/300 mm pipe the minimum recommended weld size is ¼"/6.4 mm. Minimum recommended weld size is ⅜"/9.7 mm for 14" – 48"/350mm – 1200mm standard and extra heavy pipe. Minimum recommended weld size is ½"/12.7 mm for 52" – 84"/1300 mm – 2150mm standard and extra heavy pipe. Minimum recommended weld size is ¾"/15.9 mm for 90"/2300 mm and larger standard and extra heavy pipe.
- Victaulic Type B Vic-Rings utilize a standard full penetration V groove weld.

4.1 DIMENSIONS (CONTINUED)

All Service Options



Flush



Overhung

Size			AGS Vic-Ring		
Nominal Pipe Size inches DN	Coupling Size inches mm	O.D. Ring inches mm	L1 inches mm	L2 Nominal Range inches mm	Ring Weight Approx. (Each) lb kg
54 DN1350	56.000 1422.4	56.000 1422.4	5.00 127	10.28 – 10.66 261.2 – 270.7	230.0 104.5
56 DN1400	58.000 1473.2	58.000 1473.2	5.00 127	10.28 – 10.66 261.2 – 270.7	240.0 109.0
58 DN1450	60.000 1524.0	60.000 1524.0	5.00 127	10.28 – 10.66 261.2 – 270.7	250.0 113.5
60 DN1500	62.000 1574.8	62.000 1574.8	5.00 127	10.28 – 10.66 261.2 – 270.7	300.0 136.0
62 DN1550	64.000 1625.6	64.000 1625.6	6.00 153	12.28 – 12.66 312.0 – 321.5	350.0 159.0
64 DN1600	66.000 1676.4	66.000 1676.4	6.00 153	12.28 – 12.66 312.0 – 321.5	350.0 159.0
66 DN1650	68.000 1727.2	68.000 1727.2	6.00 153	12.28 – 12.66 312.0 – 321.5	375.0 170.0
68 DN1700	70.000 1778.8	70.000 1778.8	6.00 153	12.28 – 12.66 312.0 – 321.5	375.0 170.0
70 DN1750	72.000 1828.8	72.000 1828.8	6.00 153	12.28 – 12.66 312.0 – 321.5	375.0 170.0
72 DN1800	74.000 1879.6	74.000 1879.6	6.00 153	12.28 – 12.66 312.0 – 321.5	400.0 181.5
74 DN1850	78.000 1981.2	78.000 1981.2	7.00 178	14.28 – 14.66 362.8 – 372.3	875.0 397.0
80 DN2000	84.000 2133.6	84.000 2133.6	7.00 178	14.28 – 14.66 362.8 – 372.3	950.0 431.0
84 DN2100	88.000 2235.2	88.000 2235.2	7.00 178	14.28 – 14.66 362.8 – 372.3	1000.0 453.5
90 DN2250	94.000 2387.6	94.000 2387.6	8.00 204	16.00 – 16.90 406.4 – 429.2	1075.0 487.5
96 DN2400	100.000 2540.0	100.000 2540.0	8.00 204	16.00 – 16.90 406.4 – 429.2	1150.0 521.5

For coupling sizes larger than 100"/DN2500, contact Victaulic.

³ For allowable pipe end separation see dimensional table on page 4.

⁴ "L1" dimension is from inside face to end of ring for all lined and un-lined configurations.

WELD NOTES

- 12"/300 mm pipe the minimum recommended weld size is ¼"/6.4 mm. Minimum recommended weld size is ⅜"/9.7 mm for 14" – 48"/350mm – 1200mm standard and extra heavy pipe. Minimum recommended weld size is ½"/12.7 mm for 52" – 84"/1300 mm – 2150mm standard and extra heavy pipe. Minimum recommended weld size is ⅝"/15.9 mm for 90"/2300 mm and larger standard and extra heavy pipe.
- Victaulic Type B Vic-Rings utilize a standard full penetration V groove weld.

4.2 DIMENSIONS

Ring Requirements

Size		Pipe Size
Nominal Pipe Size inches DN	Vic-Ring/Coupling Size inches mm	Ring ID (Reference) inches mm
12 DN300	14.000 355.6	12.88 327.2
14 DN350	16.000 406.4	14.14 359.2
16 DN400	18.000 457.2	16.16 410.5
18 DN450	20.000 508.0	18.18 461.8
20 DN500	22.000 558.8	20.20 513.1
22 DN550	24.000 609.6	22.22 564.4
24 DN600	26.000 660.4	Nominal Pipe Size + 0.250"/6.4mm
26 DN650	28.000 711.2	
28 DN700	30.000 762.0	
30 DN750	32.000 812.8	
32 DN800	34.000 863.6	
34 DN850	36.000 914.4	
36 DN900	38.000 965.2	
38 DN950	40.000 1016.0	
40 DN1000	42.000 1066.8	
42 DN1050	44.000 1117.6	
44 DN1100	46.000 1168.4	
46 DN1150	48.000 1219.2	

Size		Pipe Size
Nominal Pipe Size inches DN	Vic-Ring/Coupling Size inches mm	Ring ID (Reference) inches mm
48 DN1200	50.000 1270.0	Nominal Pipe Size + 0.250"/6.4mm
50 DN1250	52.000 1320.8	
52 DN1300	54.000 1371.6	
54 DN1350	56.000 1422.4	
56 DN1400	58.000 1473.2	
58 DN1450	60.000 1524.0	
60 DN1500	62.000 1574.8	
62 DN1550	64.000 1625.6	
64 DN1600	66.000 1676.4	
66 DN1650	68.000 1727.2	
68 DN1700	70.000 1778.0	
70 DN1750	72.000 1828.8	
72 DN1800	74.000 1879.6	
74 DN1850	78.000 1981.2	
80 DN2000	84.000 2133.6	
84 DN2100	88.000 2235.2	
90 DN2250	94.000 2387.6	
96 DN2400	100.000 2540.0	

NOTE

- For pipe exceeding these values contact Victaulic

5.0 PERFORMANCE

Size		Maximum Allowable Working Pressure ⁷	Maximum End Load ⁵	Activation Moment ⁶
Nominal Pipe Size inches DN	Vic-Ring/Coupling Size inches mm			
12 DN300	14.000 355.6	350 2413	53,000 235,756	31,500 42,710
14 DN350	16.000 406.4	350 2413	70,000 311,376	47,000 63,720
16 DN400	18.000 457.2	350 2413	89,000 395,892	67,000 90,840
18 DN450	20.000 508.0	350 2413	105,000 467,064	92,000 124,740
20 DN500	22.000 558.8	350 2413	130,000 578,268	125,000 169,480
22 DN550	24.000 609.6	350 2413	155,000 689,474	160,000 216,930
24 DN600	26.000 660.4	300 2068	155,000 689,474	175,000 237,270
26 DN650	28.000 711.2	300 2068	180,000 800,680	220,000 298,280
28 DN700	30.000 762.0	300 2068	210,000 934,126	270,000 366,070
30 DN750	32.000 812.8	300 2068	240,000 1,067,574	325,000 440,640
32 DN800	34.000 863.6	300 2068	270,000 1,201,020	390,000 528,770
34 DN850	36.000 914.4	300 2068	305,000 1,356,708	460,000 623,680
36 DN900	38.000 965.2	300 2068	340,000 1,512,396	540,000 732,140
38 DN950	40.000 1016.0	300 2068	375,000 1,668,084	630,000 854,170
40 DN1000	42.000 1066.8	300 2068	415,000 1,846,012	730,000 989,750
42 DN1050	44.000 1117.6	232 1600	350,000 1,556,878	650,000 881,280
44 DN1100	46.000 1168.4	232 1600	385,000 1,712,566	740,000 1,003,310
46 DN1150	48.000 1219.2	232 1600	415,000 1,846,012	840,000 1,138,890
For coupling sizes larger than 100"/DN2500, contact Victaulic.				

⁵ **Working Pressure** and **End Load** are total, from all internal and external loads, based on carbon steel, AGS rings installed in accordance with Victaulic specifications. Contact Victaulic for performance on other ring materials.

WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

⁶ Victaulic Style W77/W77B require an activation moment resulting in reaction forces and moments in the system. This moment is linearly proportional to the system MAWP and can be determined for system design pressure through this linear relationship. The design activation moment shall be used for piping system and structural design purposes.

⁷ Pipe wall thickness for use with Victaulic Vic-Rings shall be specified by the system designer for the intended service.

5.0 PERFORMANCE (CONTINUED)

Size		Maximum Allowable Working Pressure ⁷	Maximum End Load ⁵	Activation Moment ⁶
Nominal Pipe Size inches DN	Vic-Ring/Coupling Size inches mm			
48 DN1200	50.000 1270.0	232 1600	455,000 2,023,942	950,000 1,288,030
50 DN1250	52.000 1320.8	250 1724	530,000 2,357,558	1,160,000 1,572,750
52 DN1300	54.000 1371.6	250 1724	570,000 2,535,486	1,290,000 1,749,010
54 DN1350	56.000 1422.4	250 1724	610,000 2,713,416	1,440,000 1,952,380
56 DN1400	58.000 1473.2	250 1724	660,000 2,935,826	1,600,000 2,169,310
58 DN1450	60.000 1524.0	250 1724	700,000 3,113,756	1,770,000 2,399,800
60 DN1500	62.000 1574.8	250 1724	750,000 3,336,166	1,950,000 2,643,840
62 DN1550	64.000 1625.6	250 1724	800,000 3,558,578	2,150,000 2,915,010
64 DN1600	66.000 1676.4	250 1724	850,000 3,780,988	2,360,000 3,199,730
66 DN1650	68.000 1727.2	250 1724	900,000 4,003,400	2,580,000 3,498,010
68 DN1700	70.000 1778.0	250 1724	960,000 4,270,294	2,810,000 3,809,850
70 DN1750	72.000 1828.8	250 1724	1,010,000 4,492,704	3,060,000 4,148,800
72 DN1800	74.000 1879.6	250 1724	1,070,000 4,759,598	3,320,000 4,501,320
74 DN1850	78.000 1981.2	250 1724	1,190,000 5,293,384	3,890,000 5,274,130
80 DN2000	84.000 2133.6	250 1724	1,380,000 6,138,546	4,850,000 6,575,720
84 DN2100	88.000 2235.2	250 1724	1,520,000 6,761,298	5,580,000 7,565,460
90 DN2250	94.000 2387.6	250 1724	1,730,000 7,695,424	6,800,000 9,219,560
96 DN2400	100.000 2540.0	250 1724	1,960,000 8,718,516	8,190,000 11,104,150
For coupling sizes larger than 100"/DN2500, contact Victaulic.				

⁵ **Working Pressure** and **End Load** are total, from all internal and external loads, based on carbon steel, AGS rings installed in accordance with Victaulic specifications. Contact Victaulic for performance on other ring materials.

WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 ½ times the figures shown.

⁶ Victaulic Style W77/W77B require an activation moment resulting in reaction forces and moments in the system. This moment is linearly proportional to the system MAWP and can be determined for system design pressure through this linear relationship. The design activation moment shall be used for piping system and structural design purposes.

⁷ Pipe wall thickness for use with Victaulic Vic-Rings shall be specified by the system designer for the intended service.

5.1 PERFORMANCE

Coupling Size inches DN	Required Torque ft. lbs. N•m
14, 16, 18	250
DN350, DN400, DN450	338
20, 22, 24, 26, 28	375
DN500, DN550, DN600, DN650, DN700	508
30, 32, 34, 36, 38	500
DN750, DN800, DN850, DN900, DN950	678
40, 42, 44, 46, 48, 50	600
DN1000, DN1050, DN1100, DN1150, DN1200, DN1250	814
52, 54, 56, 58, 60, 62, 64, 66, 68, 70, 72, 74	1225
DN1300, DN1350, DN1400, DN1450, DN1500, DN1550, DN1600, DN1650, DN1700, DN1750, DN1800, DN1850	1660
78, 84, 88, 94, 100	2000
DN1950, DN2100, DN2200, DN2350, DN2500	2712
For coupling sizes larger than 100"/DN2500, contact Victaulic.	

6.0 NOTIFICATIONS

WARNING

- Victaulic AGS couplings **MUST ONLY** be installed on AGS Vic-ring systems provided by Victaulic.
- Failure to follow these instructions will cause grooves that are not within Victaulic AGS specifications, resulting in joint failure, serious personal injury, and property damage.

7.0 REFERENCE MATERIALS

[02.06: Victaulic® Potable Water Approvals ANSI/NSF](#)
[05.01: Victaulic® Seal Selection Guide](#)
[20.03: Victaulic® AGS Flexible Coupling](#)
[20.05: Victaulic® AGS Grooved End Fittings](#)
[20.12 Victaulic W155 Expansion Joints](#)
[20.16 Style W257 Dynamic Movement Joint](#)
[23.19 Series W719 Butterfly Valve](#)
[24.01: Victaulic® Pipe Preparation Tool Specifications](#)
[25.09: Victaulic® AGS Roll Groove Specifications](#)
[26.01: Victaulic® Design Data](#)
[29.01: Victaulic® Terms and Conditions/Warranty](#)
[I-ENDCAP: Victaulic® End Caps Installation Instructions](#)
[I-W100 Field Installation Handbook Advanced Groove System Products](#)

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