

ROUST-A-BOUT COUPLING FOR PLAIN END PIPE STYLE 99



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.

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



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.

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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 WATER SERVICES OR STEAM SERVICES.**
 - **Others.**
- 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).

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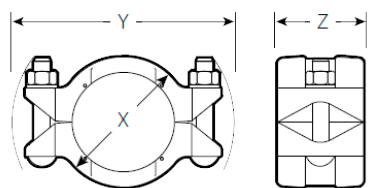
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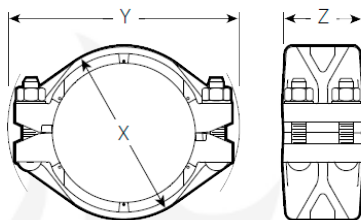
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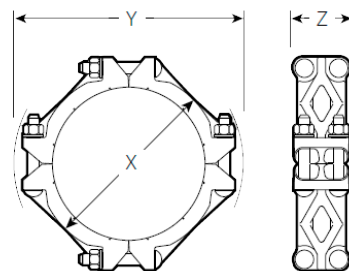
DIMENSIONS



1" - 6"/DN25 - DN150 sizes



8" - 12"/DN200 - DN300 sizes



14" - 18"/DN350 - DN450 sizes

Size			Bolt/But ²	Dimensions			Peso
Nominal Size		Actual Outside Diamete	Qty.	X	Y	Z	
DN	Nominal inches	mm			mm	mm	mm
DN25	1"	33,7	2	67	108	57	0,8
DN40	1 1/2"	48,3	2	83	140	73	1,6
DN50	2"	60,3	2	95	171	86	2,4
DN65	2 1/2"	73,0	2	108	181	86	2,5
		76,1	2	121	159	70	2,0
DN80	3"	88,9	2	127	216	86	3,9
DN90	3 1/2"	101,6	2	140	235	92	4,8
DN100	4"	114,3	2	156	254	102	5,8
DN125	5"	139,7	2	200	260	83	4,1
		141,3	2	184	289	111	7,8
DN150	6"	168,3	2	216	340	111	10,5
		165,1	2	213	337	111	10,1
DN200	8	219,1	4	276	365	127	16,9
DN250	10	273,0	4	340	416	127	21,9
DN300	12	323,9	4	394	499	130	27,2
DN350	14	355,6	8	425	527	137	40,4
DN400	16	406,4	8	483	575	137	47,6
DN450	18	457,0	8	533	597	137	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.

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PERFORMANCE

Pressure Ratings and End Loads Carbon Steel Pipe.

Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN25	1"	33,7	4,55	80	35	48	-	-	-
			3,38	40			600	41,37	3560
			2,77	10			600	41,37	3560
			1,65	5			400	27,58	2450
DN40	1 1/2"	48,3	5,08	80	60	81	750	51,71	9345
			3,68	40			750	51,71	9345
			2,77	10			600	41,37	7565
			1,65	5			400	27,58	4895
DN50	2"	60,3	5,54	80	150	203	750	51,71	14685
			3,91	40			750	51,71	14685
			2,77	10			400	27,58	8010
			1,65	5			200	13,79	4005
DN65	2 1/2"	73,0 / 76,1	7,01	80	150	203	600	41,37	17310
			5,16	40			600	41,37	17310
			3,05	10			300	20,68	8455
			2,11	5			150	10,34	4450
DN80	3"	88,9	7,62	80	200	271	600	41,37	25675
			5,49	40			600	41,37	25675
			3,05	10			225	15,51	9610
			2,11	5			125	8,62	5340
DN90	3 1/2"	101,6	8,08	80	200	271	500	34,47	27945
			5,74	40			500	34,47	27945
			3,05	10			200	13,79	11125
			2,11	5			100	6,89	5565

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 Maximum 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.

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Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN100	4"	114,3	8,56	80	200	271	450	31,03	31840
			6,02	40			450	31,03	31840
			3,05	10			175	12,07	12460
			2,11	5			60	4,14	4230
DN125	5"	141,3	9,53	80	250	339	350	24,13	37825
			6,55	40			350	24,13	37825
			3,40	10			150	10,34	16020
			2,77	5			75	5,17	8010
DN150	6"	168,3	10,97	80	250	339	300	20,68	46015
			7,11	40			300	20,68	46015
			3,40	10			100	6,89	15575
			2,77	5			75	5,17	11570
DN150	6"	165,1	6,35	-	250	339	300	20,68	44300
			5,08	-			175	12,07	26700
			3,81	-			100	6,89	15575
DN200	8"	219,1	8,18	40	250	339	250	17,24	64970
			7,04	30			200	13,79	52065
			3,76	10			100	6,89	26700
			2,77	5			50	3,45	13350
DN250	10"	273,0	9,27	40	350	475	250	17,24	101015
			7,80	30			175	12,07	70755
			4,19	10			75	5,17	30260
			3,40	5			50	3,45	20025
DN300	12"	323,9	9,53	STD	350	475	250	17,24	141955
			8,38	30			150	10,34	84995
			4,57	10			100	6,89	56515
			4,19	5			75	5,17	42275
DN350	14"	355,6	9,53	STD	350	475	200	13,79	137060
DN400	16"	406,4	9,53	STD	350	475	150	10,34	134390
DN450	18"	457,2	9,53	STD	+	+	+	+	+

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 Maximum 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.
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Pressure Ratings and End Loads Stainless Steel Pipe.

Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN25	1"	33,7	3,38	40	35	48	600	41,37	3560
			2,77	10			400	27,58	2450
			1,65	5			250	17,24	1555
DN40	1 1/2"	48,3	3,56	40	60	81	500	34,47	6230
			2,77	10			400	27,58	4895
			1,65	5	N/R	N/R	N/R	N/R	N/R
DN50	2"	60,3	3,91	40	150	203	500	34,47	9790
			2,77	10			400	27,58	8010
			1,65	5	N/R	N/R	N/R	N/R	N/R
DN65	2 1/2"	73,0 / 76,1	5,16	40	150	203	400	27,58	11125
			5,16	10			250	17,24	6675
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN80	3"	88,9	5,49	40	200	271	400	27,58	16910
			3,05	10			200	13,79	8455
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN90	3 1/2"	101,6	5,74	40	200	271	300	20,68	16465
			3,05	10			150	10,34	8455
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN100	4"	114,3	6,02	40	200	271	250	17,24	17355
			3,05	10			80	5,52	5785
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN125	5"	141,3	6,55	40	250	339	200	13,79	21360
			3,40	10			75	5,17	8010
			2,77	5	N/R	N/R	N/R	N/R	N/R
DN150	6"	168,3	7,11	40	250	339	200	13,79	30260
			3,40	10			75	5,17	11570
			2,77	5	N/R	N/R	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 Maximum 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.

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Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN150	6"	165,1	7,11	40	250	339	200	13,79	30260
			3,40	10			75	5,17	11570
			2,77	5	N/R	N/R	N/R	N/R	N/R
DN200	8"	219,1	8,18	40	250	339	200	13,79	48950
			3,76	10			75	5,17	19580
			2,77	5	25	1,72	6495		
DN250	10"	273,0	9,27	40	300	407	100	6,89	40050
			4,19	10			50	3,45	20025
			3,40	5	25	1,72	10010		
DN300	12"	323,9	10,31	40	350	475	100	6,89	56735
			4,67	10			50	3,45	28480
			3,96	5	25	1,72	14240		

Pressure Ratings and End Loads Aluminum Pipe ⁷

Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN25	1"	33,7	4,55	80	N/R	N/R	N/R	N/R	N/R
			3,38	40	35	48	600	41,37	3560
			2,77	10			300	20,68	1780
			1,65	5	100	6,89	601		
DN40	1 1/2"	48,3	5,08	80	60	81	500	34,47	6230
			3,56	40			400	27,58	4895
			2,77	10	300	20,68	3671		
			1,65	5	N/R	N/R	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 Maximum 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.
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Pressure Ratings and End Loads Aluminum Pipe ⁷

Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN50	2"	60,3	5,54	80	150	203	400	27,58	8010
			3,91	40			300	20,68	5785
			2,77	10			200	13,79	4005
			1,65	5	N/R	N/R	N/R	N/R	N/R
DN65	2 1/2"	73,0 / 76,1	7,01	80	150	203	350	24,13	9790
			5,16	40			275	18,96	7676
			5,16	10			150	10,34	4450
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN80	3"	88,9	7,62	80	200	271	300	20,68	12816
			5,49	40			200	13,79	8544
			3,05	10			100	6,89	4272
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN90	3 1/2"	101,6	8,08	80	200	271	250	17,24	13795
			5,74	40			200	13,79	11125
			3,05	10			100	6,89	5563
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN100	4"	114,3	8,56	80	200	271	200	13,79	14240
			6,02	40			150	10,34	10680
			3,05	10			50	3,45	3560
			2,11	5	N/R	N/R	N/R	N/R	N/R
DN125	5"	141,3	9,53	80	250	337	150	10,34	16020
			6,55	40			100	6,89	10680
			3,40	10			50	3,45	5340
			2,77	5	N/R	N/R	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 Maximum 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.
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Size			Pipe Wall Thickness ⁴		Required Bolt Torque ⁵		Maximum Working Pressure ⁶		End Load ⁶
Nominal		Actual Outside Diameter							
DN	inc	mm	mm	Schedule Number	Lb · Ft.	N · m	PSI	Bar	N
DN150	6"	168,3	10,97	80	250	339	150	10,34	23140
			7,11	40			100	6,89	15575
			3,40	10			50	3,45	7788
			2,77	5			35	2,41	5451
DN200	8"	219,1	8,18	40	250	339	150	10,34	40050
			7,04	30			100	6,89	26700
			6,35	20			75	5,17	20025
			3,76	10			50	3,45	13350
DN250	10"	273,0	9,27	40	300	407	100	6,98	40050
			7,80	30			75	5,17	28035
			6,35	20			50	3,45	20025
			4,19	10			25	1,72	10013
DN300	12"	323,9	10,31	40	300	407	100	6,89	56960
			8,38	30			75	5,17	42275
			6,35	20			50	3,45	26700
			4,67	10			25	1,72	14018

Model 99.

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 Maximum 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.

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