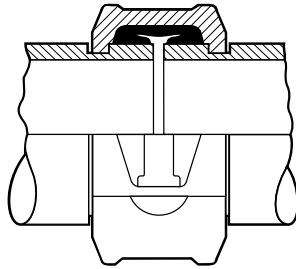


Victaulic® Rigid Coupling Style HP-70



2 – 16"/50 – 400 mm sizes



Exaggerated for clarity

Approvals/Listings



See Victaulic [publication 10.01](#) for details

See Victaulic [publication 02.06](#) for portable water approvals if applicable.

Product Description

Style HP-70 is designed with a heavy housing for high pressure service. The housing key is wider than standard and the coupling housing is designed to clamp the bottom of the groove, thus providing an essentially rigid joint. To achieve this rigidity it is necessary to torque the nuts on sizes 2 – 4"/50 – 100 mm to 60 – 80 ft. lbs./80 – 110 Nm. The nuts on the 14 and 16"/350 and 400 mm sizes are torqued to 600 and 700 ft. lbs./810 and 950 Nm, respectively. All other sizes must be bolted securely metal-to-metal.

HP-70 will not allow linear or angular movement and is useful for valve connections and other points where rigidity is required. The coupling is provided with plated bolts and nuts and standard C-cross section gasket.

⚠ WARNING

- **Victaulic RX roll sets must be used when grooving light-wall/thin-wall stainless steel pipe for use with Victaulic Couplings. Failure to use Victaulic RX roll sets when grooving light-wall/thin-wall stainless steel pipe may cause joint failure, resulting in serious personal injury and/or property damage.**

NOTICE

- **Victaulic RX grooving rolls must be ordered separately. They are identified by a silver color and the designation RX on the front of the roll sets.**

Job/Owner

System No.	
Location	

Contractor

Submitted By	
Date	

Engineer

Spec Section	
Paragraph	
Approved	
Date	

Material Specifications

Housing:

Ductile iron conforming to ASTM A-536, Grade 65-45-12. Ductile iron conforming to ASTM A-395, Grade 65-45-15, is available upon special request.

Housing Coating: (specify choice)

Standard: Orange enamel.

Optional: Hot dipped galvanized

Gasket: (specify choice¹)

Grade "E" EPDM

EPDM (Green stripe color code). Temperature range -30°F to +230°F/-34°C to +110°C. May be specified for cold and 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 PETROLEUM SERVICES.

Grade "T" Nitrile

Nitrile (Orange stripe color code). Temperature range -20°F to +180°F/-29°C to +82°C. May be specified for petroleum products, air with oil vapors, vegetable and mineral oils within the specified temperature range. Not compatible for hot water services over +150°F/+66°C or for hot dry air over +140°F/+60°C.

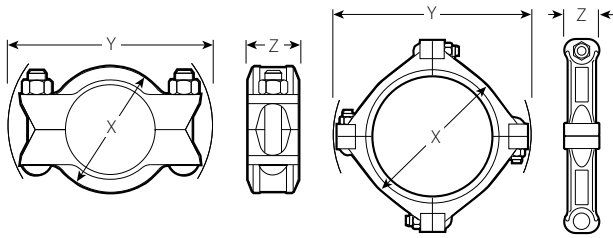
¹ Services listed are General Service Guidelines only. It should be noted that there are services for which these gaskets are not compatible. Reference should always be made to the latest [Victaulic Gasket Selection Guide](#) for specific gasket service guidelines and for a listing of services which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

Bolts/Nuts:

Heat-treated plated carbon steel, trackhead meeting the physical and chemical requirements of ASTM A-449 and physical requirements of ASTM A-183

Dimensions

Style HP-70



2 – 12” sizes

14 & 16” sizes

Nominal Size	Actual Outside Diameter	Maximum Working Pressure ²	Maximum End Load ²	Allow. Pipe End Separation ²	Bolt/Nut ^{2 3} (No.) size inches	Dimensions			Approx. Weight Each
						X inches mm	Y inches mm	Z inches mm	
2 50	2.375 60.3	1000 6900	4430 19715	0.14 3.6	2- 5/8 x 2 3/4	3.50 89	6.68 168	2.00 51	3.2 1.5
2 1/2 65	2.875 73.0	1000 6900	6490 28881	0.14 3.6	2- 5/8 x 3 1/2	4.13 105	7.13 181	2.00 51	4.0 1.8
3 80	3.500 88.9	1000 6900	9620 42810	0.14 3.6	2- 5/8 x 3 1/2	4.75 121	7.75 197	2.00 51	4.4 2.0
4 100	4.500 114.3	1000 6900	15900 70755	0.25 6.4	2- 3/4 x 4 1/4	6.00 152	9.63 245	2.13 54	7.5 3.4
6 150	6.625 168.3	1000 6900	34470 153390	0.25 6.4	2- 7/8 x 5 1/2	8.63 219	12.68 321	2.50 64	16.0 7.3
8 200	8.625 219.1	800 5500	46740 207995	0.25 6.4	2- 1 x 5 1/2	11.00 279	15.00 381	2.75 70	26.1 11.8
10 250	10.750 273.0	800 5500	72640 323250	0.25 6.4	2- 1 x 6 1/2	13.50 343	17.25 438	3.00 76	32.8 14.9
12 300	12.750 323.9	800 5500	102000 453900	0.25 6.4	2- 1 x 6 1/2	15.63 397	19.13 486	3.13 80	46.0 20.9
14 ⁴ 350	14.000 323.9	600 4100	92360 410800	0.25 6.4	2- 1 1/4 x 4 1/2	16.75 425	22.00 559	3.88 99	64.0 29.0
16 ⁴ 400	16.000 406.4	600 4100	120600 536400	0.25 6.4	2- 1 1/4 x 4 1/2	18.75 476	24.13 613	3.88 99	72.0 32.7

² Working Pressure and End Load are total, from all internal and external loads, based on standard weight (ANSI) steel pipe, standard **roll** or **cut** grooved in accordance with Victaulic specifications. Contact Victaulic for performance on other pipe.

³ Number of bolts required equals number of housing segments.

⁴ These sizes are not UL Listed or FM Approved. These sizes are not intended for use on Advanced Groove System (AGS) roll groove pipe.

General Notes

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

WARNING: Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.

WARNING: FOR ONE TIME FIELD TEST ONLY, the Maximum Joint Working Pressure may be increased to 1 1/2 times the figures shown.

For field installation only. HP-70 couplings when sufficiently pressurized, will allow pipe ends to separate to maximum point shown before joint acts in a fully restrained manner.

Installation

Reference should always be made to the [I-100 Victaulic Field Installation Handbook](#) for the product you are installing. Handbooks are included with each shipment of Victaulic products for 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.

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.

Trademarks

Victaulic® is a registered trademark of Victaulic Company.