

# Roust-A-Bout® Couplings

## STYLE 99



SEE VICTAULIC PUBLICATION 10.01 FOR DETAILS

Style 99 Roust-A-Bout couplings are designed with heavy housings and grips to provide a strong component for joining plain and beveled end, including Schedule 80 steel pipe and Victaulic plain end fittings. Roust-A-Bout 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.

Pipe is secured together by heavy jaws, which are set into the housing. All sizes are supplied with painted housings and plated nuts and bolts. Galvanized housings are available.



### WARNING

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

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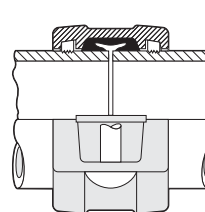
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1 ½ – 12" SIZES

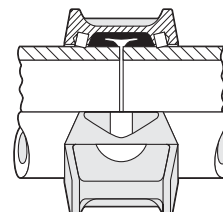


14 – 18" SIZES



Exaggerated for clarity

1 ½ – 18" SIZES



Exaggerated for clarity

1"; 76.1 & 139.7MM SIZES

## 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:** Orange enamel.

- **Optional:** Hot dipped galvanized and others.

**Jaws:** Carbon steel, case hardened, electroplated, except sizes 1"; 76.1 mm and 139.7 mm, which utilize stainless steel, Type 416, hardened.

**Gasket:** (specify choice\*)

- **Grade "E" EPDM**  
EPDM (Green color code). Temperature range –30°F to +230°F/–34°C to +110°C. Recommended 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 +86°F/+30°C and hot +180°F/+82°C potable water service. NOT RECOMMENDED FOR PETROLEUM SERVICES.
- **Grade "T" nitrile**  
Nitrile (Orange color code). Temperature range –20°F to +180°F/–29°C to +82°C. Recommended for petroleum products, air with oil vapors, vegetable and mineral oils within the specified temperature range. Not recommended for hot water services over +150°F/+66°C or for hot dry air over +140°F/+60°C.

\* 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 Gasket Selection Guide for specific gasket service recommendations and for a listing of services which are not recommended.

**Bolts/Nuts/Washers:** Heat-treated plated carbon steel, trackhead meeting the physical and chemical requirements of ASTM A-449 and physical requirements of ASTM A-183. The 6"/150mm and larger sizes are supplied with hardened steel washers meeting ASTM F-436 Type 3 (weathering steel).

### JOB/OWNER

System No. \_\_\_\_\_

Location \_\_\_\_\_

### CONTRACTOR

Submitted By \_\_\_\_\_

Date \_\_\_\_\_

### ENGINEER

Spec Sect \_\_\_\_\_ Para \_\_\_\_\_

Approved \_\_\_\_\_

Date \_\_\_\_\_

www.victaulic.com

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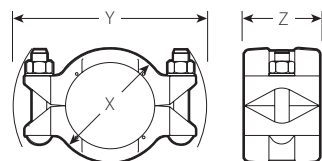


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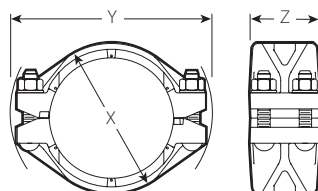
# Roust-A-Bout® Couplings

STYLE 99

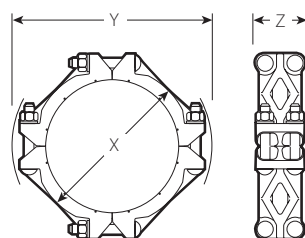
## DIMENSIONS



1 – 6"/25 – 150MM SIZES



8 – 12"/200 – 300MM SIZES



14 – 18"/350 – 450MM SIZES

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| Size                            |                                               | Max<br>Work<br>Press. | Max.<br>End<br>Load | Required<br>Bolt<br>Torque | ‡<br>Bolt/Nut<br>No. – Size | Dimensions<br>Inches/mm |              |             | Aprx.<br>Weight |
|---------------------------------|-----------------------------------------------|-----------------------|---------------------|----------------------------|-----------------------------|-------------------------|--------------|-------------|-----------------|
| Nominal<br>Size<br>Inches<br>mm | Actual<br>Outside<br>Diameter<br>Inches<br>mm | psi<br>kPa            | Lbs. *<br>N         | Lb. Ft. **<br>N•m          | Inches                      | X                       | Y            | Z           | Lbs.<br>kg      |
| 1<br>25                         | 1.315<br>33.7                                 | 600<br>4130           | 800<br>3560         | 35<br>47.5                 | 2 – 3/8 x 2                 | 2.56<br>65              | 4.25<br>108  | 2.25<br>57  | 1.7<br>0.8      |
| 1 1/2<br>40                     | 1.900<br>48.3                                 | 750<br>5175           | 2100<br>9345        | 60<br>81.4                 | 2 – 1/2 x 2 1/2             | 3.25<br>83              | 5.50<br>140  | 2.88<br>73  | 3.6<br>1.6      |
| 2<br>50                         | 2.375<br>60.3                                 | 750<br>5175           | 3300<br>14685       | 150<br>203.4               | 2 – 5/8 x 3 1/4             | 3.75<br>95              | 6.75<br>171  | 3.38<br>86  | 5.3<br>2.4      |
| 2 1/2<br>65                     | 2.875<br>73.0                                 | 600<br>4130           | 3890<br>17310       | 150<br>203.4               | 2 – 5/8 x 3 1/4             | 4.25<br>108             | 7.13<br>181  | 3.38<br>86  | 5.7<br>2.5      |
| 76.1 mm                         | 3.000<br>76.1                                 | 400<br>2700           | 2825<br>12500       | 95<br>128.8                | 2 – 1/2 x 2 3/4             | 4.69<br>119             | 6.25<br>159  | 2.75<br>70  | 4.4<br>2.0      |
| 3<br>80                         | 3.500<br>88.9                                 | 600<br>4130           | 5770<br>25676       | 200<br>271.2               | 2 – 3/4 x 4 1/4             | 5.00<br>127             | 8.50<br>216  | 3.38<br>86  | 8.7<br>3.9      |
| 3 1/2<br>90                     | 4.000<br>101.6                                | 500<br>3450           | 6280<br>27946       | 200<br>271.2               | 2 – 3/4 x 4 1/4             | 5.50<br>140             | 9.25<br>235  | 3.63<br>92  | 10.6<br>4.8     |
| 4<br>100                        | 4.500<br>114.3                                | 450<br>3100           | 7155<br>31840       | 200<br>271.2               | 2 – 3/4 x 4 1/4             | 6.13<br>156             | 10.00<br>254 | 4.00<br>102 | 12.8<br>5.8     |
| 139.7 mm                        | 5.500<br>139.7                                | 250<br>1700           | 5940<br>26440       | 160<br>217.0               | 2 – 3/4 x 5                 | 7.80<br>200             | 10.75<br>260 | 3.19<br>81  | 9.0<br>4.1      |
| 5<br>125                        | 5.563<br>141.3                                | 350<br>2400           | 8500<br>37825       | 250<br>339.0               | 2 – 7/8 x 5                 | 7.25<br>184             | 11.38<br>289 | 4.38<br>111 | 17.3<br>7.8     |
| 6<br>150                        | 6.625<br>168.3                                | 300<br>2065           | 10340<br>46013      | 250<br>339.0               | 2 – 1 x 6 #                 | 8.50<br>216             | 13.38<br>340 | 4.38<br>111 | 23.2<br>10.5    |
| 165.1 mm                        | 6.500<br>165.1                                | 300<br>2065           | 9955<br>44300       | 250<br>339.0               | 2 – 1 x 6 #                 | 8.38<br>213             | 13.25<br>337 | 4.38<br>111 | 22.2<br>10.1    |
| 8<br>200                        | 8.625<br>219.1                                | 250<br>1700           | 14600<br>64970      | 250<br>339.0               | 4 – 7/8 x 5 #               | 10.88<br>276            | 14.38<br>365 | 5.00<br>127 | 37.2<br>16.9    |
| 10<br>250                       | 10.750<br>273.0                               | 250<br>1700           | 22700<br>101015     | 300<br>406.8               | 4 – 7/8 x 5 #               | 13.38<br>340            | 16.38<br>416 | 5.00<br>127 | 48.2<br>21.9    |
| 12<br>300                       | 12.750<br>323.9                               | 250<br>1700           | 31900<br>141955     | 350<br>474.6               | 4 – 1 x 6 1/2 #             | 15.50<br>394            | 19.63<br>499 | 5.13<br>130 | 60.0<br>27.2    |
| 14<br>350                       | 14.000<br>355.6                               | 200<br>1400           | 30800<br>137060     | 350<br>474.6               | 8 – 1 x 6 1/2 #             | 16.75<br>425            | 20.75<br>527 | 5.38<br>137 | 89.0<br>40.4    |
| 16<br>400                       | 16.000<br>406.4                               | 150<br>1000           | 30200<br>134390     | 350<br>474.6               | 8 – 1 x 6 1/2 #             | 19.00<br>483            | 22.63<br>575 | 5.38<br>137 | 105.0<br>47.6   |
| 18<br>450                       | 18.000<br>457.0                               | 150<br>1000           | 38200<br>169990     | 350<br>474.6               | 8 – 1 x 6 1/2 #             | 21.00<br>533            | 23.50<br>597 | 5.38<br>137 | 125.0<br>56.7   |

\* 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.

\*\* Bolt torque ratings shown must be applied at installation.

‡ Metric thread size bolts (plated) are available (color coded) 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.

# Supplied with flat washers.

# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Carbon Steel Pipe

| 1                                    |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|--------------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                                 |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Outside Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. | Lb.Ft.<br>N • m   | psi<br>kPa                  | Lbs.<br>N              |
| 1<br>25                              | 1.315<br>33.7                           | 0.179<br>4.55                  | 80     | 35<br>47.5        | —                           | —                      |
|                                      |                                         | 0.133<br>3.38                  | 40     |                   | 600<br>4130                 | 800<br>3560            |
|                                      |                                         | 0.109<br>2.77                  | 10     |                   | 600<br>4130                 | 800<br>3560            |
|                                      |                                         | 0.065<br>1.65                  | 5      |                   | 400<br>2750                 | 550<br>2450            |
| 1½<br>40                             | 1.900<br>48.3                           | 0.200<br>5.08                  | 80     | 60<br>81.4        | 750<br>5175                 | 2100<br>9345           |
|                                      |                                         | 0.145<br>3.68                  | 40     |                   | 750<br>5175                 | 2100<br>9345           |
|                                      |                                         | 0.109<br>2.77                  | 10     |                   | 600<br>4130                 | 1700<br>7565           |
|                                      |                                         | 0.065<br>1.65                  | 5      |                   | 400<br>2750                 | 1100<br>4895           |
| 2<br>50                              | 2.375<br>60.3                           | 0.218<br>5.54                  | 80     | 150<br>203.4      | 750<br>5175                 | 3300<br>14685          |
|                                      |                                         | 0.154<br>3.91                  | 40     |                   | 750<br>5175                 | 3300<br>14685          |
|                                      |                                         | 0.109<br>2.77                  | 10     |                   | 400<br>2750                 | 1800<br>8010           |
|                                      |                                         | 0.065<br>1.65                  | 5      |                   | 200<br>1375                 | 900<br>4005            |
| 2½<br>65                             | 2.875<br>73.0                           | 0.276<br>7.01                  | 80     | 150<br>203.4      | 600<br>4130                 | 3890<br>17310          |
|                                      |                                         | 0.203<br>5.16                  | 40     |                   | 600<br>4130                 | 3890<br>17310          |
|                                      |                                         | 0.120<br>3.05                  | 10     |                   | 300<br>2065                 | 1900<br>8455           |
|                                      |                                         | 0.083<br>2.11                  | 5      |                   | 150<br>1035                 | 1000<br>4450           |
| 3<br>80                              | 3.500<br>88.9                           | 0.300<br>7.62                  | 80     | 200<br>271.2      | 600<br>4130                 | 5770<br>25675          |
|                                      |                                         | 0.216<br>5.49                  | 40     |                   | 600<br>4130                 | 5770<br>25675          |
|                                      |                                         | 0.120<br>3.05                  | 10     |                   | 225<br>1550                 | 2160<br>9610           |
|                                      |                                         | 0.083<br>2.11                  | 5      |                   | 125<br>860                  | 1200<br>5340           |

Table continued on page 4.

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# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Carbon Steel Pipe

| 1                                    |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|--------------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                                 |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Outside Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. | Lb.Ft.<br>N • m   | psi<br>kPa                  | Lbs.<br>N              |
| 3½<br>90                             | 4.000<br>101.6                          | 0.318<br>8.08                  | 80     | 200<br>271.2      | 500<br>3450                 | 6280<br>27945          |
|                                      |                                         | 0.226<br>5.74                  | 40     |                   | 500<br>3450                 | 6280<br>27945          |
|                                      |                                         | 0.120<br>3.05                  | 10     |                   | 200<br>1375                 | 2500<br>11125          |
|                                      |                                         | 0.083<br>2.11                  | 5      |                   | 100<br>690                  | 1250<br>5565           |
| 4<br>100                             | 4.500<br>114.3                          | 0.337<br>8.56                  | 80     | 200<br>271.2      | 450<br>3100                 | 7155<br>31840          |
|                                      |                                         | 0.237<br>6.02                  | 40     |                   | 450<br>3100                 | 7155<br>31840          |
|                                      |                                         | 0.120<br>3.05                  | 10     |                   | 175<br>1200                 | 2800<br>12460          |
|                                      |                                         | 0.083<br>2.11                  | 5      |                   | 60<br>415                   | 950<br>4230            |
| 5<br>125                             | 5.563<br>141.3                          | 0.375<br>9.53                  | 80     | 250<br>339.0      | 350<br>2410                 | 8500<br>37825          |
|                                      |                                         | 0.258<br>6.55                  | 40     |                   | 350<br>2410                 | 8500<br>37825          |
|                                      |                                         | 0.134<br>3.40                  | 10     |                   | 150<br>1035                 | 3600<br>16020          |
|                                      |                                         | 0.109<br>2.77                  | 5      |                   | 75<br>515                   | 1800<br>8010           |
| 6<br>150                             | 6.625<br>168.3                          | 0.432<br>10.97                 | 80     | 250<br>339.0      | 300<br>2065                 | 10340<br>46015         |
|                                      |                                         | 0.280<br>7.11                  | 40     |                   | 300<br>2065                 | 10340<br>46015         |
|                                      |                                         | 0.134<br>3.40                  | 10     |                   | 100<br>690                  | 3500<br>15575          |
|                                      |                                         | 0.109<br>2.77                  | 5      |                   | 75<br>515                   | 2600<br>11570          |
| 165.1 mm                             | 6.500<br>165.1                          | 0.250<br>6.35                  | —      | 250<br>339.0      | 300<br>2065                 | 9955<br>44300          |
|                                      |                                         | 0.200<br>5.08                  | —      |                   | 175<br>1200                 | 6000<br>26700          |
|                                      |                                         | 0.150<br>3.81                  | —      |                   | 100<br>690                  | 3500<br>15575          |
| 8<br>200                             | 8.625<br>219.1                          | 0.322<br>8.18                  | 40     | 250<br>339.0      | 250<br>1725                 | 14600<br>64970         |
|                                      |                                         | 0.277<br>7.04                  | 30     |                   | 200<br>1375                 | 11700<br>52065         |
|                                      |                                         | 0.148<br>3.76                  | 10     |                   | 100<br>690                  | 6000<br>26700          |
|                                      |                                         | 0.109<br>2.77                  | 5      |                   | 50<br>345                   | 3000<br>13350          |

Table continued on page 5.

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## STYLE 99

### PRESSURE RATINGS AND END LOADS

Carbon Steel Pipe

| 1                                    |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|--------------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                                 |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Outside Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. |                   |                             |                        |
| 10<br>250                            | 10.750<br>273.0                         | 0.365<br>9.27                  | 40     | 300<br>406.8      | 250<br>1725                 | 22700<br>101015        |
|                                      |                                         | 0.307<br>7.80                  | 30     |                   | 175<br>1200                 | 15900<br>70755         |
|                                      |                                         | 0.165<br>4.19                  | 10     |                   | 75<br>515                   | 6800<br>30260          |
|                                      |                                         | 0.134<br>3.40                  | 5      |                   | 50<br>345                   | 4500<br>20025          |
| 12<br>300                            | 12.750<br>323.9                         | 0.375<br>9.53                  | STD    | 350<br>474.6      | 250<br>1725                 | 31900<br>141955        |
|                                      |                                         | 0.330<br>8.38                  | 30     |                   | 150<br>1035                 | 19100<br>84995         |
|                                      |                                         | 0.180<br>4.57                  | 10     |                   | 100<br>690                  | 12700<br>56515         |
|                                      |                                         | 0.165<br>4.19                  | 5      |                   | 75<br>515                   | 9500<br>42275          |
| 14<br>350                            | 14.000<br>355.6                         | 0.375<br>9.53                  | STD    | 350<br>474.6      | 200<br>1375                 | 30800<br>137060        |
| 16<br>400                            | 16.000<br>406.4                         | 0.375<br>9.53                  | STD    | 350<br>474.6      | 150<br>1035                 | 30200<br>134390        |

COLUMN 1: Victaulic couplings are identified by nominal pipe size.

COLUMN 2: Nominal pipe wall thickness.

COLUMN 3: Pipe wall thickness schedule as established in ANSI Standard B36, 10-70.

COLUMN 4: Bolt torque required for installing Victaulic plain end couplings to achieve pressure ratings listed in Column 5 and Permissible Maximum End Loads listed in Column 6.

TORQUE RATINGS MUST BE APPLIED AT INSTALLATION.

COLUMN 5: Maximum line pressure, including surge, to which a joint should be subjected, based on couplings assembled to **full torque specifications** on plain end or beveled end standard weight steel pipe and/or Victaulic plain end fittings. Working pressure ratings are based on pipe prepared in accordance with Victaulic specifications.

COLUMN 6: Maximum end load from all internal and/or external forces to which the joint should be subjected based on couplings assembled to full torque specifications.

**NOTE:** 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"/6.4mm. 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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## STYLE 99

### PRESSURE RATINGS AND END LOADS

Stainless Steel Pipe

| 1                            |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                         |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. | Lb.Ft.<br>N • m   | psi<br>kPa                  | Lbs.<br>N              |
| 1<br>33.4                    | 1.315<br>33.7                           | 0.133<br>3.38                  | 40     | 35<br>47.5        | 600<br>4130                 | 800<br>3560            |
|                              |                                         | 0.109<br>2.77                  | 10     | 35<br>47.5        | 400<br>2750                 | 550<br>2450            |
|                              |                                         | 0.065<br>1.65                  | 5      | 35<br>47.5        | 250<br>1725                 | 350<br>1555            |
| 1½<br>48.3                   | 1.900<br>48.3                           | 0.145<br>3.56                  | 40     | 60<br>81.4        | 500<br>3450                 | 1,400<br>6230          |
|                              |                                         | 0.109<br>2.77                  | 10     | 60<br>81.4        | 400<br>2750                 | 1,100<br>4895          |
|                              |                                         | 0.065<br>1.65                  | 5      | N/R               | N/R                         | N/R                    |
| 2<br>60.3                    | 2.375<br>60.3                           | 0.154<br>3.91                  | 40     | 150<br>203.4      | 500<br>3450                 | 2,200<br>9790          |
|                              |                                         | 0.109<br>2.77                  | 10     | 150<br>203.4      | 400<br>2750                 | 1,800<br>8010          |
|                              |                                         | 0.065<br>1.65                  | 5      | N/R               | N/R                         | N/R                    |
| 2½<br>73.0                   | 2.875<br>73.0                           | 0.203<br>5.16                  | 40     | 150<br>203.4      | 400<br>2750                 | 2,500<br>11125         |
|                              |                                         | 0.120<br>5.16                  | 10     | 150<br>203.4      | 250<br>1725                 | 1,500<br>6675          |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 3<br>88.9                    | 3.500<br>88.9                           | 0.216<br>5.49                  | 40     | 200<br>271.2      | 400<br>2750                 | 3,800<br>16910         |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 200<br>1375                 | 1,900<br>8455          |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 3½<br>101.6                  | 4.000<br>101.6                          | 0.226<br>5.74                  | 40     | 200<br>271.2      | 300<br>2065                 | 3,700<br>16465         |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 150<br>1035                 | 1,900<br>8455          |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 4<br>114.3                   | 4.500<br>114.3                          | 0.237<br>6.02                  | 40     | 200<br>271.2      | 250<br>1725                 | 3,900<br>17355         |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 80<br>550                   | 1,300<br>5785          |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 5<br>141.3                   | 5.563<br>141.3                          | 0.258<br>6.55                  | 40     | 250<br>339.0      | 200<br>1375                 | 4,800<br>21360         |
|                              |                                         | 0.134<br>3.40                  | 10     | 250<br>339.0      | 75<br>510                   | 1,800<br>8010          |
|                              |                                         | 0.109<br>2.77                  | 5      | N/R               | N/R                         | N/R                    |

Table continued on page 7.

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# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Stainless Steel Pipe

| 1                            |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                         |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. |                   |                             |                        |
| 6<br>168.3                   | 6.625<br>168.3                          | 0.280<br>7.11                  | 40     | 250<br>339.0      | 200<br>1375                 | 6,800<br>30260         |
|                              |                                         | 0.134<br>3.40                  | 10     | 250<br>339.0      | 75<br>515                   | 2,600<br>11570         |
|                              |                                         | 0.109<br>2.77                  | 5      | N/R               | N/R                         | N/R                    |
| 165.1 mm                     | 6.500<br>165.1                          | 0.280<br>7.11                  | 40     | 250<br>339.0      | 200<br>1375                 | 6,800<br>30260         |
|                              |                                         | 0.134<br>3.40                  | 10     | 250<br>339.0      | 75<br>515                   | 2,600<br>11570         |
|                              |                                         | 0.109<br>2.77                  | 5      | N/R               | N/R                         | N/R                    |
| 8<br>219.1                   | 8.625<br>219.1                          | 0.322<br>8.18                  | 40     | 250<br>339.0      | 200<br>1375                 | 11,000<br>48950        |
|                              |                                         | 0.148<br>3.76                  | 10     | 250<br>339.0      | 75<br>515                   | 4,400<br>19580         |
|                              |                                         | 0.109<br>2.77                  | 5      | 250<br>339.0      | 25<br>170                   | 1,460<br>6495          |
| 10<br>273.0                  | 10.750<br>273.0                         | 0.365<br>9.27                  | 40     | 300<br>406.8      | 100<br>690                  | 9,000<br>40050         |
|                              |                                         | 0.165<br>4.19                  | 10     | 300<br>406.8      | 50<br>345                   | 4,500<br>20025         |
|                              |                                         | 0.134<br>3.40                  | 5      | 300<br>406.8      | 25<br>170                   | 2,250<br>10010         |
| 12<br>323.9                  | 12.750<br>323.9                         | 0.406<br>10.31                 | 40     | 350<br>474.6      | 100<br>690                  | 12,750<br>56735        |
|                              |                                         | 0.180<br>4.67                  | 10     | 350<br>474.6      | 50<br>345                   | 6,400<br>28480         |
|                              |                                         | 0.156<br>3.96                  | 5      | 350<br>474.6      | 25<br>170                   | 3,200<br>14240         |

NR = Not recommended

+ Contact Victaulic for details.

COLUMN 1: Victaulic couplings are identified by nominal pipe size.

COLUMN 2: Nominal pipe wall thickness.

COLUMN 3: Pipe wall thickness schedule as established in ANSI Standard B36, 10-70.

COLUMN 4: Bolt torque required for installing Victaulic plain end couplings to achieve pressure ratings listed in Column 5 and Permissible Maximum End Loads listed in Column 6.

TORQUE RATINGS MUST BE APPLIED AT INSTALLATION.

COLUMN 5: Maximum line pressure, including surge, to which a joint should be subjected, based on couplings assembled to **full torque specifications** on plain end or beveled end standard weight steel pipe and/or Victaulic plain end fittings. Working pressure ratings are based on pipe prepared in accordance with Victaulic specifications.

COLUMN 6: Maximum end load from all internal and/or external forces to which the joint should be subjected based on couplings assembled to full torque specifications.

**NOTE:** 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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# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Aluminum Pipe\*

| 1                            |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                         |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. |                   |                             |                        |
| 1<br>25                      | 1.315<br>33.7                           | 0.179<br>4.55                  | 80     | N/R               | N/R                         | N/R                    |
|                              |                                         | 0.133<br>3.38                  | 40     | 35<br>47.5        | 600<br>4130                 | 800<br>3560            |
|                              |                                         | 0.109<br>2.77                  | 10     | 35<br>47.5        | 300<br>2065                 | 400<br>1780            |
|                              |                                         | 0.065<br>1.65                  | 5      | 35<br>47.5        | 100<br>690                  | 135<br>601             |
| 1½<br>40                     | 1.900<br>48.3                           | 0.200<br>5.08                  | 80     | 60<br>81.4        | 500<br>3450                 | 1400<br>6230           |
|                              |                                         | 0.145<br>3.56                  | 40     | 60<br>81.4        | 400<br>2760                 | 1100<br>4895           |
|                              |                                         | 0.109<br>2.77                  | 10     | 60<br>81.4        | 300<br>2065                 | 825<br>3671            |
|                              |                                         | 0.065<br>1.65                  | 5      | N/R               | N/R                         | N/R                    |
| 2<br>50                      | 2.375<br>60.3                           | 0.218<br>5.54                  | 80     | 150<br>203.4      | 400<br>2760                 | 1800<br>8010           |
|                              |                                         | 0.154<br>3.91                  | 40     | 150<br>203.4      | 300<br>2065                 | 1300<br>5785           |
|                              |                                         | 0.109<br>2.77                  | 10     | 150<br>203.4      | 200<br>1380                 | 900<br>4005            |
|                              |                                         | 0.065<br>1.65                  | 5      | N/R               | N/R                         | N/R                    |
| 2½<br>65                     | 2.875<br>73.0                           | 0.276<br>7.01                  | 80     | 150<br>203.4      | 350<br>2415                 | 2200<br>9790           |
|                              |                                         | 0.203<br>5.16                  | 40     | 150<br>203.4      | 275<br>1895                 | 1725<br>7676           |
|                              |                                         | 0.120<br>5.16                  | 10     | 150<br>203.4      | 150<br>1035                 | 1000<br>4450           |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 3<br>80                      | 3.500<br>88.9                           | 0.300<br>7.62                  | 80     | 200<br>271.2      | 300<br>2065                 | 2880<br>12816          |
|                              |                                         | 0.216<br>5.49                  | 40     | 200<br>271.2      | 200<br>1380                 | 1920<br>8544           |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 100<br>690                  | 960<br>4272            |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |

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# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Aluminum Pipe\*

| 1                            |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                         |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. |                   |                             |                        |
| 3½<br>90                     | 4.000<br>101.6                          | 0.318<br>8.08                  | 80     | 200<br>271.2      | 250<br>1725                 | 3100<br>13795          |
|                              |                                         | 0.226<br>5.74                  | 40     | 200<br>271.2      | 200<br>1380                 | 2500<br>11125          |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 100<br>690                  | 1250<br>5563           |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 4<br>100                     | 4.500<br>114.3                          | 0.337<br>8.56                  | 80     | 200<br>271.2      | 200<br>1380                 | 3200<br>14240          |
|                              |                                         | 0.237<br>6.02                  | 40     | 200<br>271.2      | 150<br>1035                 | 2400<br>10680          |
|                              |                                         | 0.120<br>3.05                  | 10     | 200<br>271.2      | 50<br>345                   | 800<br>3560            |
|                              |                                         | 0.083<br>2.11                  | 5      | N/R               | N/R                         | N/R                    |
| 5<br>125                     | 5.563<br>141.3                          | 0.375<br>9.53                  | 80     | 250<br>339.0      | 150<br>1035                 | 3600<br>16020          |
|                              |                                         | 0.258<br>6.55                  | 40     | 250<br>339.0      | 100<br>690                  | 2400<br>10680          |
|                              |                                         | 0.134<br>3.40                  | 10     | 250<br>339.0      | 50<br>345                   | 1200<br>5340           |
|                              |                                         | 0.109<br>2.77                  | 5      | N/R               | N/R                         | N/R                    |
| 6<br>150                     | 6.625<br>168.3                          | 0.432<br>10.97                 | 80     | 250<br>339.0      | 150<br>1035                 | 5200<br>23140          |
|                              |                                         | 0.280<br>7.11                  | 40     | 250<br>339.0      | 100<br>690                  | 3500<br>15575          |
|                              |                                         | 0.134<br>3.40                  | 10     | 250<br>339.0      | 50<br>345                   | 1750<br>7788           |
|                              |                                         | 0.109<br>2.77                  | 5      | 250<br>339.0      | 35<br>240                   | 1225<br>5451           |
| 8<br>200                     | 8.625<br>219.1                          | 0.322<br>8.18                  | 40     | 250<br>339.0      | 150<br>1035                 | 9000<br>40050          |
|                              |                                         | 0.277<br>7.04                  | 30     | 250<br>339.0      | 100<br>690                  | 6000<br>26700          |
|                              |                                         | 0.250<br>6.35                  | 20     | 250<br>339.0      | 75<br>515                   | 4500<br>20025          |
|                              |                                         | 0.148<br>3.76                  | 10     | 250<br>339.0      | 50<br>345                   | 3000<br>13350          |

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# Roust-A-Bout® Couplings

## STYLE 99

### PRESSURE RATINGS AND END LOADS

Aluminum Pipe\*

| 1                            |                                         | 2                              | 3      | 4                 | 5                           | 6                      |
|------------------------------|-----------------------------------------|--------------------------------|--------|-------------------|-----------------------------|------------------------|
| Size                         |                                         | Pipe                           |        | Req'd Bolt Torque | Max. Joint Working Pressure | Max. Permiss. End Load |
| Nominal Size<br>Inches<br>mm | Actual Outside Diameter<br>Inches<br>mm | Wall Thickness<br>Inches<br>mm | Sched. |                   |                             |                        |
| 10<br>250                    | 10.750<br>273.0                         | 0.356<br>9.27                  | 40     | 300<br>406.8      | 100<br>690                  | 9000<br>40050          |
|                              |                                         | 0.307<br>7.80                  | 30     | 300<br>406.8      | 75<br>515                   | 6300<br>28035          |
|                              |                                         | 0.250<br>6.35                  | 20     | 300<br>406.8      | 50<br>345                   | 4500<br>20025          |
|                              |                                         | 0.165<br>4.19                  | 10     | 300<br>406.8      | 25<br>172                   | 2250<br>10013          |
| 12<br>300                    | 12.750<br>323.9                         | 0.406<br>10.31                 | 40     | 300<br>406.8      | 100<br>690                  | 12800<br>56960         |
|                              |                                         | 0.330<br>8.38                  | 30     | 300<br>406.8      | 75<br>515                   | 9500<br>42275          |
|                              |                                         | 0.250<br>6.35                  | 20     | 300<br>406.8      | 50<br>345                   | 6000<br>26700          |
|                              |                                         | 0.180<br>4.67                  | 10     | 300<br>406.8      | 25<br>172                   | 3150<br>14018          |

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

NR = Not recommended

COLUMN 1: Victaulic couplings are identified by nominal pipe size.

COLUMN 2: Nominal pipe wall thickness.

COLUMN 3: Pipe wall thickness schedule as established in ANSI Standard B36, 10-70.

COLUMN 4: Bolt torque required for installing Victaulic plain end couplings to achieve pressure ratings listed in Column 5 and Permissible Maximum End Loads listed in Column 6.

TORQUE RATINGS MUST BE APPLIED AT INSTALLATION.

COLUMN 5: Maximum line pressure, including surge, to which a joint should be subjected, based on couplings assembled to **full torque specifications** on plain end or beveled end standard weight steel pipe and/or Victaulic plain end fittings. Working pressure ratings are based on pipe prepared in accordance with Victaulic specifications.

COLUMN 6: Maximum end load from all internal and/or external forces to which the joint should be subjected based on couplings assembled to full torque specifications.

**NOTE:** 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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## Roust-A-Bout® Couplings

### STYLE 99

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#### 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](http://www.victaulic.com).

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#### WARRANTY

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

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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.

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STYLE 99

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14.02 1671 REV H UPDATED 3/2007

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