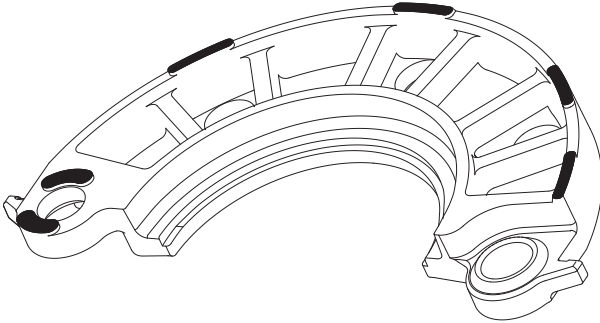


# STYLE 441 STAINLESS STEEL VIC-FLANGE® ADAPTER NOTES

---



*Exaggerated for clarity*

- The Style 441 is designed for use with Class 150 raised-face flanges, in accordance with ANSI B16.5. When a Style 441 is used with a flat-faced flange, the raised projections on the outside edge and around the mating holes of the Style 441 must be ground flush to the body. The shaded areas on the sketch above identify the projections that must be ground flush on both segments.
- The Style 441 must not be used in installations where it does not mount flush with the mating flange. Flange washers, or anything else that prevents mounting the Style 441 flush with the mating flange, must not be used.
- The Style 441 must not be used as anchor points for tie rods across non-restrained joints.
- The Style 441 must not be used against rubber coated surfaces or with wafer or lug-type valves, or when it does not mount flush with the mating flange.
- Because of the outside flange dimension, the Style 441 must not be used 90° to one another on a standard fitting.
- **STANDARD, FULL-SHANK DIAMETER ASSEMBLY BOLTS ARE REQUIRED FOR PROPER INSTALLATION OF STYLE 441 VIC-FLANGE ADAPTERS.**

**! WARNING**



- Read and understand all instructions before attempting to install any Victaulic piping products.
  - Depressurize and drain the piping system before attempting to install, remove, or adjust any Victaulic piping products.
  - Wear safety glasses, hardhat, and foot protection.
- Failure to follow these instructions could result in serious personal injury, improper product installation, and/or property damage.

**NOTICE**

- Make sure there is sufficient clearance behind the groove in the pipe to permit proper assembly of the Vic-Flange Adapter.

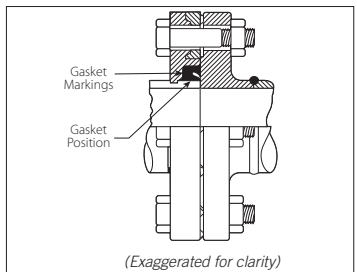


**1. CHECK PIPE ENDS:** The outside surface of the pipe, between the groove and the pipe end, must be smooth and free from indentations, projections (including weld seams), and roll marks to ensure a leak-tight seal. All oil, grease, loose paint, dirt, and cutting particles must be removed.



**2. INSERT MATING BOLT:** Insert a standard, full-shank diameter assembly bolt through a mating hole to act as a hinge, as shown above.

**3. CHECK GASKET AND LUBRICATE:** Check the gasket supplied to make sure it is suitable for the intended service. The color code identifies the gasket grade. Apply a thin coat of Victaulic lubricant or silicone lubricant to the gasket lips and exterior.

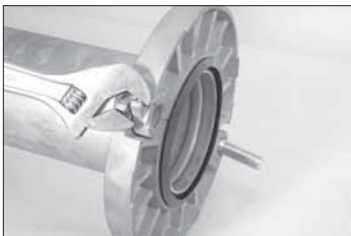


**4. INSTALL GASKET:** Install the gasket onto the pipe end. Make sure the gasket is positioned properly, as shown above. **NOTE:** The lettering on the outside of the gasket must face the gasket seating area of the Style 441 Vic-Flange Adapter.



## 5. INSTALL VIC-FLANGE

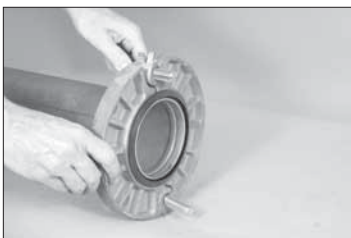
**ADAPTER:** Place the hinged flange around the grooved pipe end. Make sure the key section of the flange adapter engages with the groove in the pipe end.



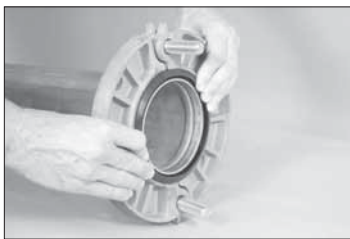
**5a.** Closure lugs are provided to ease installation. Clamp both lugs with a wrench or pliers, and pull the two segments together until the bolt holes align.

### NOTICE

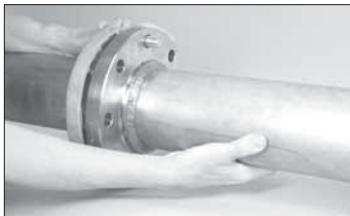
- When using stainless steel bolts/nuts, an anti-seize lubricant must be applied to the bolt threads.



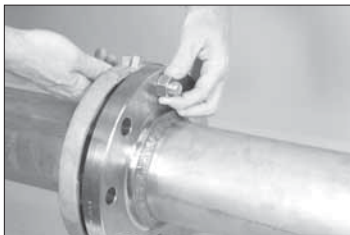
**5b.** When the bolt holes are aligned, insert a standard, full-shank diameter assembly bolt through the other mating hole of the Vic-Flange Adapter.



**5c.** Make sure the gasket is still seated properly in the flange adapter.



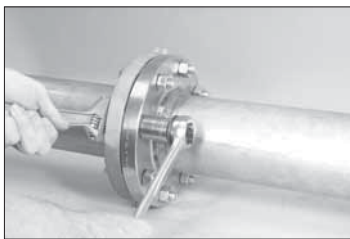
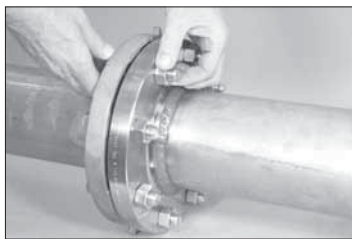
**6. JOIN VIC-FLANGE ADAPTER AND MATING FLANGE:** Join the Vic-Flange Adapter with the mating flange by aligning the two bolts with the holes in the mating flange.



**7. THREAD NUTS ONTO MATING BOLTS:** Thread a nut onto each mating bolt. Tighten the nuts until they are finger-tight.



**8. INSTALL REMAINING BOLTS/ NUTS:** Insert a standard, full-shank diameter assembly bolt through each remaining hole in the Vic-Flange Adapter and the mating flange. Thread a nut onto each bolt until they are finger-tight.



**8. INSTALL REMAINING BOLTS/ NUTS:** Insert a standard, full-shank diameter assembly bolt through each remaining hole in the Vic-Flange Adapter and the mating flange. Thread a nut onto each bolt until they are finger-tight.

**9. TIGHTEN NUTS:** Tighten all nuts evenly in a crossing pattern, as with a standard flange assembly. Continue to tighten all nuts until the standard, flange-bolt torque recommendation is achieved.

### Style 441 Helpful Information

Size		Number of Assembly Bolts/ Nuts	Assembly Bolt/Nut Size x Length	Required Mating Face Sealing Surface inches/mm	
Nominal Size inches	Actual Pipe Outside Diameter inches/mm			Required †	inches/metric †
2	2.375 60.3	4	5/8 x 2 3/4	2.38 61	3.41 87
2 1/2	2.875 73.0	4	5/8 x 3	2.88 73	3.91 99
3	3.500 88.9	4	5/8 x 3	3.50 89	4.53 11.5
4	4.500 114.3	8	5/8 x 3	4.50 114	5.53 141
6	6.625 168.3	8	3/4 x 3 1/2	6.63 168	7.78 198

† Victaulic does not supply assembly bolts/nuts. Bolt/nut sizes are for conventional flange-to-flange connections. Full-shank diameter assembly bolts are required for proper installation of Victaulic Flange Adapters.

The shaded area of the mating face (shown to the right) must be free from gouges, undulations, and deformities of any type for proper sealing

