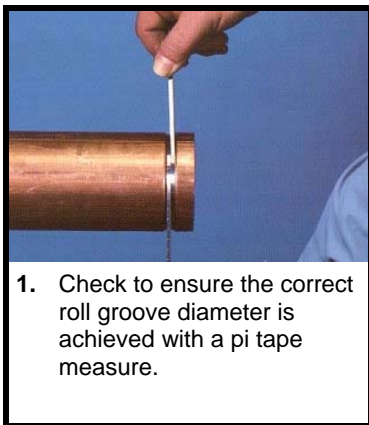


Assembling a Style 606 Copper Victaulic Coupling



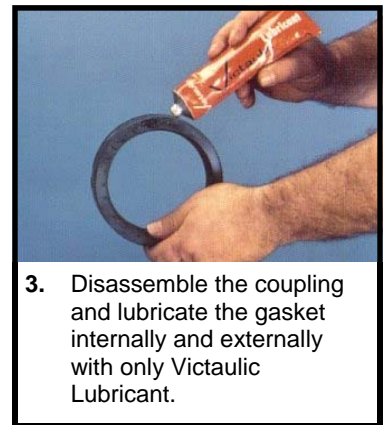
The style 606 coupling is a unique patented angle-pad design that allows the housings to offset while clamping the tube at the roll grooves. By permitting the housing to slide on the angled bolt pads, rigidity is obtained. The entire Copper Victaulic system should be supported and clipped to the requirements of AS/NZS 3500 Plumbing & Drainage code of practice. Always use ample lubrication for proper coupling assembly.



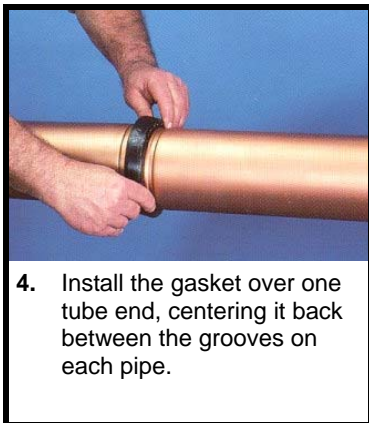
1. Check to ensure the correct roll groove diameter is achieved with a pi tape measure.



2. Copper Victaulic Style 606 Coupling.



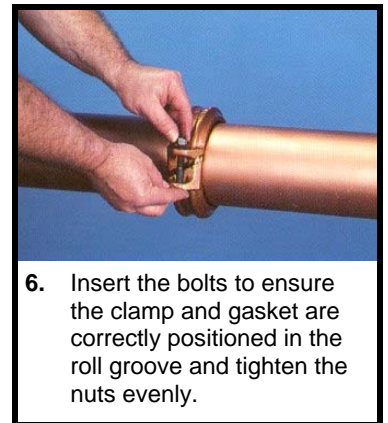
3. Disassemble the coupling and lubricate the gasket internally and externally with only Victaulic Lubricant.



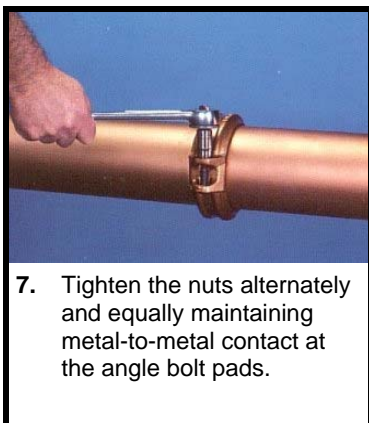
4. Install the gasket over one tube end, centering it back between the grooves on each pipe.



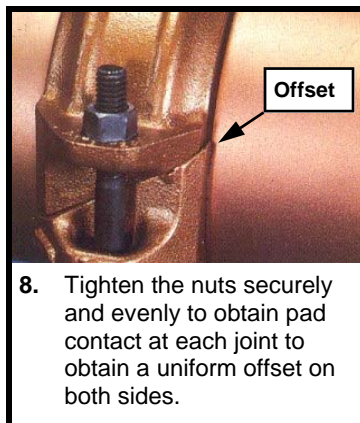
5. Position the housing into both grooves, around the gasket, and swing the mating housing into position.



6. Insert the bolts to ensure the clamp and gasket are correctly positioned in the roll groove and tighten the nuts evenly.



7. Tighten the nuts alternately and equally maintaining metal-to-metal contact at the angle bolt pads.



8. Tighten the nuts securely and evenly to obtain pad contact at each joint to obtain a uniform offset on both sides.