

TITLE: Big-Lock Piping System – Installation Instructions

Purpose: This document covers the installation instructions for the **Big-Lock piping system** supplied through Champion.

Scope: This document covers the Big-Lock piping range, specifically sizes **70mm through 273mm** inclusively.

Instructions:

Before installation the system, the following instructions must be carried out:



WARNING !!

Failure to follow instructions and warnings could cause system failure, resulting in serious personal injury and/or property damage

Every installation of this product is different and may contain certain unique hazards. It is your responsibility to be careful and work safely.

Champion cannot guarantee your safety while installing or testing Big-Lock Piping.

TITLE: Big-Lock Piping System – Installation Instructions

If you have questions after reading... STOP... Do not attempt to install or test this product. Contact customer support for more information. 704-947-6966

1. Wear safety glasses, gloves, hardhat, foot protection, and hearing protection.



2. Never work alone.

Tube Grooving

3. Insure that all groove specifications and installation processes are followed per the Victaulic Field Installation Handbook (I-100)
If you do not have this handbook, please contact customer support at (704) 947-6966.
Electronic or hard copy will be provided at no charge to you.
4. Cut tube ends must be square and smooth.
- a) A Chop Saw with at least an 80 tooth (minimum) carbide blade (for Non-Ferrous Metals) or wheeled tube cutter to produce an acceptable straight, clean cut.
 - b) Cut ends must have any Burs or sharp edges removed to protect seals during installation.
5. Victaulic Groove Gauge tape must be used to verify pipe diameter. Zero arrow must be within wide, black mark to the right of the 2 ½", 3", 4", 6", 8", 10". Only approved Victaulic grooving tools must be used to insure correct groove dimensions.

TITLE: Big-Lock Piping System – Installation Instructions

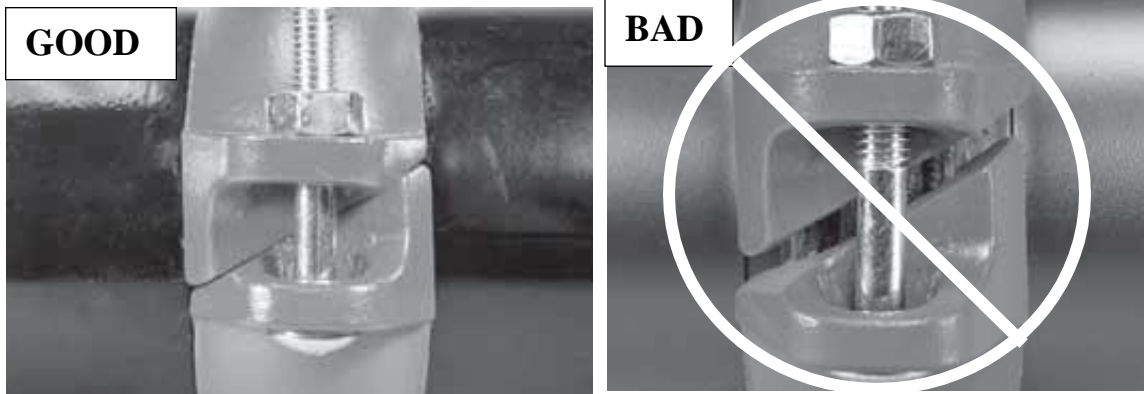
6. Tube must be grooved according to the instructions as supplied with the tool. Contact the manufacturer for any question about this process. 704-947-6966
 - a. A setting gauge will be supplied with each grooving tool and can be used as starting point for setting groove depth.
 - b. The setting gauge can only be used after the groove tool is installed on the pipe squarely against the stops and the adjustment nut hand tight.
 - c. After grooving to the approximate depth with the setting gauge, check the groove with the groove gauge tape and adjust the tool as required.
 - d. The zero arrow on the groove gauge tape must be within the narrow black mark to the left of the 2 ½", 3", 4", 6", 8", 10".
7. After the grooving tool is set to provide the correct groove, periodic adjustments may be required as you groove additional cut sections.

Important: Every groove must be verified to be in tolerance by using the groove gauge tape.

TITLE: Big-Lock Piping System – Installation InstructionsFitting Installation:

1. Inspect fittings to insure sealing surfaces are smooth and clean.
2. Do not remove the coupling bolts. Apply a thin coating of the assembly lube on the outer edge of the exposed lip of the gasket seal.
3. Install the coupling over the tube; mate the fitting to the coupling. Insure the fitting and tube are inserted into the coupling completely. Tighten the bolts evenly until the gap between the coupling halves has been eliminated and the coupling halves are aligned.

Important: All couplings must be securely tightened so that there is no visible gap between bolt pads, insuring metal-to-metal contact.



4. Visually inspect the complete system to verify all bolts are tight, coupling halves are together, and couplings are fitted properly into the tube and fitting grooves.

This Installation supplement should be used as a reference only.

The Victaulic I-100 Field Installation Manual should be utilized for detailed Installation Instructions.

For further clarification on this requirement please call the manufacturer for assistance – **704-947-6966**

TITLE: Big-Lock Piping System – Installation Instructions

REV.	DESCRIPTION OF CHANGE	DATE	APPROVALS	
			President	QA
0	Initial Release	n/a	PA	DAP
1	Layout changes only	1-18-12	PA	n/a
2	Addition of 220mm line	11-12-13	PA	TZ
3	Addition of safety requirements Addition of 273mm line	6-30-14	PA	TZ
4	Addition of safety requirements	2-26-15	PA	TZ