

Grooved Fittings

dixonvalve.com Customer Service 877.963.4966

Advantages of Grooved Fittings





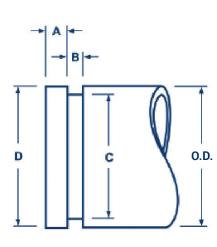
Built in deflection tolerances allow for quick installation and easy pipe alignment in uneven areas, or, where ground settling may occur.

Grooved couplings allow for some linear expansion and contraction as well as horizontal variance. These features eliminate limited pipeline stresses without the use of costly expansion joints.

Comparative Advantages	Threaded	Flanged	Welded	Grooved
Allows angular deflection-misalignment				1
Reclaimable, contraction or, no need for expansion joint				1
Reclaimable, no need for union		1		1
Allows fast connection with valves				1
Allows rotation of pipe for alignment		1		1
No special skills required to assemble	1			1
No welding slags	1			1
No weakening of pipe at joints		1		1
No fire hazard during installation	1	1	1	1
Speed of installation	1			1
Allows prefabrication	1	1		1
Low installation cost	1			1

Features and Benefits

- · Combine the features of a straight line or a flexible coupling, a union and an extension at each pipe joint
- · Housings engage the groove around the entire pipe circumference, locking the pipe together
- · Allow easy removal of pipe sections for replacement, cleaning and service
- · Grooves are not as deeply cut as threaded pipe, so less metal is removed and more of the pressure rating of the pipe is retained
- · Installation time and cost are low, since only a socket wrench is required



Groove Dimensions

Size	0.D.	Α	В	С	D
1-1/2"	1.900"	5/8"	5/16"	1.775"	1.900"
2"	2.375"	5/8"	5/16"	2.250"	2.375"
2-1/2"	2.875"	5/8"	5/16"	2.750"	2.875"
3"	3.500"	5/8"	5/16"	3.344"	3.500"
4"	4.500"	5/8"	3/8"	4.334"	4.500"
5"	5.563"	5/8"	3/8"	5.395"	5.563"
6"	6.625"	5/8"	3/8"	6.455"	6.625"
8"	8.625"	3/4"	7/16"	8.441"	8.625"
10"	10.750"	3/4"	1/2"	10.562"	10.750"
12"	12.750"	3/4"	1/2"	12.531"	12.750"

Grinnell® is a registered trademark of Tyco.



Quick Release Couplings - Series-Q

Applications

· Designed for applications requiring a quick connection and/or disconnection of a pipe joint

Features

- · A locking pin through the handle prevents accidental opening of the coupling
- See page 7 for replacement gaskets

Materials

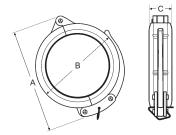
· Ductile iron body with zinc plating and steel safety clip

Comparable to

- Victaulic[®] #78
- Grinnell[®] #7003



Nominal	Pipe	Maximum Warking Dressure	Maximum End Load	Ductil	e Iron
Size	0.D.	Working Pressure PSI at 70°F (21°C)	(Lbs.)	Part # with EPDM gasket	Part # with Nitrile Rubber gasket
1-1/2"	1.900"	300	850	H315	H315BU
2"	2.375"	300	1329	H32	H32BU
2-1/2"	2.875"	300	2120	H325	H325BU
3"	3.500"	300	2886	H33	H33BU
4"	4.500"	300	4771	H34	H34BU
6"	6.625"	300	10341	H36	H36BU



А	В	С
4-3/4"	3-1/2"]"
5-1/2"	3-3/4"	1-7/8"
5-7/8"	4-3/4"	1-7/8"
7-1/4"	5-1/4"	1-7/8"
8-1/2"	6-1/2"	2"
10-5/8"	8-1/2"	2"



Standard Couplings - Series-S, Style 11

Applications

• Designed for a wide range of applications including commercial/industrial construction, mining, and process piping

Features

- Housing design allows for optimum strength without excessive casting weight
- See pages 7, 10-11 for replacement gaskets, nuts, and bolts

Material

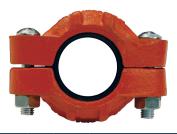
• Ductile iron body with rust-inhibiting paint

Approvals

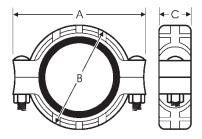
• UL listed and Factory Mutual approved

Comparable to

- Victaulic[®] #77
- Grinnell[®] #7001



Nominal	Pipe	Morlung Drocouro	Maximum			s		Ductile Iron	
Size	0.D.	PSI at 70°F (21°C)	End Load (Lbs.)		size	length	Part # with EPDM gasket	Part # with Nitrile Rubber gasket	Part # with FKM gasket
1-1/2"	1.900"	1000	2835	2	3/8"	2"	C115	C115BU	
2"	2.375"	1000	4430	2	1/2"	2-3/4"	C12	C12BU	C12V
2-1/2"	2.875"	1000	6492	2	1/2"	2-3/4"	C125	C125BU	
3"	3.500"	1000	9621	2	1/2"	3"	C13	C13BU	C13V
4"	4.500"	1000	15904	2	5/8"	3-1/4"	C14	C14BU	C14V
6"	6.625"	1000	34472	2	3/4"	4-1/4"	C16	C16BU	
8"	8.625"	800	46741	2	7/8"	5"	C18	C18BU	
10"	10.750"	800	72610	2	7/8"	5"	C20	C20BU	
12"	12.750"	800	102141	2	7/8"	5″	C24	C24BU	



Α	В	С
4-5/8"	3"	1-7/8"
5-15/64"	3-45/64"	1-27/32"
5-5/8"	4-1/4"	1-27/32"
6-21/32"	5"	1-27/32"
8-17/64"	6-3/8"	2-3/64"
11-7/32"	8-57/64"	2-3/64"
14-1/64"	11-3/8"	2-23/64"
16-5/8"	13-1/2"	2-5/8"
18-5/8"	15-1/2"	2-5/8"



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Lightweight Flexible Couplings - Series-L, Style 10

Applications

• Designed for applications requiring moderate internal pressure or where weight is a factor such as general purpose, mining, irrigation, and compressed air where a deflection of 5% or less is required

Feature

• See pages 7, 10-11 for replacement gaskets, nuts, and bolts

Material

· Ductile iron body with rust inhibiting paint

Approvals

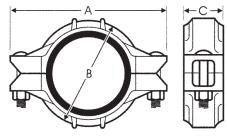
• UL listed and Factory Mutual approved

Comparable to

- Victaulic[®] #75
- Grinnell[®] #7000



Nominal	ominal Pipe Working Pressure End Lo		Maximum		Bolts		Duc	tile Iron
Size		0.D. $PSI at 70°E(21°C)$ (l.bc.)		qty	size	length	Part # with EPDM gasket	Part # with Nitrile Rubber gasket
1-1/2"	1.900"	500	1418	2	3/8"	2-1/4"	L215	L215BU
2"	2.375"	500	2215	2	3/8"	2"	L02	L02BU
2-1/2"	2.875"	300	3246	2	3/8"	2"	L025	L025BU
3"	3.500"	300	4811	2	1/2"	2-3/4"	L03	L03BU
4"	4.500"	300	6362	2	1/2"	2-3/4"	L04	L04BU
5"	5.563"	300	9722	2	5/8"	3-1/4"	L05	L05BU
6"	6.625"	300	13789	2	5/8"	3-1/4"	L06	L06BU
8"	8.625"	300	20449	2	3/4"	4-1/4"	L08	L08BU



Α	В	С
4-1/2"	2-29/32"	1-25/32"
4-7/8"	3-25/64"	1-27/32"
5-15/32"	3-45/64"	1-27/32"
6-27/64"	4-39/64"	1-27/32"
7-33/64"	5-7/8"	2-1/64"
9-17/32"	7-3/32"	2-1/64"
10-7/16"	8-7/64"	2-3/64"
13-15/32"	10-5/32"	2-13/32"
15-3/4"	12-39/64"	2-9/16"
18-23/64"	15-7/16"	2-9/16"



Grooved Rigid Couplings - Series-R, Style 5

Applications

· Ideal for fire protection, plumbing, low-pressure air, and drainage

Features

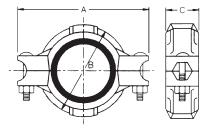
- Lightweight, low pressure
- · Small gripping teeth hold the housing into the groove allowing a straight run of pipe and preventing any flex at the joint
- See pages 7, 10-11 for replacement gaskets, nuts, and bolts

Approvals

• UL listed and Factory Mutual approved



Nominal	Pipe O.D.	Maximum Warking Dressure	Maximum		Bolts		Galvanize	d Ductile Iron
Size		Working Pressure PSI at 70°F (21°C)	End Load (Lbs.)	qty	size	length	Part # with EPDM gasket	Part # with Nitrile Rubber gasket
2"	2.375"	175	4425	2	3/8"	2"	R72	R72BU
2-1/2"	2.875"	175	6490	2	3/8"	2"	R725	R725BU
3"	3.500"	175	9620	2	1/2"	2-3/4"	R73	R73BU
4"	4.500"	175	12720	2	1/2"	2-3/4"	R74	R74BU
6"	6.625"	175	27570	2	5/8"	3-1/4"	R76	R76BU
8"	8.625"	175	35050	2	3/4"	4-1/4"	R78	R78BU



A	В	С
4-7/8"	3-17/32"	1-27/32"
5-5/8"	3-45/64"	1-3/4"
6-3/8"	4-41/64"	1-27/32"
7-45/64"	5-15/16"	2"
10-25/32"	8-7/64"	2-3/64"
13-25/32"	10"	2-21/64"



Grooved Bolted Clamps

Features

- Bolt torque: 20 ft. lbs.
- · Precision casting and machined dimensions provide an exact fit and great appearance
- · Use of lock nuts prevents clamps from loosening in high vibration applications
- · Leak-tight connection



- · Unlike steel groove clamps that secure pipe ends with high clamp force against the tubing walls, the Dixon® bolted clamp takes the full bolt force and locks in the groove of the tube preventing distortion of the tube diameter
- · White nitrile rubber for use in dry bulk food applications

Specifications

- Temperature ratings for FKM-B is 20°F to 300°F (-7°C to 149°C)
- Temperature ratings for Baylast[™] is -20°F to 180°F (-29°C to 82°C)
- 2" pressure rating: 400 PSI
- 3" pressure rating: 170 PSI
- 4" pressure rating: 120 PSI

Approvals

- · FKM-B rated for 100% biodiesel and Ethanol
- Nitrile rubber rated for petroleum service, Ethanol to E100, and biodiesel to B20
- Baylast™ rated for petroleum service, Ethanol to E100, and biodiesel to B100

Nominal Size	Gasket Material	Aluminum Part #
2"		DBV-VB200
3"		DBV-VB300
4"	FKM-B	DBV-VB400
5"		DBV-VB500
2"		DBV-BN200
3"	u itali a mahiha an	DBV-BN300
4"	nitrile rubber	DBV-BN400
5"		DBV-BN500
2"		DBV-BL200
3"	Baylast	DBV-BL300
4"		DBV-BL400
4"	and the sector is such to an	DBV-WB400
5"	white nitrile rubber	DBV-WB500



clamp with black nitrile rubber gasket Note: Supplied clamp gasket must be installed prior to use, ships separately.

Replacement Gaskets

Size	Material	Part #
2"		G200VB
3"	FKM-B	G300VB
4"		G400VB
5"		G500VB
3"		G300T
4"	nitrile rubber	G400T
5"		G500T
2"		G200BL
3"	Baylast	G300BL
4"		G400BL
4"	white nitrile rubber	G400N
5"		G500N
Feature	Painted I	ron Clamps with Baylast Gaskets



Feature

Painted red

Approvals

· Baylast seal is rated for biodiesel, Ethanol, diesel, gas, and ULSD

Nominal Size	Maximum PSI	Iron Part #
2"	500	L02BL
3"	300	L03BL
4"	300	L04BL



Flange Adapters - Series-FA

Application

· Used to connect an ANSI Class 125 and 150 flange to a grooved pipe using a grooved clamp

Feature

• Provides a rigid one-piece connection that can be disconnected by removing the clamp assembly, assemble to another flange, position bolt heads on the adapter (grooved) side

Material

· Ductile iron body with rust inhibiting paint

Nominal Pipe	Maximum Working Pressure	Flange Dimensions		Bolts		Ductile Iron	
Size	0.D.	PSI at 70°F (21°C)	Α	В	Qty	size	Part #
2"	2.375"	300	6"	2-3/8"	4	5/8"	FA20
3"	3.500"	300	7-1/4"	2-3/8"	4	5/8"	FA30
4"	4.500"	300	8-1/2"	2-3/8"	8	5/8"	FA40
6"	6.625"	300	11″	2-9/16"	8	3/4"	FA60
8"	8.625"	300	13-1/4"	3"	8	3/4"	FA80

Reducing Adapters - Series-RA

Material

· Ductile iron body with rust inhibiting paint

Approvals

• UL listed and Factory Mutual approved

Comparable to

- Victaulic[®] #50
- Grinnell[®] #7072

Nominal Size	Nominal Size	Dimensions E to E	Ductile Iron Part #
2"	1-1/2"	2.5"	RAGG20150
2-1/2"	2"	2.5"	RAGG25020
3"	2"	2.5"	RAGG3020
3	2-1/2"	2.5"	RAGG30250
	2"	3.0"	RAGG4020
4"	2-1/2"	3.0"	RAGG40250
	3"	3.0"	RAGG4030
5"	4"	3.5"	RAGG5040
	2"	4.0"	RAGG6020
c "	2-1/2"	4.0"	RAGG60250
6"	3"	4.0"	RAGG6030
	4"	4.0"	RAGG6040



ľ	E to E



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Grooved End Fittings

Series-90

Feature

· Designed to provide minimum pressure drop and uniform strength

Material

· Ductile iron body with rust inhibiting paint

Specification

• Maximum operating pressure: 500 PSI at ambient temperature 70°F (21°C)

Approvals

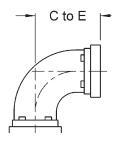
· Underwriters Listed and Factory Mutual approved

Comparable to

- Victaulic[®] #10
- Grinnell[®] #7050

Nominal Size	Dimensions C to E	Ductile Iron Part #
2"	3-1/4"	L502
2-1/2"	3-3/4"	L5025
3"	4-1/4"	L503
4"	5"	L504
6"	6-1/2"	L506
8"	7-3/4"	L508







Feature

• Designed to provide minimum pressure drop and uniform strength

Material

· Ductile iron body with rust inhibiting paint

Specification

• Maximum operating pressure: 500 PSI at ambient temperature 70°F (21°C)

Approvals

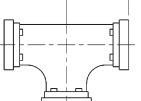
· Underwriters Listed and Factory Mutual approved

Comparable to

- Victaulic's #20
- Grinnell's #7060

Nominal Size	Dimensions C to E	Ductile Iron Part #
2"	3-1/4"	T602
2-1/2"	3-3/4"	T6025
3"	4-1/4"	T603
4"	5"	T604
6"	6-1/2"	T606
8"	7-3/4"	T608





Series-T



ANSI Caps with Tapped Outlet - Series-EC

Feature

Feature

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Painted with rust-inhibiting paint

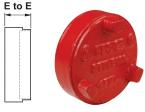
Nominal Size	Outlet	Dimensions E to E	Ductile Iron Part #
2"	1"	7/8"	EC201
2-1/2"			EC251
3"			EC301
4"			EC401
6"		l	EC601

Blank Caps - Series-BE

Comparable to

- Victaulic[®] #60
- Grinnell[®] #7074

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Painted with rust-inhibiting paint

ApprovalsUnderwriters Listed and Factory Mutual approved

Nominal Size	Dimensions	Ductile Iron
Nominal Size	E to E	Part #
2"	7/8"	BEC20
2-1/2"	7/8"	BEC25
3"	7/8"	BEC30
5"	1-19/32"	BECC50
4"	1"	BEC40
6"	1"	BEC60
8"	1-3/16"	BEC80
8"	1-7/8"	

Grooved Fitting Accessories

Nuts and Bolts

Features

- The nuts are a heavy hexagon design
- Specifically designed for use with the couplings on pages 4-6

Approval

Conforms to ASTM A183

Bolt Thread	Bolt Length	Torque (Ft. Lbs.)	Electroplated Carbon Steel Part #
3/8"	2"	30	BLT38200
3/8	2-1/4"	30	BLT38225
1/2"	2-1/2"	50	BLT50212
	2-3/4"		BLT50234
	3"		BLT50300
5/8"	3-1/4"	75	BLT58314
3/4"	4-1/4"	75	BLT75414
7/8"	5"	200	BLT78500

Groove Lube

Features

- Water soluble
- Non-toxic
- Non-corrosive
- Non-flammable
- Should not be used with High Density Polyethylene (HDPE) pipe

Approval

· NSF approved for use with potable water

Size	Container	Part #
1 qt.	2 lb. tub	GROOVLUB32



GUVLOK

STANDARD LUBRICAN

ANVIL

Nitrile Rubber Gaskets

Specification

(-31°C to 80°C)

Grooved Fitting Gaskets

- Check gasket color code to be certain it is recommended for the service intended
- Use lubricant on gasket (page 10)

• Color code: black with blue stripe

For services not listed contact Dixon[®] for recommendations

· Resistant to oxidizing acids, petroleum oils, hydraulic

fluids, halogenated hydrocarbons, and lubricants

FKM Gaskets

EPDM Gaskets Specification

(-30°C to 110°C)

Specification

 Temperature range: -13°F to 350°F (-25°C to 177°C)

• Temperature range: -22°F to 230°F

• Temperature range: -24°F to 176°F

Size	FKM Part #
2"	G200V
3"	G300V
4"	G400V
6"	G600V
8"	G800V
10"	G1000V
12"	G1200V

Features

- Color code: black with green stripe
- For water, dilute acids, alkalies, salts, and many chemical services not involving hydrocarbons, oils, or gases
- Excellent oxidation resistance
- Not for use with hydrocarbons

Size	EPDM Part #
1-1/2"	G150E
2"	G200E
2-1/2"	G250E
3"	G300E
4"	G400E
5"	G500E
6"	G600E
8"	G800E
10"	G1000E
12"	G1200E

Features

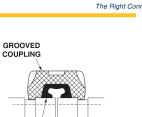
- For petroleum products, vegetable oils, mineral oils, and air contaminated with petroleum oils
- Not for use in hot water services

Size	Black Nitrile Rubber with Orange Stripe	White Nitrile Rubber
0.20	Part #	Part #
1-1/2"	G150T	
2"	G200T	
2-1/2"	G250T	
3"	G300T	
4"	G400T	G400N
5"	G500T	
6"	G600T	
8"	G800T	
10"	G1000T	
12"	G1200T	









Features







Application

• For water and air

Materials

 Body: ductile iron, epoxy coated; disc: ductile iron, EPDM encapsulated; stem: stainless steel; notch plate: zinc plated steel; seals: EPDM

Specifications

- Working pressure: 300 PSI
- Maximum temperature: 210°F (99°C)

Size	Ductile Iron Part #
2"	GIBFV200
2-1/2"	GIBFV250
3"	GIBFV300
4"	GIBFV400
6"	GIBFV600
8"	GIBFV800

Long Pipe Style Nipples - Series-AN

Groove x NPT	Dimensions E to E	Carbon Steel Part #
2"		A712
2-1/2"	4"	A7125
3"		A713
 4"		A714
5"	6"	A715
 6"		A716





E to E

Nominal Size	Aluminum Part #	Carbon Steel Part #	316 Stainless Steel Part #
2"	AVN2000-200	VN2000-200	VNR2000-200
2-1/2"	AVN2500-200	VN2500-200	VNR2500-200
3"	AVN3000-200	VN3000-200	VNR3000-200
4"	AVN4000-200	VN4000-200	VNR4000-200

NOTE: For additional information on pipe dimensions, please reference dixonvalve.com.



King Combination Nipples

Grooved End

Feature

 Grooved ends (in brass and aluminum) are available in select sizes. Consult Dixon[®] for prices and availability

Size	Unplated Steel Part #	Opt Qty	316 Stainless Steel Part #	Opt Qty
1"	STV10	50		
1-1/4"	STV15	50		
1-1/2"	STV20	50	RSTV20	50
2"	STV25	25	RSTV25	25
2-1/2"	STV30	10		
3"	STV35	10	RSTV35	10
4"	STV40	4	RSTV40	5
5"	STV50	4		
6"	STV60	4		
8"	STV80	2		
10"	STV100	1		
12"	STV120	1		



NOTE: For additional information on pipe dimensions please reference dixonvalve.com.

Global King Combination Nipples

Grooved End

Size	Plated Steel Part #
1"	GSTVC10
1-1/4"	GSTVC15
1-1/2"	GSTVC20
2"	GSTVC25
2-1/2"	GSTVC30
3"	GSTVC35
4"	GSTVC40
5"	GSTVC50
6"	GSTVC60



King Crimp Style Combination Nipples

Feature

• There are two grooves on the crimp style King combination nipples. The second groove is the roll stamp groove, which has the part number and "call Dixon" stamped on it. This groove is a smooth concentric groove so that the stamp is legible.

Size	Schedule 80 Plated Carbon Steel Part #	316 Stainless Steel Part #
1"	STV10CS	RSTV10CS
1-1/2"	STV20CS	RSTV20CS
2"	STV25CS	RSTV25CS
2-1/2"	STV30CS	RSTV30CS
3"	STV35CS	RSTV35CS
4"	STV40CS	RSTV40CS
6"	STV60CS	RSTV60CS



Holedall[™] Fittings



- · Proper ferrule selection is very important in achieving a correct coupling-to-hose assembly
- · For higher work pressure applications use long style stems and ferrules
- · Holedall stems and ferrules are specifically designed to be used together as a coupling system
- Due to differences in dimensions and tolerances, for safety reasons, do not use other manufacturer's stems or ferrules with Holedall products

External Swage Stems



Sizes

1-1/4", 1-1/2", 2", 2-1/2", 3", 4", 5", 6", 8", 10"

Materials

Plated carbon steel, 316
stainless steel

Internal Expansion Stems

Sizes

• 1-1/4", 1-1/2", 2", 2-1/2", 3", 4"

Material

Carbon steel

Holedall Petroleum Stems

Sizes

3/4", 1", 1-1/4", 1-3/8", 1-1/2", 2", 2-1/2", 3"

Material

Brass

Features

- Designed for internal expansion only
- Recommended for discharge
 and suction service
- · Intended for fuel delivery service
- Couplings are compact, light and streamlined to eliminate catching curbs and shrubs
- Stem is expanded to nominal hose I.D. for rigid, uniform, full-flow area

External Swage Ferrules

Sizes

1-1/4", 1-1/2", 2", 2-1/2", 3", 4", 5", 6", 8", 10"

Material

Plated carbon steel

Internal Expansion Ferrules

Sizes

• 1", 1-1/4", 1-1/2", 2", 2-1/2", 3", 4", 6"

Material

Plated carbon steel

Holedall Petroleum Ferrules

Sizes

3/4", 1-3/8", 1-1/2", 2", 2-1/2", 3"

Materials

· Brass or stainless steel

Feature

· For use with Scovill style stems



Grooved Piping System Guidelines

Grooved piping systems require a careful coupling selection. To ensure a properly set up system use the following guidelines:

- 1) The coupling must suit the pipe O.D., and pressure rating for the application in which it is to be used.
- 2) Use the correct gasket to suit the media being transported/conveyed.
- 3) Make sure the correct groove dimension is used to ensure the correct fittings of the coupling to the pipe.

The following industry standards must be followed to ensure a correct pipe joint assembly.

- a) All bolts should be torqued evenly to achieve metal to metal contact at the bolt pads.
- b) Tongue and recess housings must be checked for correct alignment.
- c) Apply Dixon[®] gasket lubricant to all rubber surfaces to ensure a no pinch assembly.
- d) Test the system slowly (preferably hydrostatically) and check for leaks.
- e) Depressurize the system before carefully dismantling the couplings.



A socket wrench is the only tool needed to assemble the gasket, housing, nuts and bolts.



4

Attach the two sections of the housings and insert the bolts and nuts.

Installation Instructions



Before installing the gasket, make sure that the pipe ends are correctly grooved. Remove any burrs, scores, rust or other imperfections from the pipe ends and gasket.



5

Tighten the bolts evenly until the housings are firmly together with the metal touching.

Safety



3

Smear ordinary rubber grease on the inside and outside of the gasket. Stretch the gasket over one pipe end and bring the other pipe to be coupled into alignment. Slide the gasket into the center between the grooves on the two pipe ends.

Dixon couplings and retention devices are designed to work safely for their intended use. The selection of the proper hose, coupling and retention device, and the proper application of the coupling to the hose are of utmost importance.

Users must consider the size, temperature, application, media, pressure and hose and coupling manufacturer's recommendations when selecting the proper hose assembly components. Dixon recommends that all hose assemblies be tested in accordance with the Association for Rubber Products Manufacturer's (ARPM) recommendations and be inspected regularly (before each use) to ensure that they are not damaged or have become loose. Visit ARPMINC.com for more information.

Where safety devices are integral to the coupling, they must be working and utilized. The use of supplementary safety devices such as safety clips or safety cables are recommended.

If any problem is detected, couplings must be removed from service immediately.

Dixon is available to consult, train and recommend the proper selection and application of all fittings we sell. We strongly recommend that distributors and end users make use of Dixon Testing and Recommendation Services. Call 877.963.4966 or visit dixonvalve.com to learn more.



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