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Pipelines

TECHNICAL GUIDE

RESTRAIN™ PVC-U SEWER PIPE



IPLEX RESTRAIN™ DELIVERS PIPELINE SOLUTIONS IN



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CONTENTS

1.0 GENERAL	04
1.1 INTRODUCTION	04
1.2 APPLICATIONS	04
1.3 ADVANTAGES	05
2.0 MATERIAL PROPERTIES	06
2.1 TEMPERATURE EFFECTS	06
2.2 ELECTRICAL PROPERTIES	06
2.3 CHEMICAL RESISTANCE	06
2.4 IMPACT STRENGTH	06
3.0 PRODUCT DETAILS	07
3.1 STANDARDS AND TESTING	07
3.2 COLOUR AND MARKING	07
3.3 RUBBER RING SEALS	07
3.4 PIPE STIFFNESS	07
3.5 ENVIRONMENTAL CREDENTIALS	07
3.6 RESTRAIN™ SEWER PIPE RANGE AND DIMENSIONS	07
4.0 STRUCTURAL DESIGN	08
4.1 ALLOWABLE COVER HEIGHT	08
4.2 PIPE GROUTING	09
5.0 HANDLING AND STORAGE	11
5.1 HANDLING	11
5.2 STORAGE	11
6.0 INSTALLATION	12
6.1 DRILLING LUBRICATION	12
6.2 OVERCUT	12
6.3 JOINT ASSEMBLY AND ORIENTATION	12
6.4 JOINTING INSTRUCTIONS	12
6.5 APPROVED PIPE JOINTING LUBRICANT	14
6.6 PIPE STRAPS	14
6.7 PIPE AXIAL CAPABILITY	15
6.8 PULLING HEAD	15
6.9 INTERNAL PLUG	16
6.10 EXPANSION AND CONTRACTION	16
6.11 PIPE CURVATURE	16
6.12 SERVICE LATERAL CONNECTIONS	17
7.0 FREQUENTLY ASKED QUESTIONS	18



RESTRAIN™ PVC-U SEWER PIPE

1.0 GENERAL

1.1 INTRODUCTION

Iplex Pipelines has developed Restrain™ PVC-U Sewer Pipe specifically for gravity sewer applications utilising trenchless techniques for the installation, repair or replacement of underground infrastructure. Restrain™ is a rubber ring jointed PVC-U pipe, with a threaded spigot and socket, which provides immediate axial capability during installation.



Figure 1.1 Typical joint arrangement showing rubber sealing ring and threaded spigot and socket.

1.2 APPLICATIONS

Restrain™ Sewer Pipe is suitable for installation by a range of trenchless methods, including;

- Horizontal directional drilling (HDD)
- Pipe reaming or pipe eating
- Static pipe bursting or cracking
- Auger boring or guided boring
- Micro-tunnelling

Restrain™ Sewer Pipe is not suitable for use with pneumatic or concussive pipe bursting equipment. It is also unsuitable for pipe ramming or impact moling.

1.3 ADVANTAGES

The threaded spigot and socket provides immediate axial restraint. The rubber ring seal is seated in a groove behind the spigot thread to ensure that the rubber sealing ring is not dislodged during installation.

Restrain™ Sewer Pipe is compatible with both solvent welded and rubber ring jointed DWV PVC-U sewer pipe and fittings conforming to AS/NZS 1260.

The following table provides a summary of features and benefits.

TABLE 1.1 FEATURES AND BENEFITS OF RESTRAIN™ SEWER PIPE

FEATURE	BENEFIT
Threaded socket and spigot joint	Provides immediate axial restraint during installation using trenchless methods, saving time
Compatible with conventional DWV PVC sewer fittings to AS/NZS 1260	Allows simple connection to maintenance shafts and service laterals
Two directional installation capability	Pipe can be either pushed or pulled into place to suit installation methodology
High performance rubber sealing ring	Minimises the risk of leakage and root intrusion
Conforms to AS/NZS 1260	Use with full confidence
Manufactured from PVC-U	Suitable for installation on flat grades, is certified Best Environmental Practice PVC and qualifies for GBCA Green Star PVC credit Points.
Produced in stiffness class SN16	Suitable for use in deep installations



2.0 MATERIAL PROPERTIES

Restrain™ Sewer Pipe is manufactured from PVC-U (Unplasticised Polyvinyl Chloride). The properties listed in Tables 2.1 and 2.2 are typical for PVC-U sewer pipes.

TABLE 2.1 MECHANICAL PROPERTIES FOR PVC-U SEWER PIPE

PROPERTY	VALUE & UNIT
Density	1530 kg/m ³
Ultimate Tensile Strength	52 MPa
Compressive Strength	66 MPa
Ring Bending Modulus (3min)	3200 MPa
Ring Bending Modulus (50 yr)	1400 MPa
Hardness (Shore D)	85 (ASTM D2240)
Yield Strain	5.5 %
Poisson's Ratio	0.38

2.1 TEMPERATURE EFFECTS

PVC-U pipe is suitable for service temperatures between 0°C and 50°C, it's self-extinguishing and does not support combustion when the source of ignition is removed.

PVC-U pipe should not be used for continuous service temperatures above 50°C as deformation of the pipe may result.

Typical thermal properties are provided in the following table.

TABLE 2.2 TYPICAL THERMAL PROPERTIES

PROPERTY	VALUE & UNIT
Max Continuous Service Temperature	50°C
Specific Heat	1045 J/kg/°C
Thermal Conductivity	0.138-0.150 W/m/°C
Coefficient of Thermal Expansion	$7 \times 10^{-5} / ^\circ\text{C}$
Vicat Softening Temperature	Approx. 80°C

2.2 ELECTRICAL PROPERTIES

PVC-U pipe is non-conductive and cannot be used for earthing electrical equipment.

Typical electrical properties are shown below.

TABLE 2.3 TYPICAL ELECTRICAL PROPERTIES

PROPERTY	VALUE & UNIT
Volume Resistivity	10^{16} ohm.cm (60% RH)
Surface Resistivity	$10^{13} - 10^{14}$ ohm
Power Factor (at 20°C)	0.015 – 0.020
Dielectric Constant (at 25°C)	3.4 – 3.6 (60 Hz)

2.3 CHEMICAL RESISTANCE

PVC-U sewer pipes have high resistance to a wide range of chemical reagents. Such resistance, however, is a function of temperature, concentration and pressure.

In general, PVC-U is suitable to convey strong acids, alkalis and aqueous solutions (except those which are strongly oxidising), aliphatic hydrocarbons, fluorides, photographic and plating solutions, brine, mineral oils, fats and alcohols. The suitability of a pipeline for conveying a certain chemical will depend on such factors as the concentration of the chemical in the fluid to be conveyed, temperature, flow rate, the presence of pockets or "dead spots" in the pipeline and other factors.

Restrain™ Sewer Pipes should not be used with aromatic or chlorinated hydrocarbons, ketones, esters and ethers.

A chemical resistance guide is available on the Iplex website: www.iplex.com.au.

2.4 IMPACT STRENGTH

PVC-U sewer pipes have good impact resistance, however at very low temperatures (eg. Below 5°C) the impact resistance of PVC-U pipes is reduced. Hence, when installing pipes at low temperatures extra care should be taken when handling and inserting.

PVC-U pipes are however installed in some of the coldest regions of Europe and North America in large quantities without difficulty.

3.0 PRODUCT DETAILS

3.1 STANDARDS AND TESTING

Restrain™ Sewer Pipe is manufactured to the Australian Product Standard under a third party accredited quality assurance program complying with ISO 9001.

Restrain™ Sewer Pipe has ISO Type 5 third-party StandardsMark certification, licence number SMKP20185 in accordance with AS/NZS 1260 "PVC-U pipe and fittings for drain, waste and vent application".

3.2 COLOUR AND MARKINGS

Restrain™ Sewer Pipe is manufactured in a light grey colour with a semi-gloss finish which is opaque and flawless.

Restrain™ Sewer Pipes are marked in accordance with AS/NZS 1260 'PVC-U pipes and fittings for drain, waste and vent application'. Markings include:

- Manufacturers name and brand name
- Nominal Pipe Size
- PVC-U DWV
- SN16
- Date of manufacture
- Manufacturers code
- AS/NZS 1260
- BEP PVC

Restrain™ Sewer Pipes are repeatedly marked in accordance with AS/NZS 1260.

3.3 RUBBER RING SEALS

Rubber ring seals are styrene butadiene rubber (SBR), which conforms to the requirements of AS 1646 "Elastomeric seals for waterworks purposes". SBR rings have a high resistance to sewerage as well as mineral oils.

The rubber ring seal is supplied loose and should be stored to ensure that it is not damaged. The rubber ring seal should be placed in the pipe spigot groove during the pipe jointing process.

TABLE 3.1 RESTRAIN™ RUBBER RING SEALS

PRODUCT CODE	DN
DTRR150SBR	150
DTRR225SBR	225
DTRR300SBR	300

3.4 PIPE STIFFNESS

Restrain™ Sewer Pipe is manufactured with a minimum pipe stiffness of 16,000 N/mm and is classified as SN16. Restrain™ Sewer Pipe is therefore capable of sustaining greater loads than SN6, SN8 or SN10 DWV sewer pipe.

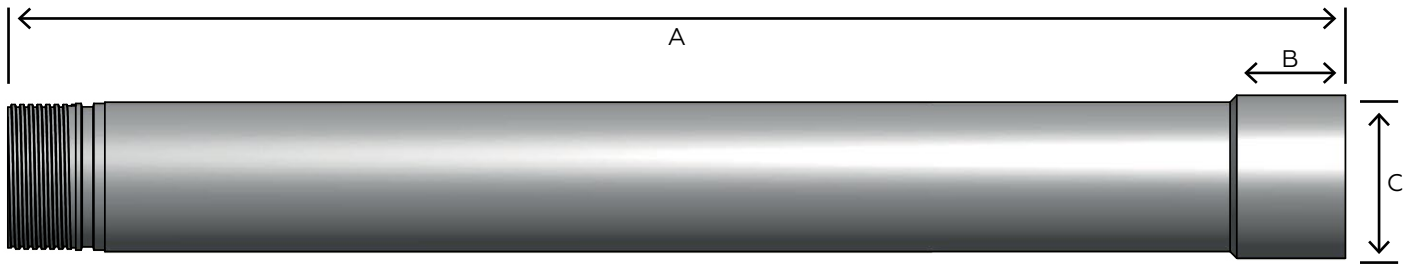
3.5 ENVIRONMENTAL CREDENTIALS

Restrain™ Sewer Pipe is certified to conform to the Best Environmental Practice PVC (BEP PVC) provisions of AS/NZS 1260.

The Green Building Council of Australia (GBCA) has defined the standards for best practice environmental performance for PVC manufacturing, against which Iplex's processes have been audited by an independent certifying body. This permits Restrain™ Sewer Pipe users to claim positive PVC Credit Points under the GBCA's Green Star rating scheme. For more information on the GBCA's Green Star rating scheme visit www.gbca.org.au.

3.6 RESTRAIN™ SEWER PIPE RANGE AND DIMENSIONS

Restrain™ Sewer Pipe is available in nominal diameters from DN150 up to DN300. The product is defined by overall length in order to facilitate on site requirements. The effective length of the pipe is the overall length less the thread length ("B").

TABLE 3.2 RESTRAIN™ SEWER PIPE RANGE AND DIMENSIONS


PRODUCT CODE	PIPE DN	SN	OVERALL LENGTH 'A' (mm)	EFFECTIVE LENGTH CONVERTER 'B' (mm)	MEAN PIPE OD (mm)	SOCKET OD 'C' (mm)	MEAN ID (mm)	MEAN WALL (mm)
DTR16150BY	150	16	2750	90	160.3	170	147.5	6.4
DTR16225BY	225	16	2750	140	250.4	260	230.6	9.9
DTR16300C	300	16	3000	140	315.5	330	290.7	12.4

NOTE: Non standard lengths may be available on request. Refer to Iplex Pipelines for availability.

PIPE FITTINGS

Restrain™ Sewer Pipe is compatible with standard PVC-U sewer fittings with both solvent weld and rubber ring joints. A full list of the range can be found in the Iplex's 'DWV Pipe and Fittings System' technical guide available on the Iplex website: www.iplex.com.au.

4.0 STRUCTURAL DESIGN

Restrain™ Sewer Pipes are defined as flexible pipes. Flexible pipes will deflect when under load and hence rely on pipe stiffness as well as soil strength to oppose the vertical loads.

External soil and live loads on buried flexible pipes will cause a small decrease in vertical diameter and an increase in horizontal diameter. The horizontal movement of the pipe walls into the soil material at the sides develops a passive resistance within the soil to support the external load. The soil type, density and the existence of water table above the pipe will influence structural performance. The greater the effective soil modulus, the less the pipe will deflect.

4.1 ALLOWABLE COVER HEIGHT

Restrain™ Sewer Pipe is manufactured from SN16 Sewer Pipe and thus can accommodate larger fill heights compared with SN6, SN8 or SN10 DWV Sewer Pipe.

4.2 PIPE GROUTING

In most situations Restrain™ Sewer Pipe will be installed via trenchless methods – horizontal directional drilling (HDD), micro-tunnelling, pipe reaming, pipe eating, static pipe bursting or cracking, auger boring or guided boring.

Where it is necessary to pressure grout the annulus between the pipe and the hole it is important to ensure that the grout is introduced as evenly as possible in a manner not to damage the Restrain™ Sewer Pipe. The grout must not exceed the pipes safe grout pressure.

For a circular ring subject to a uniform external pressure, the critical buckling pressure P_{CR} is defined by Timoshenko as:

$$P_{CR} = \frac{2.E}{((D-t)/t)^3}$$

Where:

P_{CR} = critical buckling pressure

E = short term modulus (3200 MPa)

D = pipe OD

t = wall thickness

TABLE 4.1 – SAFE BUCKLING PRESSURE @ 20°C (FACTOR OF SAFETY = 2.5)

PIPE DN	SAFE BUCKLING PRESSURE (kPa)
150	184
225	178
300	175

If necessary, the effects of grout pressures can be reduced by filling the pipeline with water prior to grouting. Alternatively it may be possible to stage the grouting process in two or three lifts, allowing the pipe to solidify in the annulus to the spring line before the top section is filled. Installers will also need to consider the effect of the grout's heat of hydration on the pipe's safe buckling pressure.





5.0 HANDLING AND STORAGE

5.1 HANDLING

Restrainer™ pipes are normally delivered in timber packs designed to hold the pipes in position and protect them from point loading and ovalisation.

Whilst Restrainer™ Sewer Pipes are easy to handle, careless handling can cause unnecessary damage to the pipe and/or its threaded joints. Pipes and fittings must not be dropped or thrown onto hard surfaces or allowed to come into contact with hard sharp objects that could inflict scratches. PVC-U pipe should not be allowed to slide across sharp edges.

Wire slings must not be used to lift pipes.

Particular care must be taken to prevent any damage to the thread on the spigot and socket keeping the thread clean and free from sand, dirt and grit which may affect the axial capacity and/or the jointing process.

5.2 STORAGE

Restrainer™ Sewer Pipes should be left in their packed units wherever possible until they are required to be installed.

If pipes and fittings are stored outdoors for more than 12 months protection from sunlight is required using a breathable material (i.e. hessian or white shade cloth) to prevent heat build up and allowing ventilation.

Pipes may be stacked on site provided the ground surface is level and free from loose stones and other sharp objects. Socketed pipes should be stacked in alternate layers of sockets facing in opposite directions to prevent load bearing.

Racks for long term storage are recommended and should preferably provide continuous support, however if this is not possible, supports of at least 75mm bearing width at 1m maximum centres should be placed beneath the pipes. Side restraints should be placed at centres not exceeding 1.5m and stacks should not exceed 1m in height.

When unloading alongside excavated trenches it is recommended that pipes be placed on the opposite side of the trench from excavated material if it is safe to do so. Rubber rings and silicone spray should be stored under cover until pipe laying commences.

Figure 5.1 Handling of block bundles

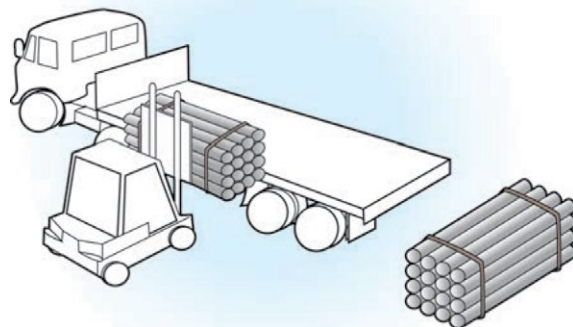


Figure 5.2 Typical loose pipe storage on ground

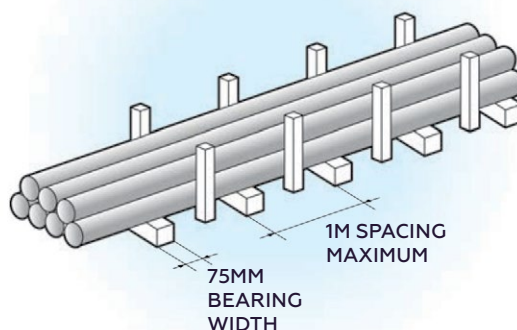
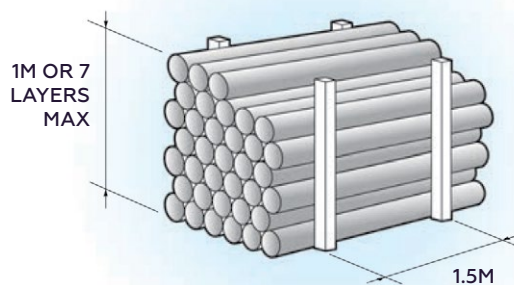


Figure 5.3 Typical loose pipes on bearers



6.0 INSTALLATION

6.1 DRILLING LUBRICATION

Trenchless applications using Restrain™ Sewer Pipe require “in hole” lubrication within the host hole with either water or an appropriate water/bentonite suspension lubricant mixture at all times.

6.2 OVERCUT

The amount of overcut of the host hole is dependent on many factors, including, the type of soil, lubrication, pipe size and line length. The host hole is normally at least 20mm larger than the maximum socket outside diameter and may be 30mm-50mm larger in rock or swelling clays.

6.3 JOINT ASSEMBLY AND ORIENTATION

Prior to lubrication and assembly check the pipe socket and spigot for any damage or scratches, especially on the threads and ensure both the Restrain™ pipe thread and seal ring are clean and free of dirt and grit.

For best results, ensure that the joint assembly is **spigot-into – socket, (not socket-over-spigot)** and that the spigot is in the direction of the pipeline insertion.



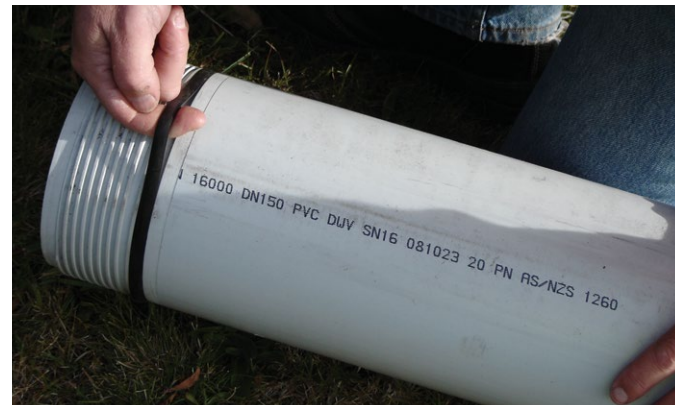
Figure 6.1 Restrain™ Sewer Pipe typical joint assembly and orientation

6.4 JOINTING INSTRUCTIONS

Regardless whether Restrain™ Sewer Pipe is installed via HDD, micro tunnelling, auger boring, static pipe bursting, pipe reaming or slip lining the method of pipe jointing will be the same.

The pipe jointing procedure is shown and described as follows;

.....



STEP 1 *Figure 6.2 Clean ends of pipe*

Ensure that the thread is clean and free from damage. Place the rubber ring in the groove (the furthest groove from the end of the pipe). The crown of the seal should be facing outwards.



STEP 2 *Figure 6.3 Lubricate surfaces*

Lubricate the spigot thread, the seal ring, the socket thread and the lead in to the socket with an approved spray lubricant.



STEP 3 *Figure 6.4 Align pipe ends*

Align the spigot with the socket in a straight line. Ensure there is a smooth initial engagement. Do not crossthread. Use temporary alignment support blocks if required.



STEP 4 *Figure 6.5 Engage thread*

Initially turn the spigot by hand in a clock-wise direction. The initial thread engagement and first few turns should be smooth and free of "binding".



STEP 5 *Figure 6.6 Start thread*

Continue to hand screw the spigot into the socket as far as it will easily go, or up to near the seal ring.



STEP 6 *Figure 6.7 Tighten joint*

For DN150 to DN225 apply the strap wrenches to both the spigot and socket and screw up pipe until the seal ring completely disappears up into the socket mouth and the joint firmly resists further tightening.



STEP 7 *Figure 6.8 Witness mark*

The end machining mark on the spigot threaded section is the approximate "witness mark"



STEP 8 *Figure 6.9 C Wrench*

A "C Wrench" assembly tool is required for the DN300 Restrainer™ Sewer Pipe due to the high torsional forces required.

6.5 APPROVED PIPE JOINTING LUBRICANT

Use only "Gensil 601", "CRC 808" or "Rocol" brand aerosol silicon lubricant or an Iplex approved equivalent for lubrication of joint prior to assembly. **Do not use conventional pipe jointing lubricant.**

The silicone spray is used to lubricate the thread and ring prior to jointing of the pipes. The lubricant also provides an ability to undo the thread should the pipes need to be removed.

6.6 PIPE STRAPS

Use strap wrenches with woven nylon webbing straps for pipe turning during assembly. "RIDGID", "Hit" or Super Ego" brand or an Iplex approved equivalent is recommended.

It is recommended that a strap wrench with an extended handle is used, at least 1200mm long for DN225 and DN300 Restrain™ Sewer Pipe. RIDGID product codes are shown below.

TABLE 6.1 RIDGID STRAP WRENCHES

DN	RIDGID CODE
150	Model 2 Cat 31345
225	Model 5 Cat 31365
300	Model 5 Cat 31365



Figure 6.10 "C wrench" assembly tool used on DN300 Restrain™ Sewer Pipe

A "C wrench" assembly tool is recommended for DN300 Restrain™ Sewer Pipe.

If it is necessary to leave the installed pipe ends exposed, protect the threaded spigot or socket ends with temporary caps. Dress threads with a file if lightly impacted or marked.

6.7 PIPE AXIAL CAPABILITY

The Restrain™ Sewer Pipe is capable of being pulled or pushed through a bore hole. The threaded spigot and socket provide axial capability. The pipe must not be over strained during the pulling or pushing process.

The maximum tensile and compressive capabilities are shown in the following table.

TABLE 6.2 MAXIMUM TENSILE AND COMPRESSIVE LOADS

PIPE DN	SN	MAX TENSILE LOAD (kN)	MAX COMPRESSIVE LOAD (kN)
150	16	29.4	29.4
225	16	93.2	93.2
300	16	117.7	117.7

6.8 PULLING HEAD

There are two types of pulling heads commonly used with Restrain™ Sewer Pipe, internal type and external type. The pulling head generally has a tapered front cone that allows drilling mud to be pushed into the annulus between the pipe and bore hole.

The pulling head is generally attached to the Restrain™ Sewer Pipe by a swivel assembly so that the pipe is not rotated during pipe reaming and/or pull back operations.



Figure 6.11 Typical external type pulling head attached to the Restrain™ Sewer Pipe



Figure 6.12 Swivel arrangements attached to Restrain™ Sewer Pipe prior to the attachment of a pulling or reaming head

6.9 INTERNAL PLUG

In some cases it is advisable to insert a plug into the lead Restrain™ Sewer Pipe in order to stop groundwater and/or drilling mud from entering the pipeline during pull back. This will ensure that the pipe joint is clean at the point of entry into the bore hole.

6.10 EXPANSION AND CONTRACTION

Distortion can occur when laying pipes in direct sunlight. When one side of the pipe is hotter than the other it might develop a slight bow. This process is reversible and the bow can be eliminated by exposing the other side to the sunlight or otherwise allowing the temperature to stabilise before installation.

Plastic pipes will expand when heated and contract when they cool. A 2.75m or 3.0m length of PVC pipe will expand/contract approximately 2mm for each 10°C rise or fall in temperature.

6.11 PIPE CURVATURE

Restrain™ Sewer Pipe must be axially aligned with the host hole at the point of entry. Some curvature back from the host hole is permitted, such as in HDD applications. Do not attempt to bend Restrain™ Sewer Pipe at the point of host entry.

The minimum radii of curvature is based on 300 x pipe OD and is shown below.

TABLE 6.3 MINIMUM RADII OF CURVATURE

PIPE DN	MEAN PIPE OD (mm)	MIN RADIUS (m)
150	160	48
225	250	75
300	315	95



6.12 SERVICE LATERAL CONNECTIONS

As Restrain™ Sewer Pipes are compatible with PVC-U pipe and fittings made in accordance with AS/NZS 1260 "PVC-U pipe and fittings for drain, waste and vent applications" connection to property or lateral connections is easily accomplished with conventional PVC sewer fittings. A full list of the range can be found in the Iplex 'DWV Pipe and Fittings System' technical guide available on the Iplex website: www.iplex.com.au.

SOLVENT WELD SADDLES

Once the Restrain™ Sewer Pipe has been installed a solvent saddle can be applied to the Restrain™ Sewer Pipe at the point of the property or service connection.

Solvent weld saddles require straps to hold the saddle in place whilst the solvent weld joint cures.

6.4 TYPICAL SOLVENT WELD SADDLE DETAILS

PRODUCT CODE	NOM SIZE	ANGLE 'a'	DIMENSIONS IN (mm)		
			'A'	'B'	'C'
D050151045	150x100	45°	250	226	55
D050221045	225x100	45°	305	250	55
D050301045	300x100	45°	305	250	55
D050301545	300x150	45°	305	330	80

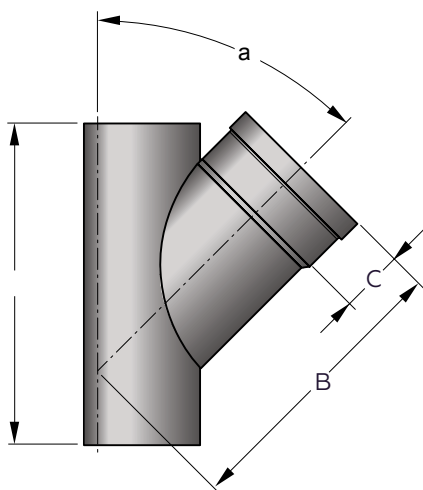


Figure 6.13 Typical solvent weld saddle details

OBLIQUE JUNCTIONS

After the Restrain™ Sewer Pipe has been installed a section of the Restrain™ Sewer Pipe is cut out and an oblique reducing junction is installed with the use of DWV slip couplings.

STAINLESS STEEL COUPLINGS

Alternatively stainless steel clamps with DWV sockets can be clamped directly to the Restrain™ Sewer Pipe.

7.0 FREQUENTLY ASKED QUESTIONS

Q1 Is Restrain™ Sewer Pipe compatible with DWV pipe and fittings?

Yes, Restrain™ Sewer Pipe is fully compatible with DWV pipe and fittings manufactured in accordance with AS/NZS 1260 "PVC-U pipe and fittings for drain, waste and vent application".

.....

Q2 How is Restrain™ Sewer Pipe tested?

Restrain™ Sewer Pipe is tested in the same manner as conventional DWV sewer pipe. Refer to AS/NZS2566.2 "Installation of flexible pipelines", AS/NZS 2032 "Installation of PVC pipe systems", WSA02 Sewerage Code of Australia and/or project specific documentation.

.....

Q3 Can I solvent weld Restrain™ Sewer Pipe to DWV sewer pipe and fittings?

Yes, Restrain™ Sewer Pipe has the same outside diameter as conventional DWV sewer pipe and can be solvent welded to DWV pipe and fittings in accordance with AS/NZS 1260 "PVC-U pipe and fittings for drain, waste and vent application". Ensure that the spigot or socket thread has been cut off before jointing to the solvent weld pipe or fitting.

.....

Q4 Why can't I use rubber ring pipe lubricant on the thread and rubber ring?

The threaded joint requires specific long lasting lubricating properties that are not provided by conventional pipe jointing lubricants.

.....

Q5 Why is a different pulling head necessary?

The pulling head allows the drilling mud in the bore hole to be pushed into the annulus between the pipe and the hole. It also protects the end of the Restrain™ Sewer Pipe. Wind-up pulling heads designed for PE pipe may be unsuitable for Restrain™ Sewer Pipe as the internal engagement grooves may be unable to effectively grip the hard PVC surface. Crossbolt style pulling heads are therefore recommended.





FOR ALL ENQUIRIES AND ORDERS CONTACT IPLEX PIPELINES

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