

DUCTILE IRON OR PVC SPIGOT TO DUCTILE IRON SOCKET

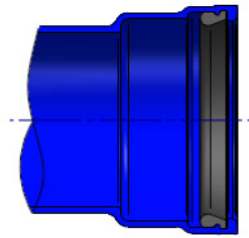
INSTALLATION GUIDELINES

STEP 1 - SOCKET AND SEAL

Generally, socket joints are supplied with the rubber ring/seal fitted (as shown below). Apply approved lubricant to the seal.

Note

If the rubber ring/seal is not fitted, do not lubricate the ring/seal or the ring groove of the socket as this may cause the rubber ring/seal to roll or dislodge during installation.



STEP 2 - SPIGOT

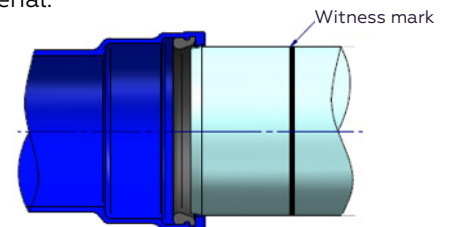
Where a pipe needs to be cut in the field ensure the spigot has been cut square and with a chamfer as per the manufacturer's recommendations. Remove any burrs and place a witness mark by measuring the depth of the socket. For cut sections of pipe the squareness and chamfer of the cut pipe will ensure ease of jointing.

Note

Ensure the sealing surface of the spigot is clean from dirt or any loose material.

Alignment

The key to jointing is aligning the spigot to the socket in a straight line. This will ensure the applied force during the jointing process is not being lost in misalignment.

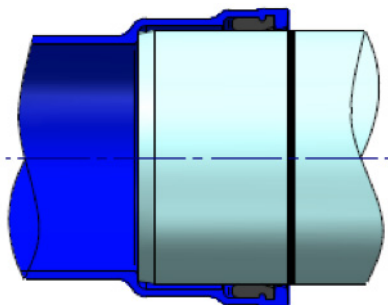


STEP 3 – RESTRAINT

It is important to restrain the fitting during the jointing process. Bends, tees, or other fittings need to be restrained by manual or mechanical means. Bends are more difficult than tees and have bosses and lugs cast in to restrain and aid in the jointing process.

Note

Care should be taken to avoid damaging the pipe/fittings when restrained.



Jointing

Ensure approved lubricant is applied evenly to the spigot up to the witness mark, including the pipe chamber, once jointed, the spigot may be moved easily within the socket, but as the lubricant dries this will be more difficult. Use a crowbar to apply force onto a wooden block bearing against the pipe end.

Note

Jointing force must be applied consistently. Once the spigot end has passed the seal and moved approximately 20-40mm inside, the force applied will decrease significantly.

Deflection

To achieve pipe deflection, insert the spigot as per above mentioned steps after which the pipe needs to be pulled back slightly and then deflected.

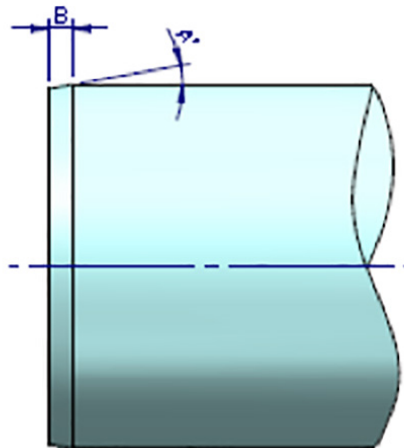
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IRONTITE® DUCTILE IRON

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DN	TYPICAL CHAMFER GUIDE (mm)					
	PVC-O		PVC-M		DUCTILE IRON	
	A°	B	A°	B	A°	B
80	N/A	N/A	N/A	N/A	20	10
100	15	6	15	15	20	10
150	15	9	15	18	20	10
200	15	12	15	21	20	10
225	15	13	15	22	20	10
250	15	14	15	23	20	10
300	15	17	15	26	20	10
375	N/A	N/A	15	30	20	16
450	N/A	N/A	15	32	20	16
500	N/A	N/A	15	42	20	16
600	N/A	N/A	N/A	N/A	20	16
750	N/A	N/A	N/A	N/A	20	20



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