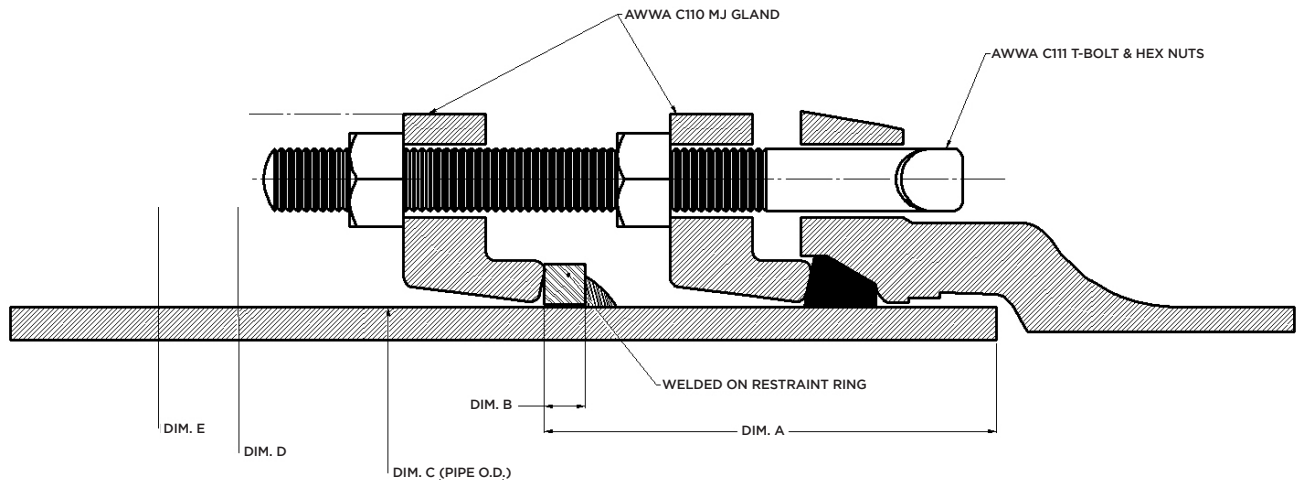




IRON STRONG

DUCTILE IRON PIPE MECHANICAL JOINT LOCK JOINT

6"-30"



ASSEMBLY INSTRUCTIONS

STEP 1A. Gather all necessary PPE, tools, and materials such as a wire brush, paint brush, pipe lube, and wrench.



STEP 1A

STEP 1B. Clean the bell socket and spigot or plain end. Be sure to remove any dirt, ice, or foreign matter from the inside of the bell.



STEP 1B

STEP 2A. Place the gland on the plain end with the lip extension toward the plain end.



STEP 2A

STEP 2B. Lubricate both the gasket and plain end by brushing on approved pipe lubricant. Place the gasket on the plain end with the narrow edge facing the plain end.



STEP 2B

Continued on next page...

ASSEMBLY INSTRUCTIONS CONTINUED...

STEP 3A. Insert the plain end of the pipe into the MJ bell until it rests against the back of the bell. Press the gasket into the bell recess.



STEP 3A

STEP 3B. Press the gasket into the bell recess. Push the gland toward the socket and center it around the pipe with the gland lip against the gasket.



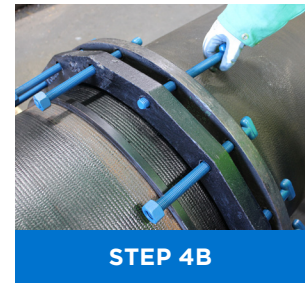
STEP 3B

STEP 4A. Slide the second gland away from the spigot end to allow enough room for the joint assembly with the first gland.



STEP 4A

STEP 4B. Insert T-head bolt and (1) nut in the first gland.



STEP 4B

STEP 5A. Snug the bolts by hand. It is important to maintain the same distance between the gland and the bell face at all times for a proper seal.



STEP 5A

STEP 5B. Tighten bolts using a torque wrench. Alternate side to side and top to bottom to achieve equal distance and torque.

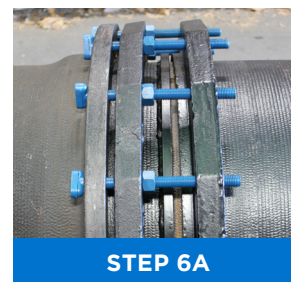


STEP 5B

NOTE: Achieving the recommended bolt torque, particularly with large diameter pipe, may require repeating Step 5B up to five times or more. Recommended bolt torque ranges are as follows:

Pipe Size in.	Bolt Diameter in.	Nut Across Flats in.	Torque Range Foot lbs.
3	5/8	1-1/16	45 to 60
4-24	3/4	1-1/4	75 to 90
30	1	1-1/2	100-120

STEP 6A. Slide second gland onto the bolts and attach the second set of nuts.



STEP 6A

STEP 6B. These will be tightened to 20 foot pounds of torque.



STEP 6B



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