

5 EASY STEPS TO PUSH-ON JOINT ASSEMBLY

DO IT RIGHT – WATER TIGHT!

A displaced or rolled gasket creating water loss in a ductile iron pipeline is one of the most common errors that occurs during joint assembly. **To avoid displacing or rolling a gasket and to ensure proper joint assembly, be sure to follow these 5 easy steps.**



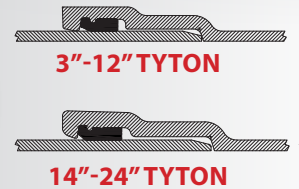
BELL CLEANING

Thoroughly clean out the bell. Remove all foreign matter, dirt, sand, mud, ice, or excess paint or lining. Use a damp cloth. For caked-on debris, use a wire brush or chisel and flush with water.



PLAIN-END PREP

Clean the plain-end, removing any dirt, foreign matter, or excess paint. On a field-cut, use a file to make sure the plain-end is beveled as shown above. Smooth any sharp edges that might damage the gasket.



GASKET INSERTION

Using a V-shape fold as shown above, insert the gasket in its recess inside the bell, with the large end of the gasket entering first. Make sure the gasket faces in the correct direction and is properly seated as illustrated.



LUBRICATION

Apply a thin coating of lubricant to the inside surface of the installed gasket just prior to joint assembly. Make certain the entire inner surface of the gasket is coated. Also apply a thin coating of lubricant to the beveled portion of the plain-end.

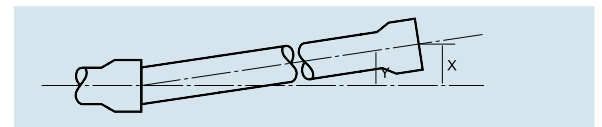


JOINING

Guide the plain-end of the bell and compress the gasket by pushing the plain-end all the way into the bell socket. Keep the bell and plain-end in reasonably straight alignment during assembly. Any deflection should be taken after the joint is assembled.

For more detailed instructions and a video, see our "How to Avoid Displaced or Rolled Gaskets" blog at McWaneDuctile.com/Blog.

JOINT DEFLECTION CHART



PUSH-ON JOINT PIPE
Maximum Allowable Joint Deflection

Pipe Size In.	Y-Maximum Joint Deflection in Degrees	X Deflection in Inches 18 ft. Length	Approximate Radius in ft. of Curve Produced by Succession of Joints 18 ft. Length
3	5°	19	205
4	5°	19	205
6	5°	19	205
8	5°	19	205
10	5°	19	205
12	5°	19	205
14	5°	19	205
16	5°	19	205
18	5°	19	205
20	5°	19	205
24	5°	19	205
30	5°	19	205
36	4°	15	260