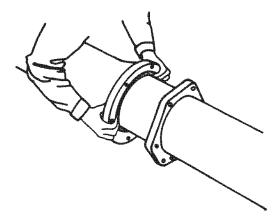


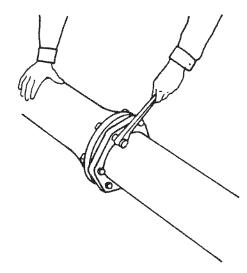
1. Clean the socket and the plain end. Lubrication and additional cleaning should be provided by brushing both the gasket and plain end with soapy water or an approved pipe lubricant meeting the requirements of ANSI/AWWA C111/A21.11 just prior to slipping the gasket onto the plain end for joint assembly. Place the gland on the plain end with the lip extension toward the plain end, followed by the gasket with the narrow edge of the gasket toward the plain end. NOTE: In cold weather it is preferable to warm the gasket to facilitate assembly of the joint.



2. Insert the pipe into the socket and press the gasket firmly and evenly into the gasket recess. Keep the joint straight during assembly.



3. Push the gland toward the socket and center it around the pipe with the gland lip against the gasket. Insert bolts and hand-tighten nuts. Make deflection after joint assembly but before tightening bolts.



4. Tighten the bolts to the normal range of bolt torque as indicated in Table 1 while at all times maintaining approximately the same distance between the gland and the face of the flange at all points around the socket. This can be accomplished by partially tightening the bottom bolt first, then the top bolt, next the bolts at either side, finally the remaining bolts. Repeat the process until all bolts are within the appropriate range of torque. In large sizes (30–48 in. [762–1,219 mm]), five or more repetitions may be required. The use of a torque-indicating wrench will facilitate this procedure.

Figure 3 Mechanical-joint assembly