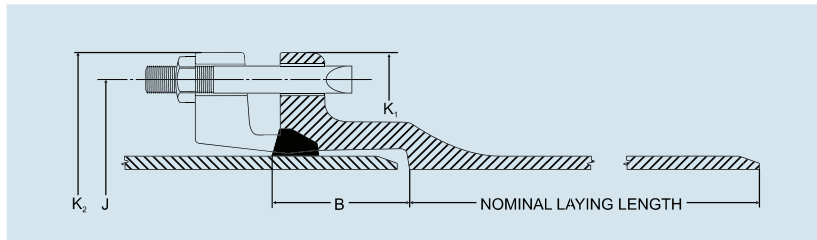




For Generations

MECHANICAL JOINT PIPE



Pipe Size In.	Pipe Thickness In.		Outside Diameter In.	*Dimensions In.						Bolts		Bell Weight Lb.	Gland** Bolts Gasket Weight Lb.
	From	To		B	J	K1	K2	No.	Size In.	Length In.			
3	.25	.40	3.96	2.50	6.19	7.62	7.69	4	5/8	3	11	7	
4	.26	.41	4.80	2.50	7.50	9.06	9.12	4	3/4	3-1/2	16	10	
6	.25	.43	6.90	2.50	9.50	11.06	11.12	6	3/4	3-1/2	18	16	
8	.27	.45	9.05	2.50	11.75	13.31	13.37	6	3/4	4	24	25	
10	.29	.47	11.10	2.50	14.00	15.62	15.62	8	3/4	4	31	30	
12	.31	.49	13.20	2.50	16.25	17.88	17.88	8	3/4	4	37	40	
14	.33	.51	15.30	3.50	18.75	20.25	20.25	10	3/4	4-1/2	61	45	
16	.34	.52	17.40	3.50	21.00	22.50	22.50	12	3/4	4-1/2	74	55	
18	.35	.53	19.50	3.50	23.25	24.75	24.75	12	3/4	4-1/2	85	65	
20	.36	.54	21.60	3.50	25.50	27.00	27.00	14	3/4	4-1/2	98	85	
24	.38	.56	25.80	3.50	30.00	31.50	31.50	16	3/4	5	123	105	

* Nominal laying length is 18 ft.

** Weight shown for regular grey cast iron follower gland, corton bolts and rubber gasket.

ASSEMBLY INSTRUCTIONS

- Step 1. Clean the bell socket and spigot or plain end. Lubricate both the gasket and plain end by brushing an approved pipe lubricant.
- Step 2. Place the gland on the plain end with the lip extension toward the plain end. Place the gasket on the plain end with the narrow edge facing the plain end.
- Step 3. Insert the plain end into the bell and 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 4. Insert and tighten the bolts. It is important to maintain the same distance between the gland and the bell face at all times. This is best done by alternating side to side and top to bottom, while tightening the bolts.

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

Pipe Size In.	Bolt Diameter In.	Nut Across Flats In.	Wrench Length In.	Torque Range Foot Lbs.
3	5/8	1-1/16	8	45 to 60
4-24	3/4	1-1/14	10	75 to 90



IRON STRONG



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