

## 4" - 36" DUCTILE IRON TR FLEX<sup>®</sup> PIPE

<b>MATERIAL</b>	Ductile Iron per AWWA C150/ANSI A21.50, AWWA C151/ANSI A21.51, ASTM A536
<b>PRESSURE</b>	350 PSI Water Working Pressure 4" - 24" & 250PSI FOR 30 & 36"
<b>TESTING</b>	ANSI / AWWA C151 / ANSI 21.51 & UL - FM requirements
<b>LAYING LENGTH</b>	18 foot Nominal Length
<b>CEMENT LINING</b>	ANSI / AWWA C104 / ANSI 21.4
<b>COATING</b>	ANSI / AWWA C104 / ANSI 21.4
<b>GASKETS</b>	ANSI / AWWA C111/ ANSI A21.11
<b>STANDARDS</b>	AWWA C150/ANSI A21.50, AWWA C151/ANSI A21.51, AWWA C104 / ANSI 21.4, AWWA C111/ ANSI A21.11



4"-20"



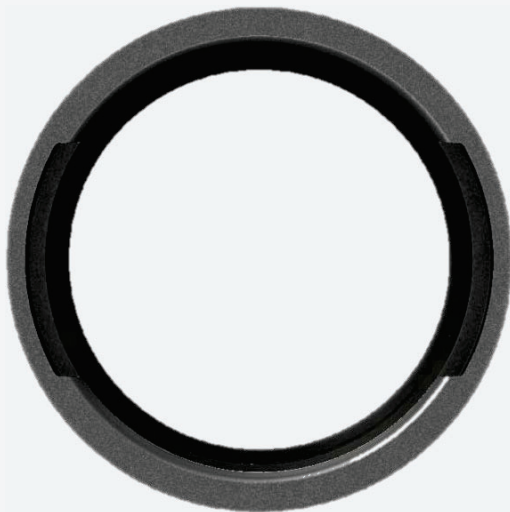
24"-36"

❖ All Dimensions are in Inches

## 4" - 36" DUCTILE IRON TR FLEX<sup>®</sup> PIPE ASSEMBLY INSTRUCTIONS

### TR Flex<sup>®</sup> pipes and fittings assembly instructions:

- When laying a pipe or fitting in a trench, orient the locking segment insertion bell slots so that:
  - The 2 slots on 4" - 20" pipe are at the horizontal or 3 and 9 o'clock positions
  - The 4 slots on 24" - 36" pipe are at the 2, 4, 8 and 10 o'clock positions or forming an 'X' when looking at the bell face



**4"-20"**



**24"-36"**

- Thoroughly clean the bell cavity area including the gasket seat and the locking segment groove to remove all dirt, debris and any foreign material(s) that could inhibit proper gasket sealing or locking segment placement. Ensure the gasket seat area is dry
- Insert a standard Tyton gasket in the bell socket, make sure the retainer bead on the heel of the gasket is fully inserted into the corresponding socket groove
- Apply a thin but continuous layer of lubricant on the installed gasket and the pipe spigot up to the weld bead
- Keeping the mating pipe aligned, insert the pipe spigot into the corresponding pipe bell and push home
- There are two locking segments for 4" - 10" joints, four locking segments for 12" - 20" joints and eight locking segments for 24" - 36" joints
- Insert the locking segments one at a time into the bell slots and rotate / slide each locking segment into the bell cavity. Red segments rotate to the right and black segments rotate to the left
- Insert the rubber retainer into the bell slot between two installed locking segments to retain the locking segments in their correct position
- Once all locking segments and rubber retainers are properly installed, pull back on the installed joint to fully extend the joint and set any desired deflection