

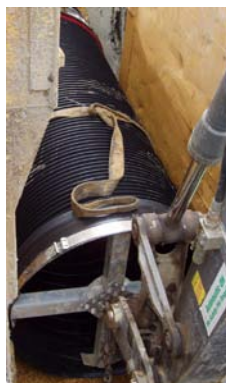
Joining - Spigot/Socket Joint (600 - 2250mmØ)



1. Ensure that the first pipe to be laid is placed in the correct direction with the spigot end facing downstream.
2. The receiving pipe should be anchored with 75% of backfill in place.
3. The spigot and socket ends of the pipe should be clean and free from significant debris.
4. The rubber ring seal around the spigot is factory fitted but should be checked immediately prior to installation to ensure that it has not been damaged.
5. Slacken the stainless steel creep band, such that it is relatively loose. Also, prior to joining, make sure that the tightening bolts are at, or towards the top of the pipe.
6. Apply lubricant around the inner bore of the socket end of the adjoining (receiving) pipe.
7. Lay the pipe up to the adjoining (receiving) pipe and locate the spigot inside the socket.



8. Using the AquaSpira Joining Frame, position the frame inside the socket of the pipe to be joined, and with the arm of the machine, gently nudge the pipe home.



9. Check alignment of the pipe (1° maximum angle). The pipe is fully inserted when the bright red section on the spigot is fully inside the socket and is no longer visible.
10. Tighten up the creep bands until they are hand tight, approximately 8Nm torque, but no more than 12Nm.