

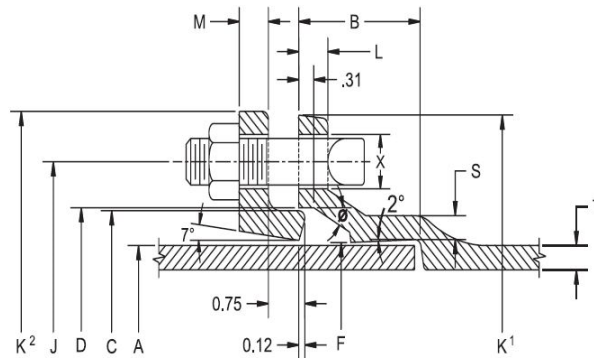
DOMESTIC

NON-DOMESTIC

SUBMITTAL: C153 MECHANICAL JOINT PRODUCT

(Current revisions for the noted Standards apply)

- SIZES:** 2" - 64" (2" not included in ANSI/AWWA C153 standard)
- STANDARDS:** ANSI/AWWA C153/A21.53, NFPA13/24, 3"-16" UL and 3"-10" FM listed & approved (File - Tyler Union)
- MATERIAL:** Cast of ASTM A536 qualified ductile iron. Date code is cast on and required for traceability.
- PRESSURE RATING:** *Flanged fittings rated at 250 psi. Mechanical joints 2" – 24" rated at 350 psi and 30" – 48" at 250 psi.
*Note: With rubber annular ring flange gasket, 2" – 24" Flanged fittings can be rated at 350 psi.
Note: Wyes over 12" are not pressure rated. Contact Tyler Union for rating in your application.
- DEFLECTION:** Joint deflection 5° max for 2"– 12" and 3° max for 14"– 48". Reduces by 50% at nominal pipe & fitting diameters
- NSF-61 & NSF372:** Meets all requirements including Annex G, Tyler Union's Underwriters Laboratory listing MH16439.
- ASPHALT COATING:** Per ANSI/AWWA C104/A21.4 and ANSI/AWWA C153/A21.53.
- CEMENT LINING:** Per ANSI/AWWA C104/A21.4, with double cement lining available upon request.
- EPOXY COATING:** Fusion bonded epoxy per ANSI/AWWA C116/A21.16. Additional coatings available upon request.
- BARE FITTINGS:** Available upon request.
- FASTNERS:** High strength low alloy weathering steel per ANSI/AWWA C111/A21.11 and ASTM A242
- INSTALLATION:** Install per AWWA C600/C651 using pipe conforming to ANSI/AWWA C151/A21.51 or AWWA C900/905.



NOMINAL JOINT DIMENSIONS IN INCHES

BOLTS

Size Inches	A Dia. DI Pipe	B Hub Depth	C Dia. GLAND	D Dia.	F Dia.	J Dia. GLAND	K ¹ Dia.	K ² Dia. GLAND	L	M GLAND	S	T	X	Size	Qty.
2	2.51	2.50	3.50	3.60	2.61	4.75	6.19	6.89	0.58	0.62	0.36	0.30	3/4	5/8x3	2
3	3.96	2.50	4.84	4.94	4.06	6.19	7.62	7.69	0.58	0.62	0.39	0.33	3/4	5/8x3	4
4	4.80	2.50	5.92	6.02	4.90	7.50	9.06	9.12	0.60	0.75	0.39	0.34	7/8	3/4x3-1/2	4
6	6.90	2.50	8.02	8.12	7.00	9.50	11.06	11.12	0.63	0.88	0.43	0.36	7/8	3/4x3-1/2	6
8	9.05	2.50	10.17	10.27	9.15	11.75	13.31	13.37	0.66	1.00	0.45	0.38	7/8	3/4x4	6
10	11.10	2.50	12.22	12.34	11.20	14.00	15.62	15.62	0.70	1.00	0.47	0.40	7/8	3/4x4	8
12	13.20	2.50	14.32	14.44	13.30	16.25	17.88	17.88	0.73	1.00	0.49	0.42	7/8	3/4x4	8
14	15.30	3.50	16.40	16.54	15.44	18.75	20.31	20.25	0.79	1.25	0.55	0.47	7/8	3/4x4-1/2	10
16	17.40	3.50	18.50	18.64	17.54	21.00	22.56	22.50	0.85	1.31	0.58	0.50	7/8	3/4x4-1/2	12
18	19.50	3.50	20.60	20.74	19.64	23.25	24.83	24.75	1.00	1.38	0.68	0.54	7/8	3/4x4-1/2	12
20	21.60	3.50	22.70	22.84	21.74	25.50	27.08	27.00	1.02	1.44	0.69	0.57	7/8	3/4x4-1/2	14
24	25.80	3.50	26.90	27.04	25.94	30.00	31.58	31.50	1.02	1.56	0.75	0.61	7/8	3/4x5	16
30	32.00	4.50	33.29	33.46	32.17	36.88	39.12	39.12	1.31	2.00	0.82	0.66	1-1/8	1x6	20
36	38.30	4.50	39.59	39.76	38.47	43.75	46.00	46.00	1.45	2.00	1.00	0.74	1-1/8	1x6	24
42	44.50	4.50	45.79	45.96	44.67	50.62	53.12	53.12	1.45	2.00	1.25	0.82	1-3/8	1-1/4x6-1/2	28
48	50.80	4.50	52.09	52.26	50.97	57.50	60.00	60.00	1.45	2.00	1.35	0.90	1-3/8	1-1/4x6-1/2	32
54	Available on Request														
60	Available on Request														
64	Available on Request														

Anniston: 1501 W 17th St. • Anniston, AL 36201 • (800) 226-7601
Corona: 1001 El Camino Ave. • Corona, CA 92879 • (866) 527-8471
Tyler: 11910 CR 492 • Tyler, Texas 75706 • (800) 527-8478
Dallas: 1201 Ave. S. Suite100 • Grande Prairie, TX 75050

Elmer: 701 Kenyon Ave. • Elmer, New Jersey 03318
New Lenox: 2200 West Haven • New Lenox, IL 60451
Portland: 15670 N. Lombard St. • Portland, OR 97203
Oxford: 1800 Greenbrier Dear Road • Anniston, AL 36207

C153 DUCTILE IRON COMPACT FITTINGS

SAMPLE SPECIFICATIONS

(Current ANSI/AWWA revisions apply)

Mechanical joint watermain fittings with accessories, 2" through 64" shall be manufactured from ductile iron in accordance with and meet all applicable terms and provisions of standards ANSI/AWWA C153/A21.53 and ANSI/AWWA C111/A21.11. Ductile iron mechanical joint fittings 2" through 24" shall be rated for 350 psi working pressure. Ductile iron 30" through 48" shall be rated for 250 psi working pressure. Flanged ductile iron fittings in 4" (610 mm) and smaller sizes may be rated for 350 psi (2,413 kPa) with the use of special (annular ring or comparable) gaskets. All coated and lined fittings meet requirements of NSF-61, NSF-372 and Annex G.

NOTE: EXCEPTIONS: Mechanical joint fittings with flanged branches are rated for water pressure of 250 psi.

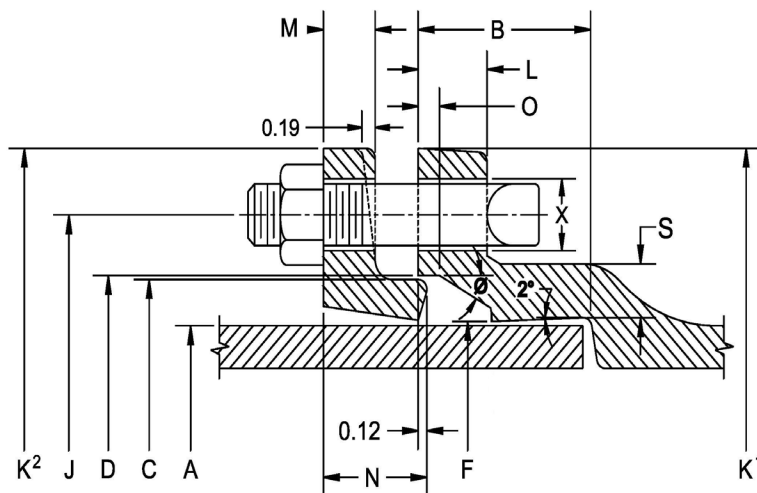
NOTE: Wyes over 12" are not pressure rated. Contact manufacturer for rating in your application.

NOTE: Fittings are cement lined and seal coated in accordance with ANSI/AWWA C104/A21.4. Fittings are available double cement-lined, bare, or epoxy coated upon request. Epoxy coating per ANSI/AWWA C116.

NOTE: Installation per AWWA C600 and AWWA C651, current revision.

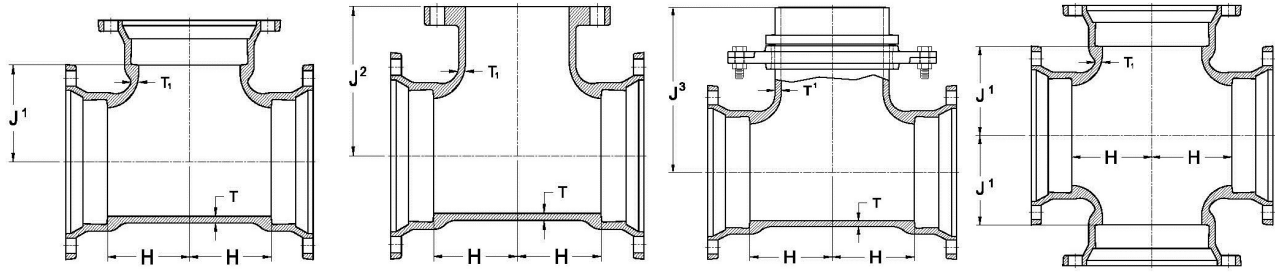
Nominal Joint Dimensions in Inches														
Size	A	B	C	D	F	ø	X	J	K1	K2	L	M	O	S
2	2.51	2.50	3.50	3.60	2.61	28°	3/4	4.75	6.19	6.89	0.58	0.62	0.31	0.36
3	3.96	2.50	4.84	4.94	4.06	28°	3/4	6.19	7.62	7.69	0.58	0.62	0.31	0.39
4	4.80	2.50	5.92	6.02	4.90	28°	7/8	7.50	9.06	9.12	0.60	0.75	0.31	0.39
6	6.90	2.50	8.02	8.12	7.00	28°	7/8	9.50	11.06	11.12	0.63	0.88	0.31	0.43
8	9.05	2.50	10.17	10.27	9.15	28°	7/8	11.75	13.31	13.37	0.66	1.00	0.31	0.45
10	11.10	2.50	12.22	12.34	11.20	28°	7/8	14.00	15.62	15.62	0.70	1.00	0.31	0.47
12	13.20	2.50	14.32	14.44	13.30	28°	7/8	16.25	17.88	17.88	0.73	1.00	0.31	0.49
14	15.30	3.50	16.40	16.54	15.44	28°	7/8	18.75	20.25	20.25	0.79	1.25	0.31	0.55
16	17.40	3.50	18.50	18.64	17.54	28°	7/8	21.00	22.50	22.50	0.85	1.31	0.31	0.58
18	19.50	3.50	20.60	20.74	19.64	28°	7/8	23.25	24.75	24.75	1.00	1.38	0.31	0.68
20	21.60	3.50	22.70	22.84	21.74	28°	7/8	25.50	27.00	27.00	1.02	1.44	0.31	0.69
24	25.80	3.50	26.90	27.04	25.94	28°	7/8	30.00	31.50	31.50	1.02	1.56	0.31	0.75
30	32.00	4.00	33.29	33.46	32.17	20°	1 1/8	36.88	39.12	39.12	1.31	2.00	0.38	0.82
36	38.30	4.00	39.59	39.76	38.47	20°	1 1/8	43.75	46.00	46.00	1.45	2.00	0.38	1.00
42	44.50	4.00	45.79	45.96	44.67	20°	1 3/8	50.62	53.12	53.12	1.45	2.00	0.38	1.35
48	50.80	4.00	52.09	52.26	50.97	20°	1 3/8	57.50	60.00	60.00	1.45	2.00	0.38	1.35
54	57.56	4.00	58.82	59.02	57.73	20°	1 3/8	63.20	65.70	65.70	1.55	2.00	0.38	1.45
60	61.61	4.00	62.87	63.07	61.78	20°	1 3/8	67.72	70.22	70.22	1.75	2.00	0.38	1.50
64	65.67	4.00	66.96	67.13	65.84	20°	1 3/8	71.86	74.36	74.36	1.75	2.00	0.38	1.50

NOTE: For projects where product weights, specifications or dimensions are critical, advise upon order placement



ANSI/AWWA
C153 Mechanical Joint Fittings

C153 DUCTILE IRON COMPACT FITTINGS

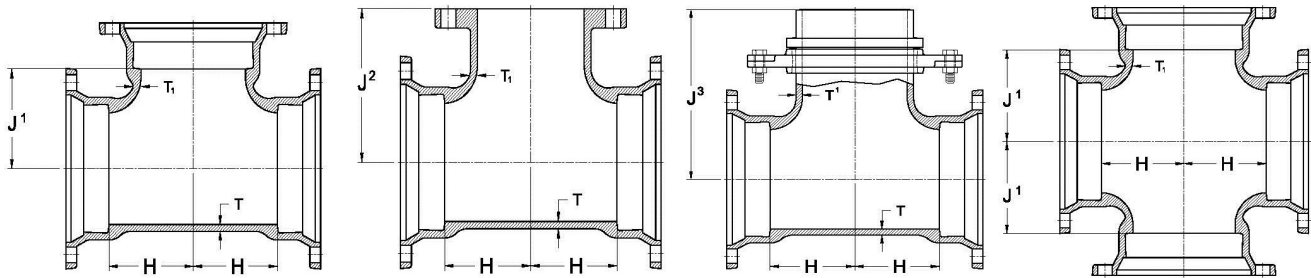


		MJ Tee						MJxFE Tee				MJxSwivel Tee				Cross	
		Domestic						Weight				Import				Weight	
Size	T	T1	H	J1	J2	J3	MJ	MJ x FE	†MJ x S	Cross	T	T1	H	J1	MJ	Cross	
3	0.34	0.34	3.50	3.50	5.50	—	26	29	—	31	0.33	0.33	3.00	3.00	28	35	
4x3	0.35	0.34	3.50	4.00	6.50	—	35	34	—	39	0.34	0.33	3.50	4.00	30	34	
4	0.35	0.35	4.00	4.00	6.50	—	37	39	—	45	0.34	0.34	4.00	4.00	32	40	
6x3	0.37	0.34	4.00	4.00	6.50	—	51	54	—	—	0.36	0.33	3.50	5.00	42	—	
6x4	0.37	0.35	5.00	6.00	8.00	—	52	57	—	62	0.36	0.34	4.00	5.00	46	57	
6	0.37	0.37	6.00	6.00	8.00	10.50	62	69	61	72	0.36	0.36	5.00	5.00	56	75	
8x3	0.39	0.34	4.00	6.50	9.00	—	56	—	—	—	—	—	—	—	—	—	
8x4	0.39	0.35	5.00	6.50	9.00	—	68	82	—	84	0.38	0.34	4.00	6.50	60	68	
8x6	0.39	0.37	5.50	6.50	9.00	11.50	79	87	105	98	0.38	0.36	5.00	6.50	72	74	
8	0.39	0.39	6.50	6.50	9.00	11.50	89	101	116	112	0.38	0.38	0.38	6.50	86	105	
10x3	0.41	0.34	4.00	7.50	11.00	—	80	—	—	—	—	—	—	—	—	—	
10x4	0.41	0.35	4.50	7.50	11.00	—	82	92	—	98	0.40	0.34	4.00	7.50	78	112	
10x6	0.41	0.37	5.50	7.50	11.00	13.00	99	116	114	121	0.40	0.36	5.00	7.50	90	119	
10x8	0.41	0.39	6.50	7.50	11.00	13.00	116	128	138	135	0.40	0.38	6.50	7.50	105	124	
10	0.41	0.41	7.50	7.50	11.00	—	132	144	—	156	0.40	0.40	7.50	7.50	120	145	
12x3	0.43	0.34	4.00	8.75	12.00	—	99	—	—	—	—	—	—	—	—	—	
12x4	0.43	0.35	4.00	9.00	12.00	—	108	118	—	119	0.42	0.34	4.00	8.75	94	119	
12x6	0.43	0.37	5.00	9.00	12.00	14.25	119	133	132	138	0.42	0.34	4.00	8.75	110	126	
12x8	0.43	0.39	6.50	9.00	12.00	14.25	126	146	149	149	0.42	0.38	6.50	8.75	125	149	
12x10	0.43	0.41	7.50	8.75	12.00	—	159	174	—	187	0.42	0.40	7.50	8.75	140	179	
12	0.43	0.43	8.75	8.75	12.00	—	171	198	—	202	0.42	0.42	8.75	8.75	160	213	
14x6	0.51	0.44	6.50	10.50	14.00	16.00	183	205	211	210	0.47	0.36	6.50	10.50	182	200	
14x8	0.51	0.45	7.50	10.50	14.00	—	211	—	—	231	0.47	0.38	7.50	10.50	206	228	
14x10	0.51	0.46	8.50	10.50	14.00	—	229	244	—	255	0.47	0.40	8.50	10.50	228	—	
14x12	0.51	0.47	9.50	10.50	14.00	—	245	284	—	269	0.47	0.42	9.50	10.50	234	—	
14	0.51	0.51	10.50	10.50	14.00	—	281	291	—	299	0.47	0.47	10.50	10.50	280	299	
16x6	0.52	0.45	6.50	11.50	14.00	16.00	222	230	243	250	0.50	0.36	6.50	11.50	228	240	
16x8	0.52	0.46	7.50	11.50	15.00	—	245	248	—	264	0.50	0.38	7.50	11.50	248	385	
16x10	0.52	0.47	8.50	11.50	15.00	—	265	287	—	286	0.50	0.40	8.50	11.50	264	—	
16x12	0.52	0.48	9.50	11.50	15.00	—	277	312	—	312	0.50	0.42	9.50	11.50	280	—	
16x14	0.52	0.51	10.50	11.50	15.00	—	317	348	—	—	0.50	0.47	10.50	11.50	316	—	
16	0.52	0.52	11.50	11.50	15.00	—	337	324	—	451	0.50	0.50	11.50	11.50	322	—	
18x6	0.59	0.44	6.50	14.50	15.50	18.00	275	261	279	—	0.54	0.36	6.50	12.50	275	—	
18x8	0.59	0.45	7.50	14.50	14.50	—	280	351	—	—	0.54	0.38	7.50	12.50	295	—	
18x10	0.59	0.47	8.50	12.50	—	—	286	—	—	—	0.54	0.40	8.50	12.50	315	—	
18x12	0.59	0.49	9.50	12.50	—	—	372	—	—	—	0.54	0.42	9.50	12.50	335	348	
18x14	0.59	0.56	10.50	12.50	—	—	415	—	—	—	0.54	0.47	10.50	12.50	380	—	
18x16	0.59	0.57	11.50	12.50	—	—	445	—	—	—	0.54	0.50	11.50	12.50	405	—	
18	0.59	0.59	13.00	12.50	—	—	490	—	—	—	0.54	0.54	12.50	12.50	435	348	
20x6	0.60	0.44	7.00	14.00	16.00	19.50	335	362	358	—	0.57	0.36	6.50	14.00	315	—	
20x8	0.60	0.45	8.00	14.00	—	—	390	—	—	—	0.57	0.38	8.00	14.00	345	379	
20x10	0.60	0.47	9.00	14.00	—	—	417	—	—	—	0.57	0.40	9.00	14.00	370	—	
20x12	0.60	0.49	10.00	14.00	—	—	460	—	—	—	0.57	0.42	10.00	14.00	395	413	
20x14	0.60	0.56	11.00	14.00	—	—	475	—	—	—	0.57	0.47	11.00	14.00	440	—	
20x16	0.60	0.57	12.00	14.00	—	—	530	—	—	—	0.57	0.50	12.00	14.00	465	—	
20x18	0.60	0.59	13.00	14.00	—	—	560	—	—	—	0.57	0.54	13.00	14.00	505	—	
20	0.60	0.60	14.00	14.00	—	—	605	—	—	—	0.57	0.57	14.00	14.00	535	—	

NOTE: Contact TU Inside Sales representative for MJ Crosses larger than 16 inch. †MJxSwl Weights include swivel gland

**NOTE: Other sizes available, contact Tyler Union for information.

C153 DUCTILE IRON COMPACT FITTINGS



MJ Tee				MJxFE Tee			MJxSwivel Tee				Cross				
Domestic							Weight			Import				Weight	
Size	T	T1	*H	*J1	*J2	*J3	MJ	MJ x FE	†MJ x S	T	T1	H	J1	MJ	Cross
24x6	0.62	0.44	7.00	16.00	19.00	21.50	465	451	457	0.61	0.36	7.00	16.00	415	—
24x8	0.62	0.45	8.00	16.00	—	—	475	—	—	0.61	0.38	8.00	16.00	445	481
24x10	0.62	0.47	9.00	16.00	—	—	516	—	—	0.61	0.40	9.00	16.00	470	—
24x12	0.62	0.49	10.00	16.00	—	—	549	580	—	0.61	0.42	10.00	16.00	500	529
24x14	0.62	0.56	11.00	16.00	—	—	585	—	—	0.61	0.47	11.00	16.00	550	—
24x16	0.62	0.57	12.00	16.00	—	—	625	744	—	0.61	0.50	12.00	16.00	580	576
24x18	0.62	0.59	13.00	16.00	—	—	675	—	—	0.61	0.54	13.00	16.00	625	—
24x20	0.62	0.60	14.00	16.00	—	—	740	—	—	0.61	0.57	14.00	16.00	660	1589
24	0.62	0.62	16.00	16.00	—	—	844	—	—	0.61	0.61	16.00	16.00	720	—
30x6	0.66	0.36	8.00	20.00	—	—	700	—	—	0.66	0.36	8.00	20.00	685	—
30x8	0.66	0.38	8.50	20.00	—	—	739	—	—	0.66	0.38	8.50	20.00	739	—
30x12	0.66	0.42	10.00	20.00	—	—	739	—	—	0.66	0.42	10.00	20.00	830	882
30x16	0.66	0.50	12.50	20.00	—	—	959	—	—	0.66	0.50	12.50	20.00	959	—
30x18	0.66	0.52	13.00	20.00	—	—	975	—	—	0.66	0.54	13.00	20.00	1039	—
30x20	0.66	0.57	15.00	20.00	—	—	995	—	—	0.66	0.57	15.00	20.00	995	—
30x24	0.66	0.61	16.00	20.00	—	—	1160	—	—	0.66	0.61	16.00	20.00	1060	1246
30	0.66	0.66	20.00	20.00	—	—	1323	—	—	0.66	0.66	20.00	20.00	1323	1840
36x6	0.74	0.36	7.00	23.50	—	—	630	—	—	0.74	0.36	8.00	23.50	685	—
36x8	0.74	0.38	9.00	23.50	—	—	739	—	—	0.74	0.38	8.50	23.50	739	—
36x10	0.74	0.47	10.00	23.50	—	—	739	—	—	0.74	0.40	10.00	23.50	830	882
36x12	0.74	0.49	10.00	23.50	—	—	959	—	—	0.74	0.42	12.50	23.50	959	—
36x14	0.74	0.56	12.50	23.50	—	—	1103	—	—	0.74	0.47	10.00	23.50	1146	—
36x16	0.74	0.57	12.50	23.50	—	—	1385	—	—	0.74	0.50	12.50	23.50	1190	—
36x18	0.74	0.59	13.00	23.50	—	—	1400	—	—	0.74	0.54	12.50	23.50	1410	—
36x20	0.74	0.60	15.00	23.50	—	—	1521	—	—	0.74	0.57	12.50	23.50	1365	—
36x24	0.74	0.61	16.00	23.50	—	—	1533	—	—	0.74	0.61	16.00	23.50	1446	1785
36x30	0.74	0.66	20.00	23.50	—	—	2270	—	—	0.74	0.66	20.00	23.50	1675	—
36	0.74	0.74	23.50	23.50	—	—	1910	—	—	0.74	0.74	23.50	23.50	2015	2655
42x12	0.82	0.62	10.00	27.50	—	—	1410	—	—	0.82	0.42	10.00	27.50	1885	—
42x24	0.82	0.62	20.00	27.50	—	—	2295	—	—	0.82	0.61	20.00	27.50	2270	2668
42x30	0.82	0.66	22.00	29.50	—	—	2337	—	—	0.82	0.66	22.00	30.00	2425	2950
42x36	0.82	0.74	30.00	30.00	—	—	3000	—	—	0.82	0.74	30.00	30.00	3000	3607
42	0.82	0.82	30.00	30.00	—	—	3169	—	—	0.82	0.82	30.00	30.00	3175	3725
48x12	0.90	0.62	9.00	32.00	—	—	2500	—	—	0.90	0.42	9.00	32.00	2535	—
48x24	0.90	0.62	23.00	32.00	—	—	2822	—	—	0.90	0.74	23.00	32.00	2870	—
48x36	0.90	0.82	33.50	33.25	—	—	3982	—	—	0.90	0.74	33.50	33.25	3900	—
48x42	0.90	0.82	33.50	33.50	—	—	4100	—	—	0.90	0.82	33.50	33.50	4100	—
48	0.90	0.82	33.50	33.50	—	—	4251	—	—	0.90	0.90	33.50	33.50	4250	4955

† Weight includes the swivel gland.

PROTECTO 401™ Ceramic Epoxy

STANDARD SPECIFICATION FOR LINING DUCTILE IRON PIPE FOR SEWER SERVICE

I. CONDITION OF DUCTILE IRON PRIOR TO SURFACE PREPARATION

All ductile pipe and fittings shall be delivered to the application facility without asphalt, cement lining, or any other lining on the interior surface. Because removal of old linings may not be possible, the intent of this specification is that the entire interior of the ductile iron pipe and fittings shall not have been lined with any substance prior to the application of the specified lining material and no coating shall have been applied to the first six inches of the exterior of the spigot ends.

II. LINING MATERIAL

The Standard of Quality is Protecto 401 Ceramic Epoxy. The material shall be an amine cured novalac epoxy containing at least 20% by volume of ceramic quartz pigment. Any request for substitution must be accompanied by a successful history of lining pipe and fittings for sewer service, a test report verifying the following properties, and a certification of the test results.

A. A permeability rating of 0.00 when tested according to Method A of ASTM E-96-66, Procedure A with a test duration of 30 days.

B. The following test must be run on coupons from factory lined ductile iron pipe:

- * ASTM B-117 Salt Spray (scribed panel) - Results to equal 0.0 undercutting after two years.
- * ASTM G-95 Cathodic Disbondment 1.5 volts @ 77°F. Results to equal no more than 0.5 mm undercutting after 30 days.
- * Immersion testing rated using ASTM D-714-87.
 - 20% Sulfuric acid—No effect after two years.
 - 140°F 25% Sodium Hydroxide—No effect after two years.
 - 160°F Distilled Water—No effect after two years.
 - 120°F Tap Water (scribed panel)—0.0 undercutting after two years with no effect.
- * ASTM G-22 90 Standard practice for determining resistance of Synthetic Polymeric materials to bacteria. The test should determine the resistance to growth of Acidithiobacillus Bacteria and should be conducted at 30 degrees centigrade for a period of 7 days on a minimum of 4 panels. The growth must be limited only to trace amounts of bacteria.

C. An abrasion resistance of no more than 3 mils (.075 mm) loss after one million cycles using European Standard EN 598: 1994 Section 7.8 Abrasion Resistance.

III. APPLICATION

Applicator

The lining shall be applied by a certified firm with a successful history of applying linings to the interior of ductile iron pipe and fittings.

Surface Preparation

Prior to abrasive blasting, the entire area to receive the protective compound shall be inspected for oil, grease, etc. Any areas with oil, grease, or any substance that can be removed by solvent, shall be solvent cleaned to remove those substances. After the surface has been made free of grease, oil or

other substances, all areas to receive the protective compounds shall be abrasive blasted using sand or grit abrasive media. The entire surface to be lined shall be struck with the blast media so that all rust, loose oxides, etc., are removed from the surface. Only slight stains and tightly adhering oxide may be left on the surface. Any area where rust reappears before lining must be reblasted.

Lining

After surface preparation and within 12 hours of surface preparation, the interior of the pipe shall receive 40 mils nominal dry film thickness of Protecto 401. No lining shall take place when the substrate or ambient temperature is below 40°F. The surface also must be dry and dust free. If flange pipe or fittings are included in the project, the lining shall not be used on the face of the flange.

Coating of Bell Sockets and Spigot Ends

Due to the tolerances involved, the gasket area and spigot end up to 6 inches back from the end of the spigot end must be coated with 6 mils nominal, 10 mils maximum using Protecto 401 Joint Compound. The Joint Compound shall be applied by brush to ensure coverage. Care should be taken that the Joint Compound is smooth without excess buildup in the gasket seat or on the spigot ends. Coating of the gasket seat and spigot ends shall be done after the application of the lining.

Number of Coats

The number of coats of lining material applied shall be as recommended by the lining manufacturer. However, in no case shall this material be applied above the dry thickness per coat recommended by the lining manufacturer in printed literature. The maximum or minimum time between coats shall be that time recommended by the lining material manufacturer. To prevent delamination between coats, no material shall be used for lining which is not indefinitely recoatable with itself without roughening of the surface.

Touch-Up and Repair

Protecto 401 Joint Compound shall be used for touch-up or repair in accordance with manufacturer's recommendations.

IV. INSPECTION AND CERTIFICATION

Inspection

All ductile iron pipe and fitting linings shall be checked for thickness using a magnetic film thickness gauge. The thickness testing shall be done using the method outlined in SSPC PA-2 Film Thickness Rating.

The interior lining of all pipe barrels and fittings shall be tested for pinholes with a non-destructive 2,500 volt test. Any defects found shall be repaired prior to shipment.

Each pipe joint and fitting shall be marked with the date of application of the lining system along with its numerical sequence of application on that date and records maintained by the applicator of his work.

Certification

The pipe or fitting manufacturer must supply a certificate attesting to the fact that the applicator met the requirements of this specification, and that the material used was as specified.



Look Beneath the Surface.

V. HANDLING

Protecto 401 lined pipe and fittings must be handled only from the outside of the pipe and fittings. No forks, chains, straps, hooks, etc. shall be placed inside the pipe and fittings for lifting, positioning, or laying. The pipe shall not be dropped or unloaded by rolling.

Care should be taken not to let the pipe strike sharp objects while swinging or being off loaded. Ductile iron pipe should never be placed on grade by use of hydraulic pressure from an excavator bucket or by banging with heavy hammers.

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