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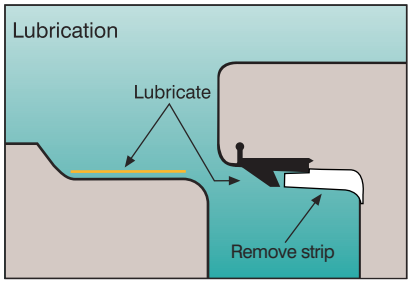
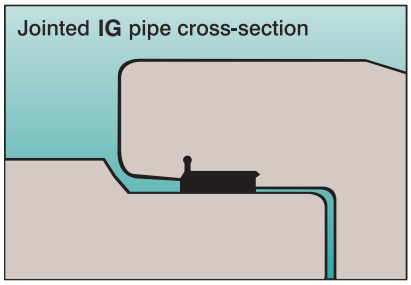
Circular Pipe Installation

Installation of Circular Pipes with IG Joint

- Pipes should be handled carefully to avoid damage, particularly to the ends and joint surfaces.
- Clean each joint and inspect for damage prior to laying. Completely remove the protective polystyrene strip by pulling on the red tag. Thoroughly inspect the area at the back of the gasket ensuring that any soil, bedding or frozen matter is removed.
- Lubricate the spigot of the pipe over the entire surface and gasket.
- Joint pipes using a suitable method until a nominal joint gap of 5mm is achieved. Pipes should be protected from the mechanical equipment used to joint them by means of timber packings or baulks.
- The IG joint is designed to be tight for maximum water tightness. If jointing forces suddenly increase, the pipe should be disjointed, checked for debris and realigned before continuing.
- The finished joint gap should be between 5mm and 25mm.
- The pipeline should be air tested for joint integrity prior to backfilling.
- Backfill as soon after the air test as possible.

IG Joint



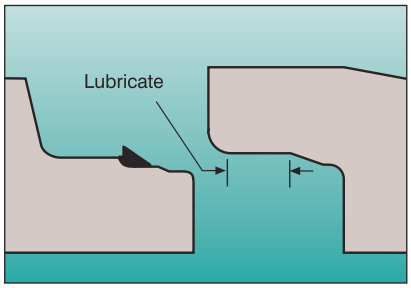


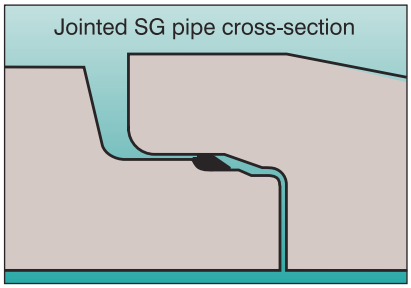
Installation of Circular Pipes with SG Joint

SG joints are produced on DN 2000 - 2400 pipes

- Before jointing, each pipe should be examined for damage and the jointing surfaces and gasket thoroughly cleaned.
- The pipe incorporates a sliding gasket which should be fitted onto the spigot in the position shown.
- Ensure the gasket is evenly stretched.
- Apply a thin layer of the lubricant supplied to the area shown opposite.
- Use only lubricant supplied or approved by Stanton Bonna.
- Enter the spigot carefully into the socket and check that the joint is concentric and the gasket is correctly positioned.
- During jointing the pipe should be supported at its point of balance and positioned clear of the trench bottom. Care must be taken not to displace th gasket as the spigot is entered into the socket.
- Before pushing the joint home, ensure pipe ends are square with each other.
- Carefully push the pipes home, ensuring that the gasket remains in the correct position.
- Alternative methods of joint assembly may be used, provided the spigot entry is steady and controlled to line and level.

SG Joint





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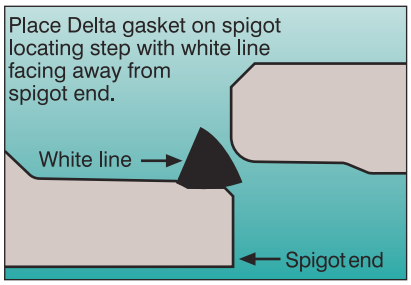
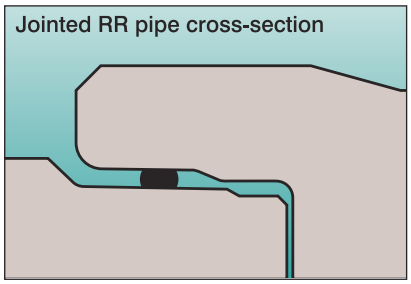
Circular Pipe Installation

Installation of Circular Pipe with RR Joint

- Before jointing, each pipe should be examined for damage and the jointing surfaces and gasket thoroughly cleaned.
- The pipe incorporates a flexible rolling gasket joint which uses the unique Delta shaped gasket.
- Care must be taken to ensure the Delta gasket is positioned on the spigot end without twists. The flat face of the Delta gasket is marked with a white line.
- The gasket must be positioned on the spigot and against the locating step with the white line facing away from the spigot (see illustration opposite).
- For pipes of DN 1400 and above, refer to the lifting and jointing system on pages 1.3.4 and 1.3.5
- During jointing the pipe should be supported at its point of balance and positioned clear of the trench bottom. Care must be taken not to displace the gasket as the spigot is entered into the socket.
- **Lubricants must not be used on RR joint pipes.**
- Before pushing the joint home, ensure pipe ends are square with each other to allow even gasket roll.
- Alternative methods of joint assembly may be used, provided the spigot entry is steady and controlled to line and level.

RR Joint





Testing of Pipelines

- Sewers up to DN 750 should be subjected to air or water tests which accord with Civil Engineering Specification for the Water Industry 5th Edition. For sewers above DN 750 special equipment may be required however a visual inspection is normally considered sufficient.
- Where the pipeline is below the water table the air test is not effective and an infiltration test should be used.
- The pipe should be air tested at least after every third or fourth pipe laid, prior to backfilling.
- To air test, seal the pipeline at each end and any junctions with **inflatable test stoppers**. Attach a U tube (manometer) and pressurise to slightly above 100mm water gauge.
- Allow 5 minutes for air temperature stabilisation and adjust the pressure back to 100mm water gauge. The air test is temperature sensitive and a 1°C change in air temperature will result in a change of approximately 38mm in the water gauge.
- Allow a further 5 minutes to elapse without pumping, the water head should not drop below 75mm water gauge.
- If the water head drops more than 25mm investigate the possible causes, for example air temperature change, dryness of the pipe wall, faulty stoppers or test equipment. A solution of soap and water may be used to assist in the detection of leaks.
- Failure of an air test should not mean rejection of a pipeline. In the unlikely event of an air test failure, a water test should always be carried out before rejecting the pipeline.