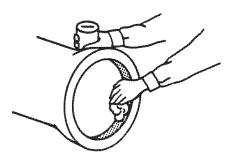
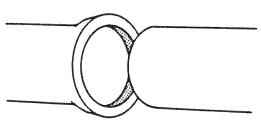


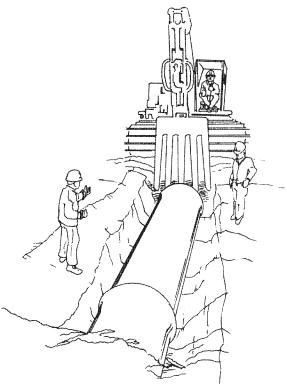
1. Thoroughly clean the groove and the bell socket of the pipe or fitting; also clean the plain end of the mating pipe. Using a gasket of the proper design for the joint to be assembled, make a small loop in the gasket and insert it in the socket. For pipe sizes larger than 20 in., it may be necessary to make 2 loops in the gasket (6 and 12 o'clock). Assure that the gasket faces the correct direction and that it is properly seated. Note: In cold weather, it is preferable to warm the gasket to facilitate assembly of the joint.



2. Apply lubricant to the exposed surface of the gasket and plain end of the pipe in accordance with the pipe manufacturer's recommendations. Do not apply lubricant to the bell socket or the surface of the gasket in contact with the bell socket. Lubricant is furnished in sterile containers, and every effort should be made to protect against contamination of the container's contents.



3. Be sure that the plain end is beveled per the manufacturer's recommendations; square or sharp edges may damage or dislodge the gasket and cause a leak. When pipe is cut in the field, bevel the plain end with a heavy file or grinder to remove all sharp edges. Push the plain end into the bell of the pipe. Keep the joint straight while pushing. Make deflection after the joint is assembled.



4. Small pipe can be pushed into the bell socket with a long bar. Large pipe requires additional power, such as a jack, lever puller, or backhoe. The supplier may provide a jack or lever puller on a rental basis. A timber header should be used between the pipe and jack or backhoe bucket to avoid damage to the pipe.

Figure 2 Push-on-joint assembly