



Series 1500-S
Joint Restraint for
IPS PVC Pipe
Patent No. 6,322,273

Installation
Instructions



1. Clean the socket and pipe. Lubricate gasket with an approved pipe lubricant meeting AWWA C111. Place the gland on the pipe with the lip extension toward the plain end, followed by the lubricated gasket with the tapered edge of the lubricated gasket toward the plain end. Transition gasket is required.

2. Insert the pipe into the socket and press the gasket firmly and evenly into the gasket recess. Keep the joint straight during assembly.

3. Push the gland toward the socket and center it around the pipe with the gland lip against the gasket. Insert T-bolts and hand tighten nuts. Set deflection after joint assembly but before tightening bolts. (max. deflection is 5°)

4. Tighten the T-bolt nuts to the torque recommended in AWWA C111 (45-60 ft. lbs. for 3" and 75-90 ft. lbs. in 4"-12" sizes). Tighten in an alternating manner, (12 o'clock, 6 o'clock, 9 o'clock, 3 o'clock) maintaining the same gap between the gland and the face of the MJ bell at all points around the socket. Repeat the process until all bolts are within the recommended torque range. Use of a torque wrench is recommended.

5. After correct assembly of the mechanical joint, bring all restraint segments in contact with the pipe surface by turning the Auto-Tork® actuating screws in a clockwise direction until contact is made with the pipe surface.

6. Tighten each Auto-Tork® screw approximately 180 degrees (1/2 turn), alternating among screws until the heads twist off. Never turn a single screw more than 180 degrees without alternating to another screw. Use a torque wrench to ensure a minimum of 75 ft. lbs. has been applied to Auto-Tork® screws.



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