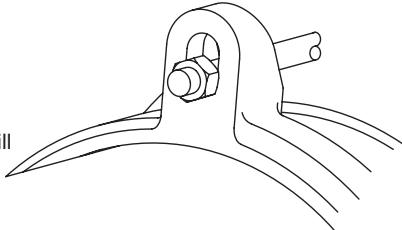
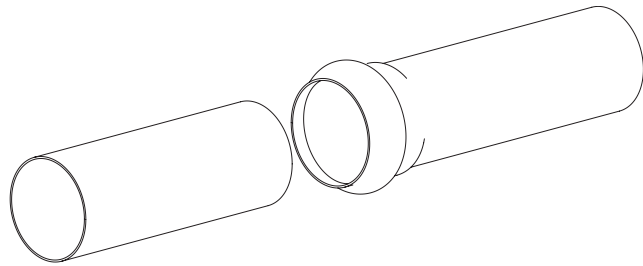


# ASSEMBLY INSTRUCTIONS for 4" - 12" SERIES 1355-x-DWB

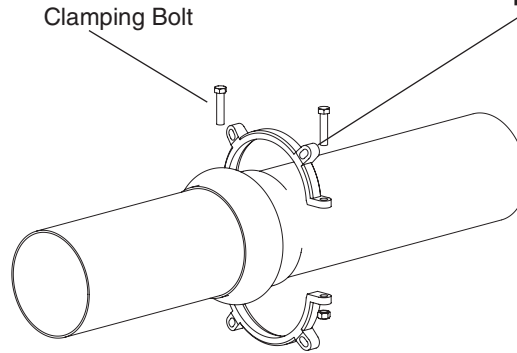
Standard restraint device for new or existing installations of Ductile Iron Pipe or C900 PVC Pipe Bell Joints

**IMPORTANT**

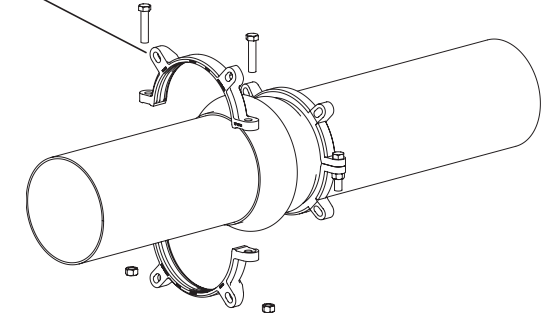
**Note:** Position the restraint and back-up ring so the nuts for the connecting rod contact the flat side of the ears. The restraint will not function properly if installed incorrectly.

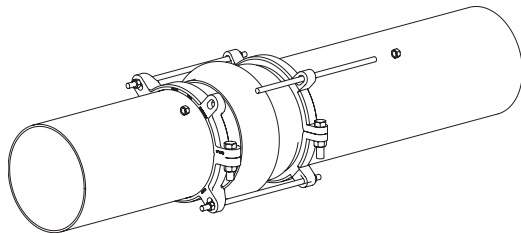
1. Assemble spigot pipe end to bell using standard procedure, following pipe manufacturer's recommendations.



2. Assemble split (non-serrated) back-up ring onto the pipe behind the pipe bell. Make sure beveled side of ring faces the pipe bell and is snug against the bell transition. Evenly tighten the clamping bolts to the recommended torque as shown in Table 1.



3. Assemble Series 1300-x-DWB serrated clamping ring onto spigot end of the pipe using the connecting rods as a guide for position. Evenly tighten clamping bolts to the recommended torque as shown in Table 1.



4. Insert connecting rods into the slots and position as close to the pipe as possible. Snug connecting nuts hand tight. Using a wrench, tighten each connecting nut an additional 1/2 turn in order to firmly seat the back up ring against the bell. **Do not over-tighten the connecting nuts.**

Table 1

Recommended Clamping Bolt Torque		
	PVC	DIP
4" and 6"	100 ft-lb	100 ft-lb
8" and 10"	150 ft-lb	150 ft-lb
12"	150 ft-lb	200 ft-lb



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