

## Joint Assembly:

National's gasketed pipe products have a permanently installed "locked-in" reinforced rubber ring gasket providing a leak proof integral bell joint. Recommended assembly of a properly lubricated spigot end inserted into this integral bell is performed as follows:

### Step 1. Clean & Align



It is important when assembling PVC pipe cut in the field the spigot end should be inspected to ensure that the cut is perpendicular to the pipe's longitudinal axis. Edges should be deburred and beveled and the insertion line reapplied. The integral bell and spigot must be cleared of dirt and foreign material with a clean rag. Spigot end should be cleaned beyond insertion line.

### Step 2. Lubricate



Lubricant used must be approved for potable water (PW) service. Use lubricant supplied with pipe or recommended by pipe manufacturer.

Non-approved lubricant may cause bacterial growth or damage the gasket. Lubricate the entire spigot end up to the insertion mark as well as the entire surface area of the gasket installed in the integral bell end. Do not allow lubricated spigot end to come in contact with bedding material, which could adhere and lodge between spigot and gasket.

### Step 3. Block & Bar Assembly



Manual assembly of small diameter pipe may be accomplished using only manual force. The block and bar method of assembly is recommended for larger diameter requiring a greater insertion force. This method allows workman the ability to judge the amount of force and determine if undue resistance exists. Be sure belled end lengths are properly braced to avoid over-insertion of previous joint.

### Step 4. Observe Reference Mark

**Only insert spigot end into the gasketed bell until the reference mark is aligned with the leading edge of the bell lip. Over-insertion of spigot end past the reference mark may create a stress condition resulting in joint failure or leakage and may interfere with the normal expansion/contraction performance of the joint.**



**Note: Failure to properly assemble integral gasketed joint may void manufacturers warranty.**