



SAINT-GOBAIN PAM LAYING RECOMMENDATIONS

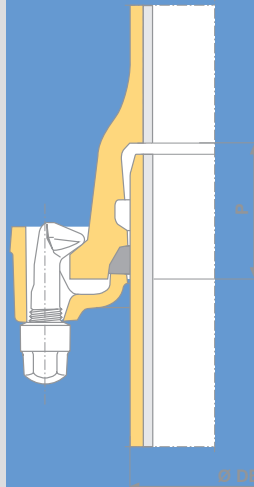
- STORAGE
- HANDLING
- BACKFILL
- STANDARD JOINT
- STANDARD Vi JOINT
- STANDARD Ve JOINT
- UNIVERSAL Vi JOINT
- STANDARD V+i JOINT
- UNIVERSAL Ve JOINT DN 100 to 1200 MM
- EXPRESS JOINT
- EXPRESS Vi JOINT
- PIPE CUTTING
- WELD BEAD
- ANCHOR BLOCKS
- ANCHORING
- EXTERNAL COATING REPAIRS
- INTERNAL LINING REPAIRS
- PE SLEEVE INSTALLATION
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- CONTACTS

AEP-MEM-15A VERSION 2007 - 4000 EX

PAM

LAYING RECOMMENDATIONS

EXPRESS JOINT




SAINT-GOBAIN
PAM

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These recommendations are based upon our knowledge of the products and their use. It is the contractor's responsibility to ensure that installation is carried out according to the best rules of practice.

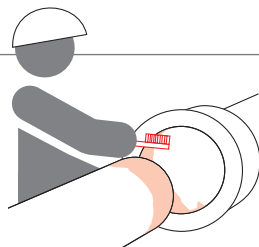

SAINT-GOBAIN
CANALISATION

ASSEMBLING THE EXPRESS JOINT

! Ensure strict compliance for spigot insertion depth and for bolt tightening torques (to be obtained with a torque spanner).

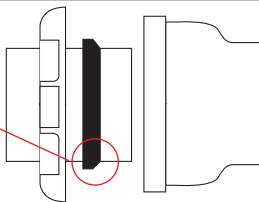
CLEAN THEM

Clean the inside of the socket, the spigot end of the pipe and the gasket.



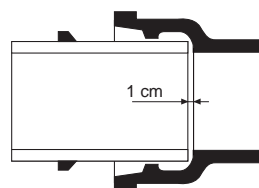
SLIP ON THE GLAND THEN THE GASKET

Make sure the gasket is facing the socket.



INSERT IT

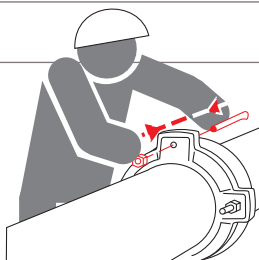
Insert the spigot into the socket, as far as it will go, making sure that the parts being assembled, stay aligned then **withdraw the spigot about 10 mm.**



👍 Applying a little grease to the socket may facilitate positioning the gasket.

ASSEMBLING

- Slide the gasket along the barrel, insert it into its housing and bring up the gland.



- Insert the bolts and **pre-tighten the nuts with the joint aligned.**

Deflect the angle within the allowable angle limits if required.

TIGHTEN THE BOLTS

Check the position of the gland.

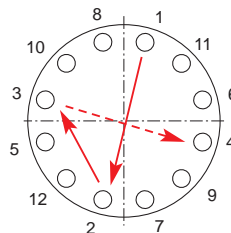
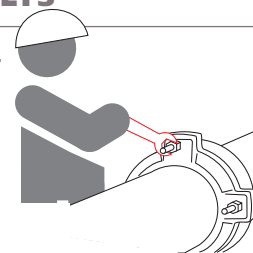
Tighten the nuts with a torque spanner working successively as per the diagram.

Bolt tightening torque:

- 22 Ø bolts: 12 m.kgf,
- 27 Ø bolts: 30 m.kgf.

Check tightening **after hydraulic testing.** Tighten again if required.

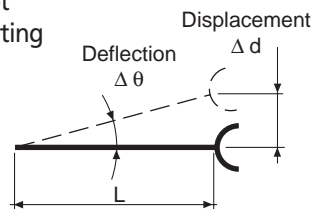
Suggestion ! for large DN, start tightening while the part to be assembled is still supported by the lifting tackle; this will facilitate correct positioning of the gasket in its housing.



ANGLE DEFLECTION

Pipe centrelines must be kept perfectly straight when inserting the spigot into the socket.

Deflection can only be adjusted between pre-tightening and final tightening.



Maximum allowable deflection

DN	$\Delta\theta$	L m	Δd cm
60 to 150	5°	6	52
200 to 300	4°	6	42
350 to 600	3°	6	32
700 to 800	2°	7	25
900 to 1000	1°5	7	19
1000 to 1200	1°5	8	21