



## SAINT-GOBAIN PAM LAYING RECOMMENDATIONS

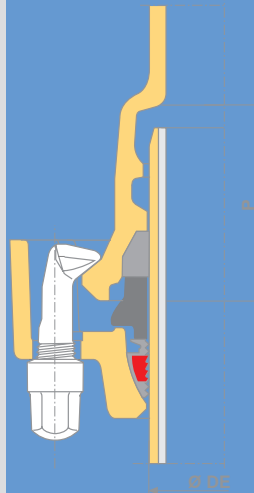
- STORAGE
- HANDLING
- BACKFILL
- STANDARD JOINT
- STANDARD Vi JOINT
- STANDARD Ve JOINT
- UNIVERSAL Vi JOINT
- STANDARD V+i JOINT
- UNIVERSAL Ve JOINT DN 100 to 1200 MM
- EXPRESS JOINT
- EXPRESS Vi JOINT
- PIPE CUTTING
- WELD BEAD
- ANCHOR BLOCKS
- ANCHORING
- EXTERNAL COATING REPAIRS
- INTERNAL LINING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

AEP-MEM-15A VERSION 2007 - 4000 EX

# PAM

## LAYING RECOMMENDATIONS

### EXPRESS Vi 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.*

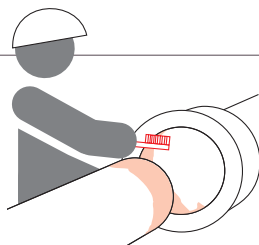
  
**SAINT-GOBAIN**  
CANALISATION

# ASSEMBLING THE EXPRESS VI JOINT

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

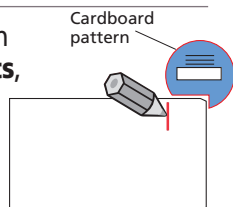
## CLEAN THEM

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



## MARK THE SOCKET DEPTH

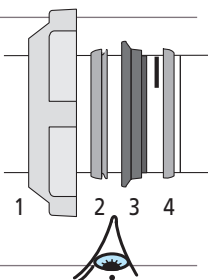
- Use the cardboard pattern delivered with the parts,
- Carefully read the assembly recommendations written on the back of the pattern.



## POSITIONING PARTS

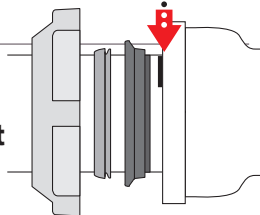
In the order given and according to the scheme :

- the gland (1),
- the locking ring (2),
- the spacer (3),
- the gasket (4).



## ASSEMBLING

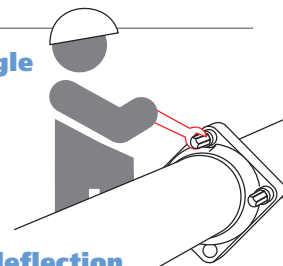
- Insert the spigot into the socket carefully, respecting the socket depth (socketface vertical to the mark),
- Place the gasket in its housing,
- Bring the other parts into contact,
- Insert the bolts and tighten the nuts until they come into contact with the gland.



## TIGHTEN THEM

### Assembling WITHOUT angle deflection

Gradually tighten the nuts working diagonally up to the **final torque\***.

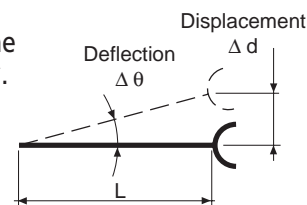


### Assembly WITH angular deflection

- Pre-tighten the nuts with the joint aligned up to the **pre-tightening torque\***.

Deflect the angle within the allowable angle limits.

- Continue to tighten until the **final torque\*** is reached.



**Warning!** only use the bolts delivered in the kit.

### \*Tightening torques

| DN         | pre-tightening m. kgf | final tightening m. kgf | bolts marking |
|------------|-----------------------|-------------------------|---------------|
| 60 to 125  | 2                     | 12                      | D2L (22x80)   |
| 150 to 200 | 6                     | 18                      | D2L (22x80)   |
| 250 to 300 | 6                     | 18                      | D7L (27x102)  |

### Maximum allowable deflection

| DN         | $\Delta\theta^\circ$ | L m | $\Delta d$ cm |
|------------|----------------------|-----|---------------|
| 60 to 150  | 4°                   | 6   | 42            |
| 200 to 300 | 3°                   | 6   | 32            |

**Warning !** for a pre-assembled section to be handled (e.g.: bayonet), always check the tightening torque of EXPRESS Vi joints after the section has been finally laid.