



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

Pipe cutting




SAINT-GOBAIN
PAM

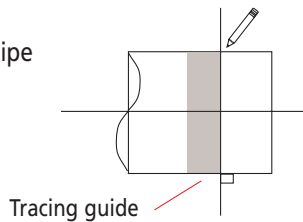
MARKETING DEPARTMENT
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54705 PONT A MOUSSON CEDEX
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www.pamline.fr

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

DRAW

Draw the cutting plane **perpendicular** to the pipe centerline.



CHECK THE OD (Outside diameter)

Before cutting, use a circumeter to check that the **OD measured is less than the OD + 1 mm** (see table below).

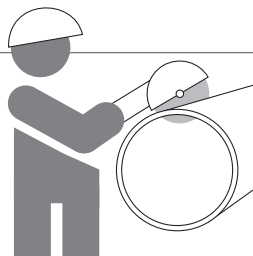
DN ≤ 300: cut within **4 m of the spigot end** of the pipe.

DN > 300: if there are a large number of pipe to be cut on site, make sure you order "calibrated pipes". These pipes are calibrated over 2/3 of their length starting from the spigot. They are marked with two rings painted in metallic grey paint on the socket face.

DN	DE mm	DN	DE mm	DN	DE mm	DN	DE mm
60	77	250	274	600	635	1200	1255
80	98	300	326	700	738	1400	1462
100	118	350	378	800	842	1500	1565
125	144	400	429	900	945	1600	1668
150	170	450	480	1000	1048	1800	1875
200	222	500	532	1100	1151	2000	2082

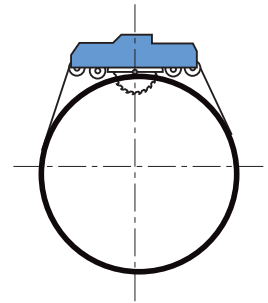
CUTTING

• **For DN 60 to 700**
Cut using a slitting disc cutter for example (follow safety rules).



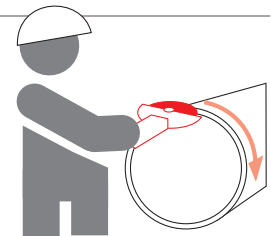
• For DN 800 to 2000

Use an air operated saw (FEIN for example) which, with a special attachment, can make the chamfer at the same time.



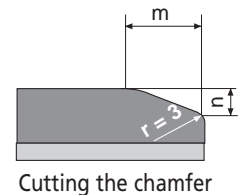
FETTLING OR CHAMFERING

• **For mechanical joints** EXPRESS, SLEEVE, LINK GS (GGs), fettle the edge of the cut



• **For push-on joints** STANDARD, STANDARD Vi, remake the chamfer to avoid damaging the gasket.

DN	m (mm)	n (mm)
60 to 600	9	3
700 to 1200	15	5
1400 to 1600	20	7
1800 to 2000	23	8



REPAIRING THE COATING

Repair the protective coating on the raw edge and the chamfer.

For standard coatings use bituminous paint:

- ENDOLAC 245-30, for black coatings (1 kg : Ref. 158134 ; 5 kg : Ref. 158131),
- EUROKOTE 438, for Natural coatings (1 kg : Ref. 158255).

