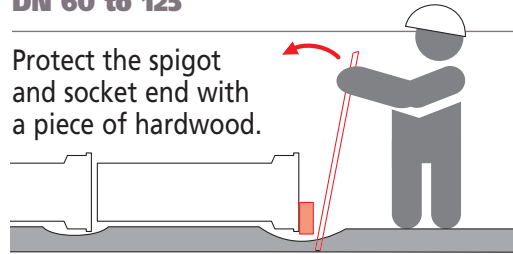


ASSEMBLING EQUIPMENT

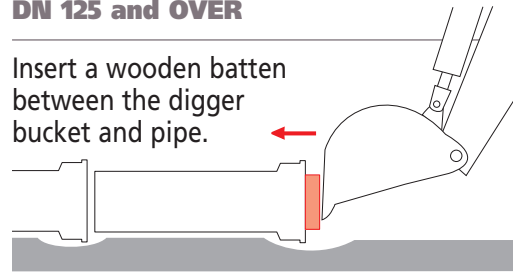
DN 60 to 125

Protect the spigot and socket end with a piece of hardwood.



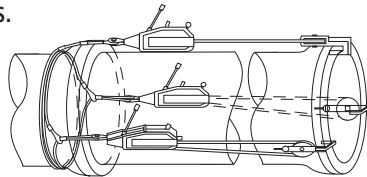
DN 125 and OVER

Insert a wooden batten between the digger bucket and pipe.



DN 150 and OVER

Advantageous solution for difficult access constraints.



Use one or more lifting tackles* depending on the DN

DN	No. of lifting tackles
150 to 300	1 T516 (2.5 tonnes)
350 to 600	1 T532 (5 tonnes)
700 to 1200	2 T532 (2 x 5 tonnes)
1400 to 2000	3 T532 (3 x 5 tonnes)

* Available on request, see "Assembly Equipment" laying recommendations



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

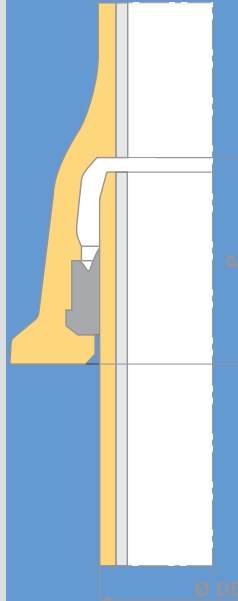


MARKETING DEPARTMENT
21 AVENUE CAMILLE CAVALLIER
54705 PONT A MOUSSON CEDEX
FRANCE
TEL: 03.83.80.73.50
www.pamline.fr

AEP-MEM-15A VERSION 2007 - 4000 EX

PAM LAYING RECOMMENDATIONS

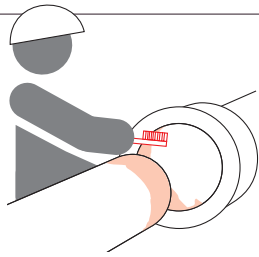
STANDARD JOINT



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.

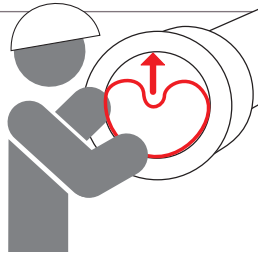
CLEAN THEM

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

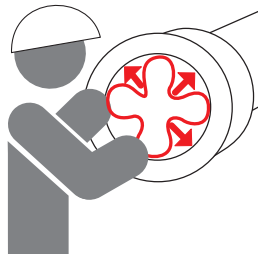


PLACE THE GASKET

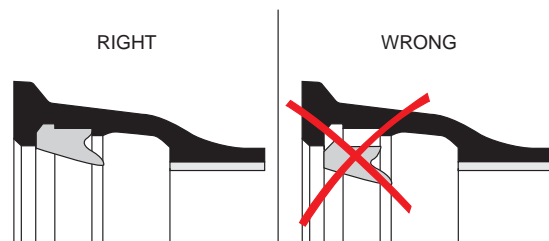
DN ≤ 800



Insert the gasket before lowering the pipe into the trench

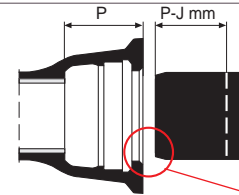


DN > 800



MARK THE SOCKET DEPTH

(When it has not been originally marked).
Mark the spigot at P-J mm.



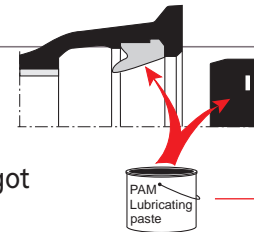
J=15 mm (DN 60 to 300)
J=20 mm (DN 350 to 600)
J=25 mm (DN 700 to 900)
J=30 mm (DN 1000 to 1200)
J=40 mm (DN 1400 to 2000)

Also check the condition of the chamfer

LUBRICATE IT

Grease:

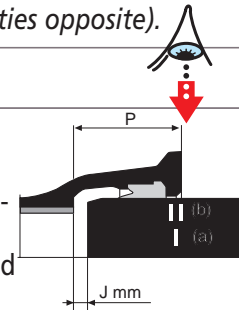
- the visible face of the gasket,
- the chamfer and spigot end of the pipe



Grease is applied with a paintbrush in reasonable quantities. (see the table of quantities opposite).

ASSEMBLING

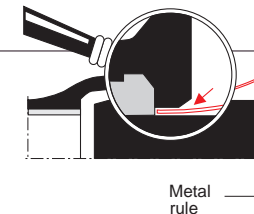
Centre and insert the spigot into the socket (making sure the centre-lines are aligned):
(a) up to the line marked at depth P-J mm



(b) up to between the 2 lines when shop marked.

CHECK IT

The same depth should be shown by the tape all round the periphery.



DN	P mm	DN	P mm	DN	P mm	DN	P mm
60	87	250	104	600	130	1200	235
80	90	300	105	700	192	1400	245
100	92	350	108	800	197	1500	265
125	95	400	110	900	200	1600	265
150	98	450	113	1000	203	1800	275
200	104	500	115	1100	225	2000	290

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

Section of chamfer

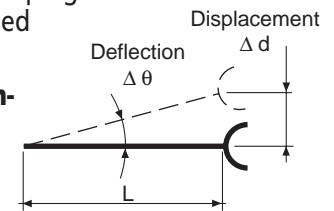
Number of cans for 100 joints

DN	No	DN	No	DN	No	DN	No
60	2	250	4	600	9	1200	24
80	2	300	5	700	13	1400	40
100	2	350	5	800	15	1500	45
125	2	400	6	900	17	1600	50
150	3	450	6	1000	19	1800	60
200	3	500	7	1100	21	2000	71

MAX ADMISSIBLE DEFLECTION

Pipes shall be inserted keeping the pipes perfectly aligned on their centrelines.

Only when joint assembly has been fully completed shall the deflection be made.



DN	Δθ	L m	Δ d cm
60 to 300	5°	6	52
350 to 600	4°	6	42
700 to 1000	4°	7	49
1100 to 1200	4°	8	56
1400 to 1600	3°	8	42
1800	2°5	8	35
2000	2°	8	28