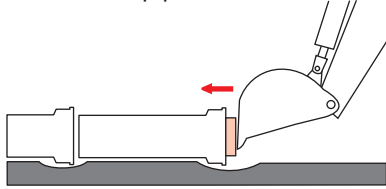


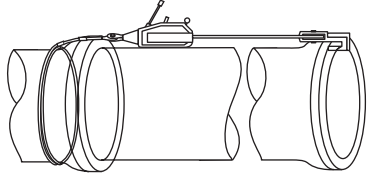
DIGGER BUCKET

Insert a wooden batten between the digger bucket and the pipe.



LIFTING TACKLE

An advantageous solution for difficult access constraints.



Use a T532 lifting tackle (5 tonnes, ref. 158024), for inserting 2 pipes and 2 lifting tackles for inserting one pipe and one fitting.
Available on request.

DISMANTLING THE JOINT

STANDARD V+i joints can be dismantled.

The UNIVERSAL Vi locking gasket should not be used again after dismantling.



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



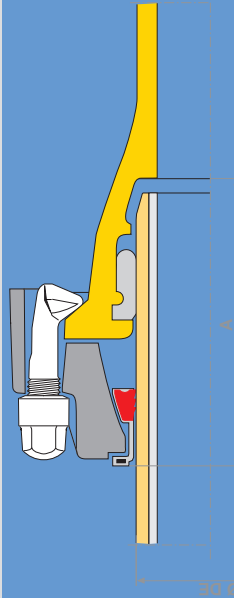
MARKETING DEPARTMENT
21 AVENUE CAMILLE CAVALLIER
54705 PONT A MOUSSON CEDEX
FRANCE
TEL: 03.83.80.73.50
www.pamline.fr

AEP-MEM-15A VERSION 2007 - 4000 EX



LAYING RECOMMENDATIONS


STANDARD V+i JOINT

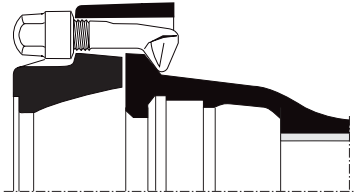


! The Standard V+i anchoring system must not be used to lock a string of pipes to be pulled (in a casing, on a bridge, in case of Horizontal Directional Drilling, for example). For these types of installation, use the Ve anchoring system (with a weld bead).

INSERT THE GLAND AND BOLTS

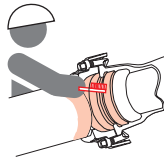
Install the gland and bolts on the STANDARD connection socket. **Tighten the nuts until the gland seats on the fitting face, making sure the gland remains well centred on the socket.**

 First insert 2 bolts from the top and tighten them by hand to centre it properly.



CLEAN THEM

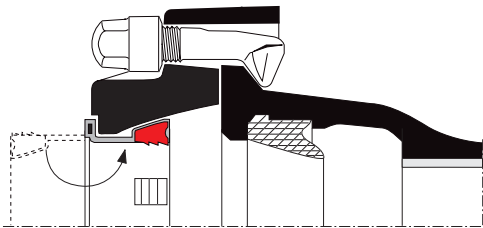
Clean the insides of the socket and gland, the spigot end of the pipe, gasket and locking gasket.



POSITIONING GASKET AND RING

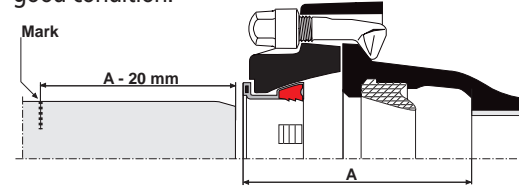
We recommend that this work is carried out before the pipe is lowered into the trench.

Place the STANDARD gasket in the socket and the UNIVERSAL Vi locking ring in the gland.



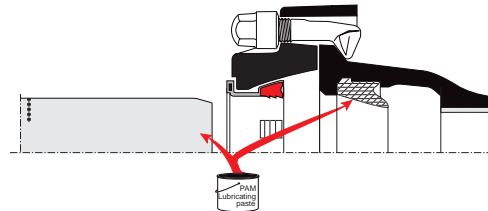
MARK THE SOCKET DEPTH

(When it has not been originally marked). Dimension A is to be measured and transferred to the spigot end. Mark the spigot end **A - 20 mm**. Also check that the chamfer conforms and is in good condition.




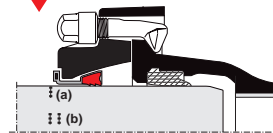
LUBRICATE

Apply the lubricating paste to:
 - the housing and exposed surface of the gasket,
 - the chamfer and pipe spigot.



ASSEMBLY

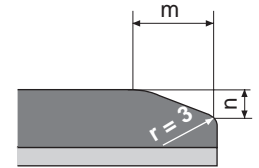
 Centre and insert the spigot into the socket (making sure centre-lines are aligned):



(a) up to the line marked at depth A - 20 mm,
 (b) up to between the two lines when shop marked on **UNIVERSAL pipes** (not to be confused with the two marked lines on the spigots of STANDARD pipes).

Chamfer dimensions

DN	350 to 600
m (mm)	9
n (mm)	3



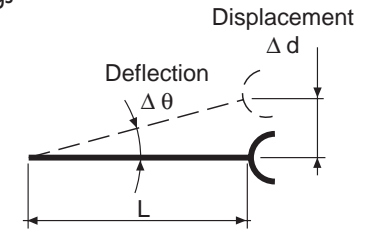
Quantity of lubricating paste for 100 joints

DN	350	400	450	500	600
Number of cans	5	6	6	7	9

MAXIMUM ALLOWABLE DEFLECTION

Pipes shall be inserted keeping pipe and fittings centrelines **perfectly aligned**.

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



DN	Δθ	L m	Δ d cm
350	3°	5,97	32
400	3°	5,97	32
450	3°	5,97	32
500	2°	5,97	21
600	2°	5,97	21