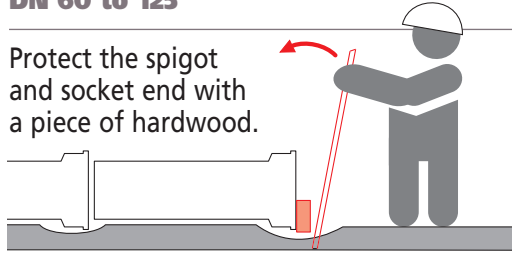


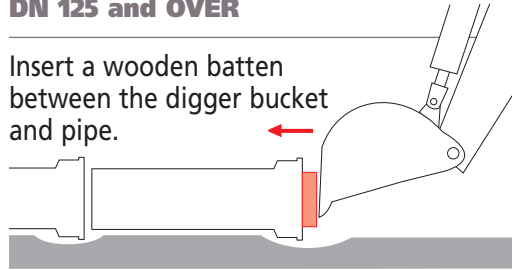
DN 60 to 125

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.

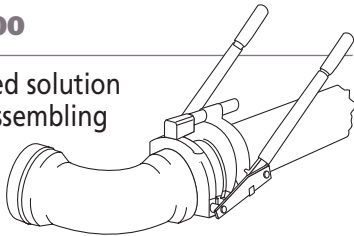


Assemble in-line.

DN 80 to 300

Recommended solution for fittings assembling

Equipment available on request at SAINT-GOBAIN PAM.



DN 350 TO 600

Assemble in-line with two pull lift (6 tons each).

DISMANTLING

STANDARD Vi joints can be dismantled with special tools **before pressurization** if required. Contact SAINT-GOBAIN PAM. **It can no longer be dismantled after pressurization or tensioning.**



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

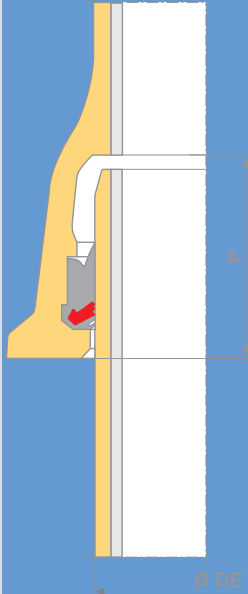
SAINT-GOBAIN
PAM

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

PAM
LAYING
RECOMMENDATIONS

STANDARD Vi JOINT



SAINT-GOBAIN
CANALISATION

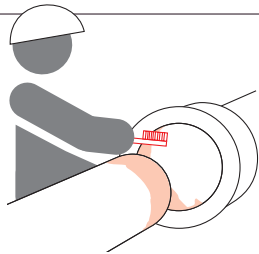
! The Standard Vi anchoring system must not be used to lock a string of pipes to be pulled (in a casing, on a bridge, in case of Horizontal Directional Drilling, for example). For these types of installation, use the Ve anchoring system (with a weld bead).

PRELIMINARY REMARKS

- STANDARD Vi anchorage is achieved by the **automatic grip of serrated metal inserts** on to the spigot during joint assembly.
- The STANDARD Vi gasket can be fitted to all STANDARD sockets and all plain spigots.

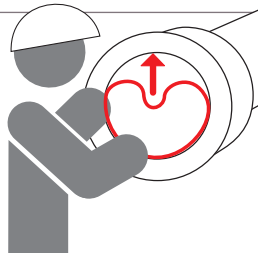
CLEAN THEM

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

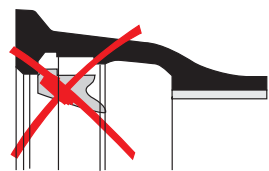


PLACE THE GASKET

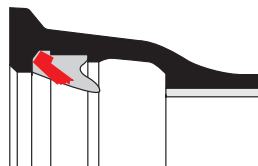
Insert the gasket before lowering the pipe into the trench.



WRONG



RIGHT

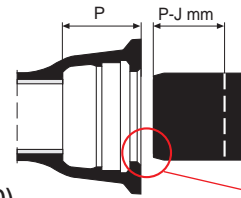


MARK THE SOCKET DEPTH

(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)

Also check the condition of the chamfer

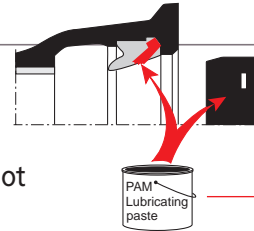


LUBRICATE IT

Grease:

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

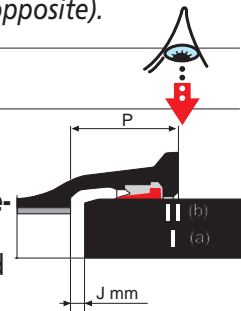
Grease is applied with a paintbrush in reasonable quantities. (see table of quantities opposite).



ASSEMBLING

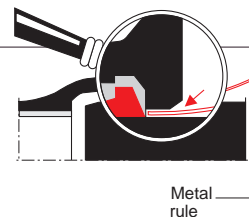
Centre and insert the spigot into the socket (**making sure the centre-lines are aligned**):

- up to the line marked at depth P-J mm,
- up to between the 2 lines when shop marked.



CHECK IT

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



DN	P mm	DN	P mm	DN	P mm
60	87	200	104	400	110
80	90	250	104	450	113
100	92	300	105	500	115
125	95	350	108	600	130
150	98				

DN	m (mm)	n (mm)
60 - 600	9	3

Section of chamfer

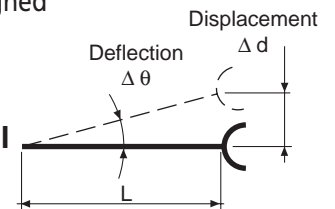
Number of cans for 100 joints

DN	No	DN	No	DN	No
60	2	200	3	400	6
80	2	250	4	450	6
100	2	300	5	500	7
125	2	350	5	600	9
150	3				

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.



Admissible deflection

DN	Δθ	L m	Δ d cm
60 to 150	5°	6	52
200 to 250	4°	6	42
300 to 350	3°	6	32
400 to 600	2°	6	21