

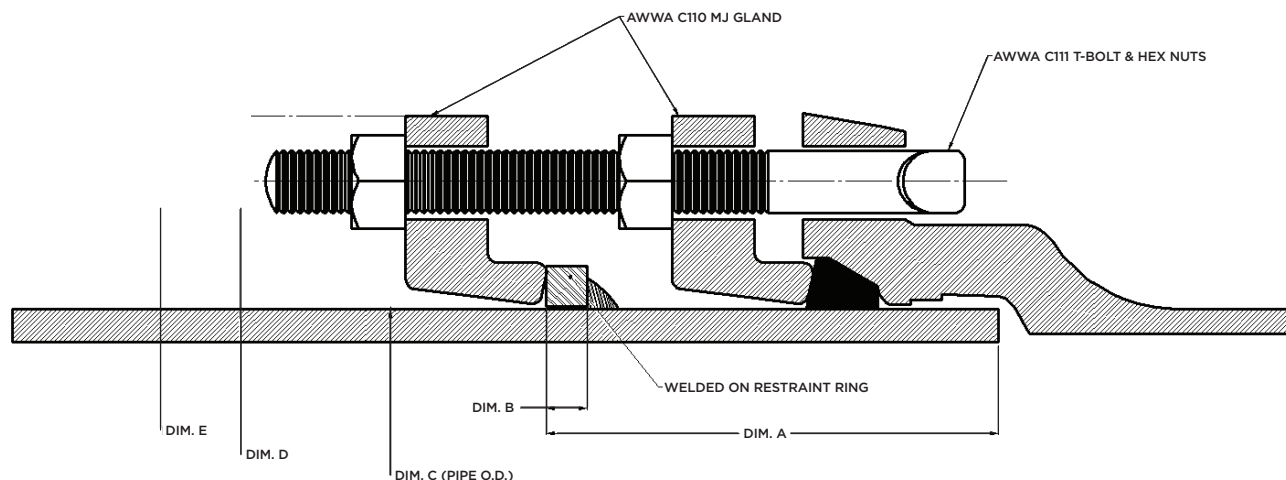


IRON STRONG

DUCTILE IRON PIPE

MJ LOCK JOINT

6"-30"



ASSEMBLY INSTRUCTIONS

STEP 1A. Gather all necessary PPE, tools and materials, such as a wire brush, paint brush, pipe lube and wrench.

STEP 1B. Clean the bell socket and spigot. Be sure to remove any dirt, ice or foreign matter from the inside of the bell.

STEP 2A. Place the gland on the plain end with the lip extension toward the plain end.

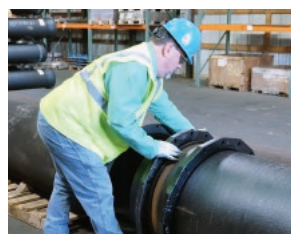
STEP 2B. Lubricate both the gasket and plain end by brushing on approved pipe lubricant. Place the gasket on the plain end with the narrow edge facing the plain end. **Note:** Use only lube as supplied and/or approved by the manufacturer. *Currently approved lubricants provided by McWane Ductile include Phoenix XL-27 and Black Swan.*



STEP 1A



STEP 1B



STEP 2A



STEP 2B

ASSEMBLY INSTRUCTIONS

STEP 3A. Insert the plain end of the pipe into the MJ bell until it rests against the back of the bell.



STEP 3A

STEP 3B. Press the gasket into the bell recess. Push the gland toward the socket and center it around the pipe with the gland lip against the gasket.



STEP 3B

STEP 4A. Slide the second gland away from the spigot end to allow enough room for the joint assembly with the first gland.



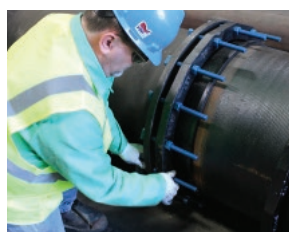
STEP 4A

STEP 4B. Insert T-head bolt and (1) nut in the first gland.



STEP 4B

STEP 5A. Snug the bolts by hand. It is important to maintain the same distance between the gland and the bell face at all times for a proper seal.



STEP 5A

STEP 5B. Tighten bolts using a torque wrench. Alternate side to side and top to bottom to achieve equal distance and torque.



STEP 5B

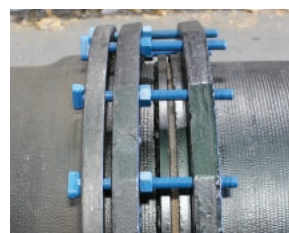
NOTE: Achieving the recommended bolt torque, particularly with large diameter pipe, may require repeating Step 5B up to five times or more. Recommended bolt torque ranges are as follows:

STEP 6A. Slide second gland onto the bolts and attach the second set of nuts.

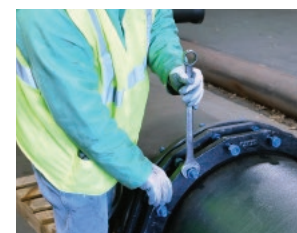
PIPE SIZE IN.	BOLT DIAMETER	NUT ACROSS FLATS IN.	TORQUE RANGE FOOT LBS.
16-24	3/4	1 1/4	75 to 90
30	1	1 5/8	100 to 120

NOTE: If deflection is needed, apply deflection at this point before tightening the outer hex nuts.

STEP 6B. These will be tightened to 20 foot pounds of torque.



STEP 6A



STEP 6B



POCKET ENGINEER

Available for iOS + Android
or online at pe.mcwane.com

CONNECT WITH US ON



NEW JERSEY
183 Sitgreaves St.
Phillipsburg, NJ 08865
908-454-1161

OHIO
2266 S. 6th St.
Coshocton, OH 43812
740-622-6651

UTAH
1401 E. 2000 South
Provo, UT 84606
801-373-6910



CanadaPipe.com

CANADA
55 Frid St. Unit #1
Hamilton, ON, L8P 4M3
905-547-3251

Rev. January 2026

McWaneDuctile.com