

DOS & DONT'S OF JOINT ASSEMBLY WITH SURE STOP 350® GASKET

DO IT RIGHT - WATER TIGHT!

McWane Ductile's Sure Stop 350® Gaskets are boltless, allowing quick, simple installation without special wrenches or tools and provide instant and easy joint restraint for Tyton Joint® pipe. To ensure proper joint assembly, follow these 7 basic steps.



1. BELL CLEANING

Thoroughly clean out the bell. Remove all foreign matter, dirt, sand, mud, ice, or excess paint or lining. Use a damp cloth. For caked-on debris, use a wire brush or chisel and flush with water.



2. PLAIN-END PREP

Clean the plain-end removing any dirt, foreign matter, or excess paint. On a field-cut, bevel the plain-end and smooth any sharp edges that might damage the gasket.



3. GASKET INSERTION

Form a V-shape in the gasket. One loop for sizes 3" - 18", two loops for sizes 20" - 24". Insert the gasket in its recess inside the bell, with the large end of the gasket entering first. Make sure the gasket faces in the correct direction and is properly seated. **NOTE:** Take a moment to double-check your work during this step.



4. LUBRICATION

Apply a generous coating of manufacturer-approved lubricant to the inside surface of the installed gasket just before joint assembly. Make certain the entire inner surface of the gasket is coated. Also, coat the plain-end of the adjoining pipe back to the home lines. **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.*



5. JOINING

Center the bevel of the plain-end with the inner surface of the Sure Stop Gasket. Maintain straight alignment until the pipe is fully homed. **DO NOT** move/wiggle the pipe side to side or up and down during assembly. **NOTE:** Additional force is required when assembling restraint gasket joints compared to standard Tyton® gaskets.

Do NOT "Wiggle" Pipe



Continued on reverse side...

DOS & DON'TS OF JOINT ASSEMBLY WITH SURE STOP® GASKET...CONTINUED

6. PRE-DEFLECTION

After the pipe is homed, take deflection on the pipe if needed while simultaneously pulling back on the pipe to remove slack and engage the gasket teeth.



8.



VERIFY ASSEMBLY

Use a feeler gauge to verify a properly assembled joint.

7. DEFLECTION

Deflection may be obtained after the joint is assembled.

SIZE INCHES	RATING PSI	DEFLECTION DEGREES
3	350	5
4	350	5
6	350	5
8	350	5
10	350	5
12	350	5
14	350	5
16	350	4
18	350	4
20	350	2.5
24	350	2.5

9.



VIEW INSTRUCTIONAL VIDEO

Using a mobile device, scan QR code to view a step-by-step gasket installation video.

ADDITIONAL APPLICATION NOTES:

- DO NOT reuse Sure Stop Gaskets. They may have been damaged during any previous installation or during removal.
- DO NOT use Sure Stop Gaskets to conduct electricity through the pipe joint.
- DO NOT use Sure Stop Gaskets in above-ground applications.
- DO NOT use Sure Stop Gaskets with thick coating on the pipe exterior.
- DO NOT just push pipe through a straight casing. The most reliable method is a concurrent PUSH and PULL. PUSH to drive the pipe, PULL to keep the pipe straight and avoid detrimental snaking of the pipeline.
- BE SURE to visit McWaneDuctile.com/blog and subscribe to the McWane Ductile YouTube channel for helpful articles and videos on Sure Stop Gaskets and other products and services.
- BE SURE to contact your local McWane Ductile sales representative for assistance with your water or wastewater project.



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