

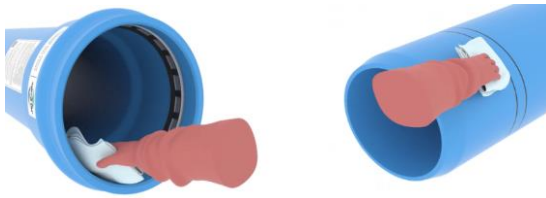
Proper Assembly with Dual Insertion Marks

Introduction

Eagle Loc 900RL, Blue Brute C900, and Ultra-Blue PVCO (C909) comes with two assembly mark lines on the spigot end of the pipe. These dual lines indicate the maximum and minimum depth of the insertion of the spigot into the bell. After the correct assembly of a joint with two insertions lines, the line closest to the spigot end (minimum) should not be visible, and the line furthest from the spigot end (maximum) should be visible.

Insertion Assembly Instructions

1. Clean the bell and spigot and remove all dirt, dust, water, pipe lubrication, etc.



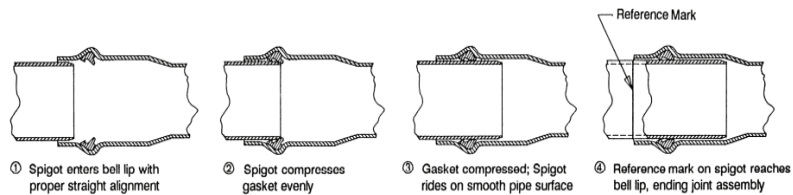
2. Lubricate. Apply a thin layer of lubricant to the entire spigot end circumference, with particular attention paid to the beveled end.

**For C909 & RL, also apply a thin layer to the face of the gasket, be careful not to get lubricant behind or under the gasket.*

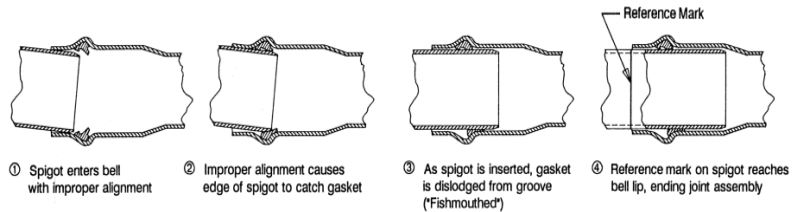


3. Assemble pipe. Insert the spigot end into the pipe until it contacts the gasket uniformly. Straight alignment is required. Apply steady pressure by hand or mechanical means (bar and block, come-along, hydraulic jack) until the spigot slips through the gasket. Insert the pipe until the stop line is flush with the bell end.

STRAIGHT ALIGNMENT BELL-AND-SPIGOT ASSEMBLY

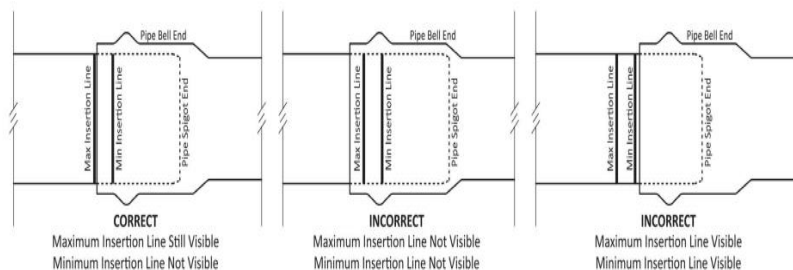


IMPROPER ALIGNMENT BELL-AND-SPIGOT ASSEMBLY



Prevent Over Assembly Instructions

When the second black line goes past the lip of the bell, it is called over-assembled or homed. When a spigot is over-inserted, there may not be adequate room for movement of the joint caused by thermal expansion and/or hydrostatic pressure. If over-insertion is combined with axial deflection of the joint, contact between the bell and spigot may cause joint leakage or significant stress in the bell wall.



Scan for

JM Eagle Loc 900RL & Ultra-Blue PVCO (C909)

Installation Video