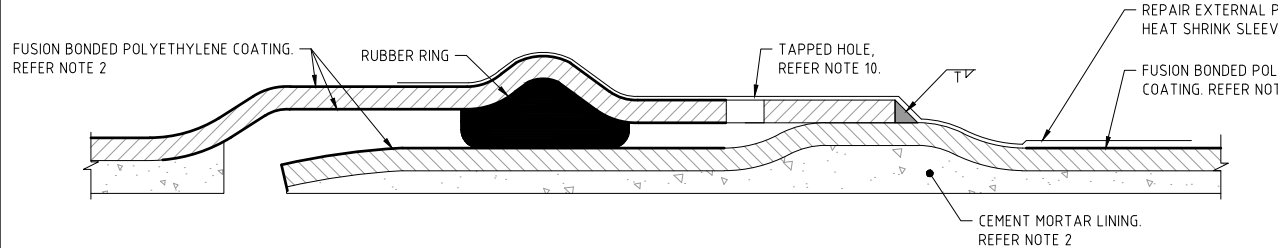


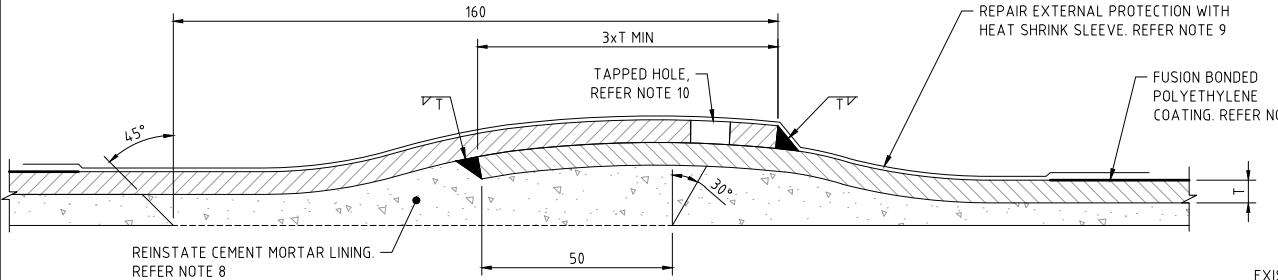
SPHERICAL SLIP IN WELDED JOINT DN150 TO DN750

SCALE 1:1
*MAXIMUM WALL THICKNESS OF 12mm



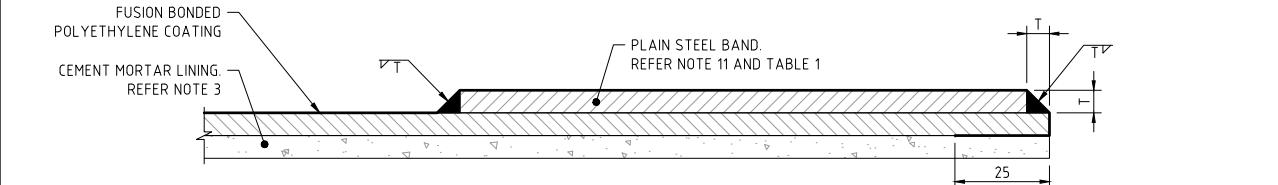
SOCKET WELDED END

SCALE 1:1
*MAXIMUM WALL THICKNESS OF 10mm (≤ 10mm)



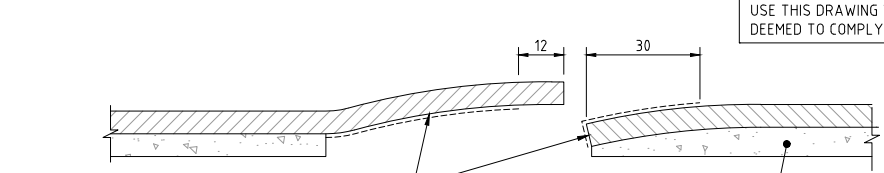
BALL AND SOCKET JOINT DN900-DN1200

SCALE 1:1



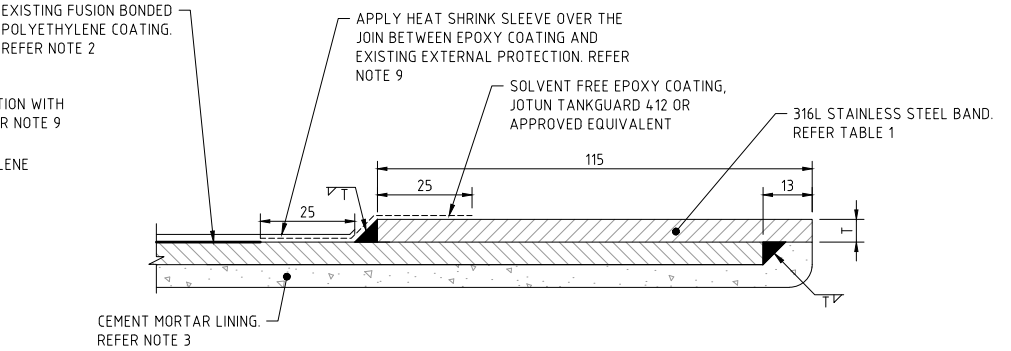
STEEL SPIGOT BAND FOR CONNECTIONS TO DCL SOCKET (RUBBER RING JOINT)

SCALE 1:1



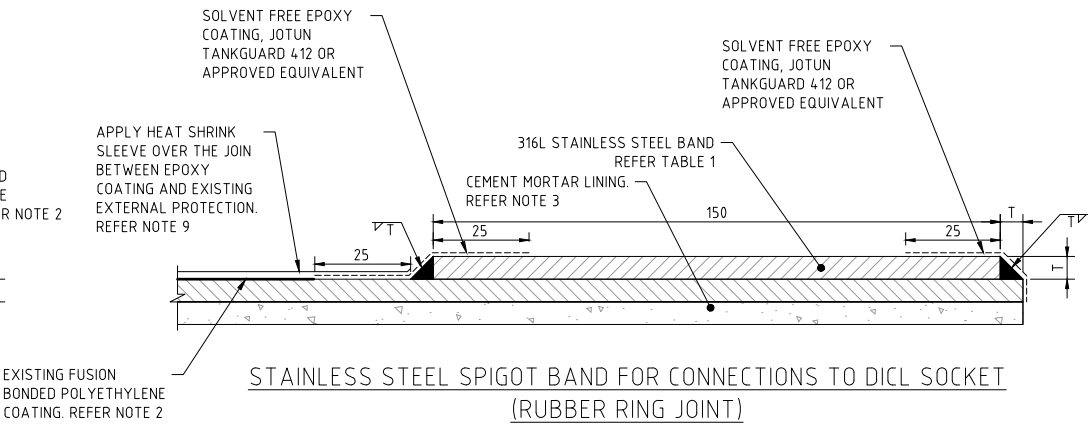
METALLIZING DETAILS OF SLIP-IN JOINT TYPE

SCALE 1:1



STAINLESS STEEL SPIGOT BANDS FOR DISMANTLING JOINTS

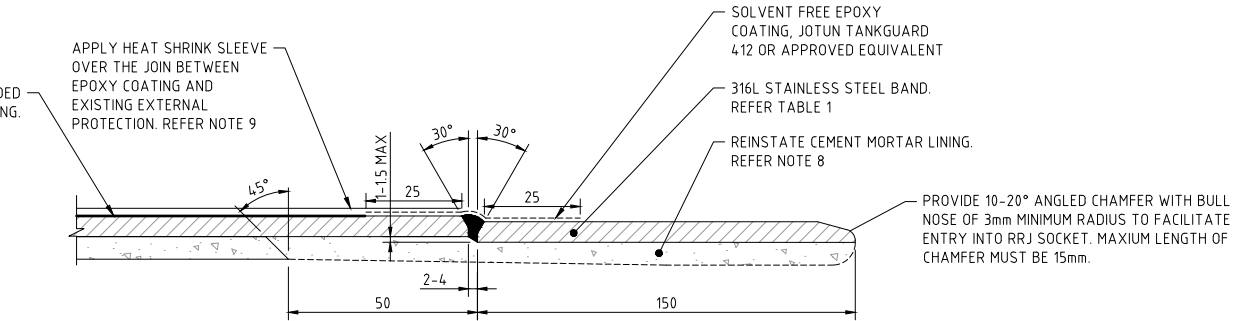
SCALE 1:1



STAINLESS STEEL SPIGOT BAND FOR CONNECTIONS TO DCL SOCKET (RUBBER RING JOINT)

SCALE 1:1

(SUITABLE ONLY WHERE USED IN CONCRETE ENCASEMENT)



INLINE SPIGOT BAND FOR CONNECTION TO DCL RRJ SOCKET FOR DN450 DCL/OD508 SCL & DN500 DCL/OD559 SCL ONLY

SCALE 1:1

(SUITABLE ONLY WHERE USED IN CONCRETE ENCASEMENT)

NOTES:

1. THIS DRAWING MUST BE READ IN CONJUNCTION WITH DTC/1100.
2. EXISTING FUSION BONDED POLYETHYLENE MUST BE CUT BACK 100 TO 125 mm FROM INTENDED WELD SITE.
3. INTERNAL CEMENT MORTAR LINING MUST FINISH AS CLOSE AS POSSIBLE TO THE END OF THE PIPE WHILE MAINTAINING THE ALLOWANCE FOR MAXIMUM DEFLECTION OF THE JOINT AS SPECIFIED BY THE MANUFACTURER. MAXIMUM GAP BETWEEN CEMENT MORTAR LINING TO BE 15mm.
4. CARE IS TO BE TAKEN WHEN INSTALLING PIPE, DAMAGE TO THE PIPE COATING IS TO BE REPAIRED AS PER MANUFACTURERS GUIDELINES.
5. ALL SPIGOT BANDS TO BE FACTORY MANUFACTURED.
6. ALL WELDS MUST BE GROUND FLUSH WITH EXTERNAL SURFACE AND SHARP EDGES TO BE REMOVED.
7. FILLET WELDS MUST BE CONTINUOUS. MINIMUM LEG LENGTH MUST BE 5mm.
8. CEMENT MORTAR LINING TO BE REINSTATED, OR WITH STEELMAINS EZLINE MORTAR MIX STRICTLY IN ACCORDANCE WITH MANUFACTURERS REQUIREMENTS, OR APPROVED EQUIVALENT. AT THE TIME OF APPLICATION OF THE MORTAR, THE SURFACE OF THE PIPE OR FITTING MUST BE FREE OF LOOSE RUST, LOOSE MILL SCALE, DIRT, DEBRIS, OIL, GREASE AND OTHER DETRIMENTAL MATERIAL.
9. HEAT SHRINK SLEEVE TO BE CANUSA K-60 WRAPAROUND SLEEVE FOR BURIED INSTALLATIONS AND CANUSA KLON SLEEVE FOR ABOVE GROUND INSTALLATIONS, OR APPROVED EQUIVALENT TO WSA PS-336. HEAT SHRINK SLEEVE TO EXTEND A MINIMUM OF 100mm OVER EXISTING FUSION BONDED POLYETHYLENE COATING AND 25mm OVER SOLVENT FREE EPOXY COATING, AND TO BE INSTALLED IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
10. PROVIDE A 5mm TAPPED HOLE TO RELEASE GASES DURING WELDING AND FOR PRESSURE TESTING. PLUG HOLE WITH 5mm GRUB SCREW AND GROUND FLUSH AFTER PRESSURE TESTING.
11. PLAIN STEEL SPIGOT BAND MUST BE GRADE 250.
12. WHERE METALLIZING MEETS EXISTING FUSION BONDED POLYETHYLENE COATING, TAPE ALONG THE JOIN USING DENSO TAPE SYSTEM OR APPROVED EQUIVALENT. EXTENDING 50mm MINIMUM EITHER SIDE OF JOIN.

TABLE 1 – SPIGOT BAND DIMENSIONS FOR CONNECTION TO DI SOCKET					
DICL DN	DICL OD	SCL OD	STAINLESS STEEL BAND T	FBPE COATED SCL T	
(mm)	(mm)	(mm)	(mm)	(mm)	
100	122	114	4	N/A	
150	177	168	4	N/A	
200	232	219	6	4	
250	286	273	6	4	
300	345	324	10	8	
300	345	337	4	N/A	
375	426	406	10	8	
375	426	419	4	N/A	
450	507	508	6*	N/A	
500	560	559	6*	N/A	
600	667	660	3	N/A	
750	826	813	6	4	

*APPLIES TO INLINE SPIGOT BAND