

## Assembly Steps – Series 1000 – For Ductile Iron Pipe

Steps : 1 and 2

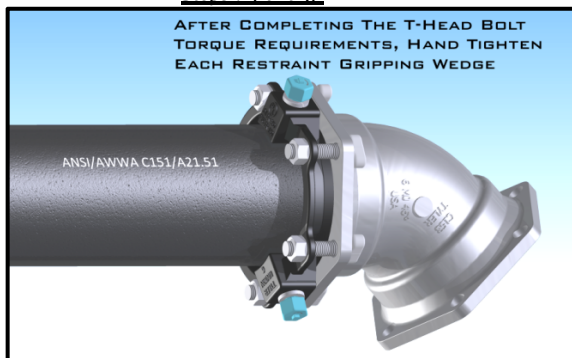


Step : 3

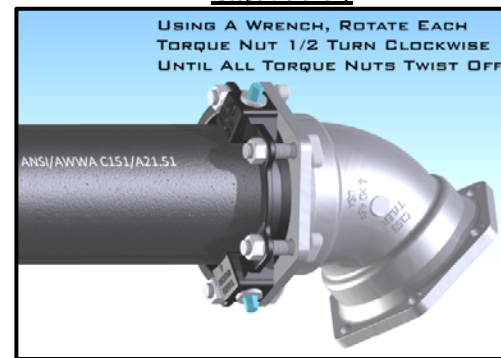


1. Insure the beveled pipe end to be joined and mechanical joint socket are clean and free of debris. Slide the Black TUF Grip onto the pipe to be restrained. The TUF Grip compression lip extension must be toward the beveled end of the pipe to be restrained.
2. Evenly lubricate the beveled pipe end, pipe wall exterior, and inside surface of the MJ gasket with a lubricant that meets the requirements of AWWA C111. Now place the \*\*MJ gasket over the plain beveled end of the pipe with the narrow edge of the tapered gasket toward the beveled end of the pipe to be restrained. **\*\*NOTE :** For Steel pipe with IPS diameter in sizes 3"-12", use of a MJ Transition gasket is required.
3. Fully insert the pipe end into the MJ socket pipe landing. Keeping the pipe straight, slide/push the MJ gasket firmly and evenly into the socket recess. Joint must be kept straight during assembly.

Steps : 4 and 5



Steps : 6 and 7



4. Push the TUF Grip compression lip extension evenly against the thick side of the gasket and insert T-Head bolts with the T-Head against the back side of the MJ fitting bolt flange. Use only T-Head bolts and nuts that meet AWWA C111 requirements. Evenly hand-tighten the nuts on the T-Head bolts making sure the gland is centered around the pipe and within the MJ socket. If joint deflection is needed, only deflect the pipe in the joint after hand tightening of all nuts is completed. \*Joint deflection is 3° max for 3", 5° max for 4"-12", 2° max for 14"-16", and 1.5° max for 18"- 48".  
**\*NOTE :** Maximum deflection values provided apply with nominal pipe, fitting, and restraint diameters.
5. Using a wrench, tighten the nuts on the T-Head bolts a few turns at a time in an alternating or star pattern maintaining equal spacing or distance between the TUF Grip bolt flange and face of the MJ socket bolt flange as the MJ gasket is compressed. The T-Head bolt and nut torque requirement is 45-60 ft-lb for 3", 75-90 ft-lb for 4"- 24", 100-120 ft-lb for 30"- 36", and 120-150 ft-lb for 42"- 48". **DO NOT OVER-TORQUE!**
6. Hand-tighten the torque limiting nut attached to each TUF Grip wedge assembly in a clockwise direction with an alternating or star pattern until all gripping wedges are in contact with the pipe wall. Rotational direction of torque limiting nut is indicated by a recessed arrow on the face of the nut. With a wrench (box, socket, or pneumatic), continue to tighten each torque nut ½ turn in an alternating or star pattern around the restraint until all torque limiting nuts twist off. **NEVER** turn a torque limiting nut more than ½ turn without turning the remaining torque nuts an equal amount!
7. When all torque limiting nuts twist off, the assembly of the mechanical joint is complete.

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