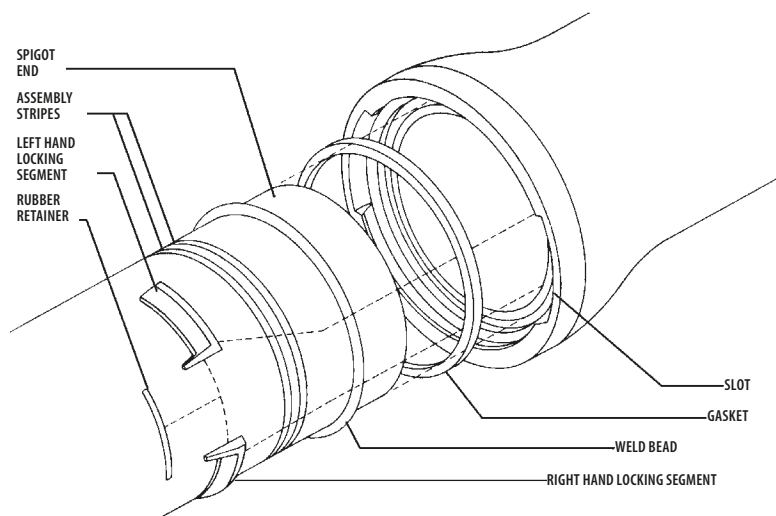


TWO BELL SLOTS

1. Lay pipe or fitting such that both of the bell slots are accessible (*in the horizontal position if possible*).
2. Clean the socket and insert a Tyton Gasket.
3. Clean the pipe spigot end back to the assembly stripes.
4. Lubricate the exposed surface of the gasket and the pipe spigot end back to the weld bead.
5. Make a conventional push-on joint assembly, fully homing the pipe until the first assembly stripe is in the bell socket. Keep the joint in straight alignment during assembly.
6. Insert lower locking segment into a bell slot and slide the segment around the pipe.
7. Insert upper locking segment into the same bell slot and rotate around the pipe.
8. Hold the upper segment in place and wedge the rubber retainer into the slot between the two locking segments.
9. Repeat steps 6–8 for other slot. Make sure that all 4 locking segments and 2 rubber retainers are securely in place.
10. Extend the joint to remove the slack in the locking segment cavity. Joint extension is necessary to attain the marked laying length on the pipe and to minimize growth or extension of the line as it is pressurized. (*Refer to the Table on page 21.*)
11. Set the joint deflection as required. (*See Table on page 21.*)



Components required for each joint:

- 2 right-hand locking segments (*painted red, marked RH*)
- 2 left-hand locking segments (*painted black, marked LH*)
- 2 rubber retainers
- 1 Tyton Gasket
- Tyton Joint® Lubricant



Installation Tips

- Fold and insert rubber retainer/s in a "U" shape as shown for normal buried applications.



Installation Tips

- For applications involving HDD, pipe bursting, bridge crossings, pipe in casings and above ground use.
- Trim rubber retainer/s 1/4" longer than the gap between the locking segments when they are inserted into the segment cavity. Drive the rubber retainer to the back of the cavity. The rubber is in compression and secure.