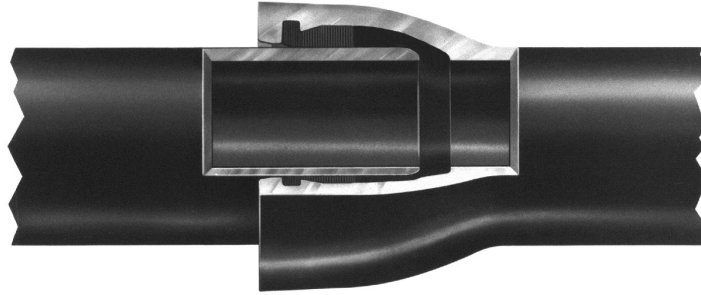




AMERICAN Fastite® Joint Pipe For Water, Sewage or Other Liquids



AMERICAN Fastite Joint Pipe in sizes 4" -64" for water, sewage or other liquids has the proven long-life and high-strength qualities inherent in pipe produced centrifugally in accordance with AWWA C151. In addition, this significant AMERICAN development, a dependable, single gasket, push-on type joint meeting the requirements of AWWA C111, affords the customer lower joint cost and time-saving advantages in installation. It provides exceptional strength and flexibility and has been widely accepted by engineers, contractors and utility officials since the 1950s. For added flexibility during construction, and for possible elimination of bends, a liberal 5° allowable deflection is standard in all sizes through 30", offering 21" offset in a 20' length of pipe. Liberal deflection can also be provided in larger diameter pipe with standard and Special Fastite Deflection Bells.

The patented AMERICAN Fastite Joint embodies many advanced design features and is rated for a water working pressure of 350 psi. For specific conditions, ductile iron piping with this joint has been approved for much higher pressure conditions. The socket, which is scientifically designed with two gasket recesses and a dividing buttress, is manufactured to close tolerances so that the gasket is self-centered, securely confined, and firmly compressed for a permanent, tight, trouble-free joint. The Fastite joint seal, bubble-tight under vacuum and external pressure, becomes even tighter with the application of internal pressure due to a specially designed wedging surface in the socket.

Fastite Joint Assembly

The bell opening is slightly tapered to provide easy entry of the pipe end; the flared socket design permits liberal joint deflection. The

plain end of the pipe is tapered or rounded to facilitate entry into the bell and self-centering in the gasket. On pipe cut in the field, the plain end can be easily beveled and smoothed by the use of a portable grinding wheel or other suitable apparatus. Methods of cutting ductile iron pipe are described in Section 3.

A stripe is painted on the plain end of AMERICAN Fastite Joint Pipe to provide a visual means of checking the joint alignment and to assure proper insertion. See page 2-10 for detailed assembly instructions.

Fastite Gasket

The Fastite Joint sealing component—a molded synthetic rubber ring gasket of two hardnesses, shaped to fit the configuration of the gasket socket—is manufactured per all requirements of ANSI/AWWA C111/A21.11 and under AMERICAN's own rigid specifications, assuring closely controlled dimensional and hardness properties. The smaller end of the gasket is of harder rubber, approximately 85 durometer hardness, which provides a strong shoulder for self-centering on the gasket buttress, a permanent seal against cold flow, and protection from deterioration. The larger end of the gasket is of softer rubber, approximately 65 durometer hardness, providing ease of assembly and positive sealing. The design assures effective sealing at low or high pressures and in straight or deflected joint alignment. It also eliminates any concerns of infiltration or root intrusion, and assures positive sealing against negative pressure, thus preventing gasket "pullout" should a vacuum be created in the line.

A taper on the inside of the gasket allows the entering pipe to locate and center on the hard section and reduces friction loads during



subsequent assembly. The snug fit and the hard section of the gasket, in conjunction with the design of the buttress, act to restrain the gasket against dislodgment during assembly. Additional internal pressure results in increased tightness of the seal when pipe is either in straight alignment or deflected.

Gaskets made of SBR (Styrene Butadiene Rubber) are standard. For information on gaskets made of special types of rubber, for applications involving air or liquid temperatures in excess of 150°F, or for chemical, hydrocarbon or other special service applications, and for installations in contaminated soils where permeation through gaskets might be a concern, consult AMERICAN for recommendations. See Table 2-1.

Fastite Lubricant

AMERICAN Fastite Joint Lubricant is a non-toxic water soluble material imparting neither taste nor odor to the conveyed water and is ANSI/NSF 61 approved. The lubricant is suitable

for use in hot or cold weather and will adhere to wet or dry pipe. AMERICAN Fastite Joint Pipe can be assembled when submerged, though for such installation, special AMERICAN underwater joint lubricant is recommended. See Table No. 2-5 for appropriate lubricant quantities.

Fastite Joint Materials

Standard joint materials include Fastite plain rubber gaskets and a sufficient supply of Fastite joint lubricant. Fastite pipes are most often readily joined with available excavating equipment; however, assembly tools can be supplied by AMERICAN on a loan basis with a nominal deposit which is refundable upon return of tools in good condition.

Coating and Lining

AMERICAN Fastite Joint Pipe can be furnished asphaltic coated, cement lined, or with special coating or lining where required. See Section 11.

Fastite Gaskets

Table No. 2-1

Common Name or Trade Name*	Chemical Name	Maximum Service Temperature**		Common Uses
		Water & Sewer	Air	
Plain Rubber	Styrene Butadiene Copolymer(SBR)	150°F	150°F	Fresh Water, Salt Water, Sanitary Sewage
Plain Rubber (conductive)	Styrene Butadiene Copolymer(SBR)	150°F	150°F	Electrical continuity for thawing of Service Water and Sewage
EPDM	Ethylene Propylene Diene Monomer	212°F	200°F	Water, Sewage, Ketones, Dilute Acids and Alkalies, Vegetable Oil, Alcohols, Air
Neoprene	Polychloroprene(CR)	200°F	180°F	Fresh Water, Sewage
Nitrile Buna-N	Acrylonitrile Butadiene(NBR)	150°F	150°F	Non-Aromatic Hydrocarbons, Petroleum Oil, Hydraulic Fluids, Fuel Oil, Fats, Oil, Grease†
Fluoroelastomer Fluorel Viton®***	FKM	212°F	300°F	Aromatic Hydrocarbons, Gasoline, Refined Petroleum Products, most Chemicals and Solvents, High Temp., Air (Least permeable of all available Fastite gasket rubbers)

*AMERICAN reserves the right to furnish any Trade or Brand rubber for the chemical formulation specified.
 Temperature is in reference to conveyed fluid. **Lubricating oil in air can adversely affect SBR and EPDM performance. SBR, Nitrile and Neoprene are not recommended for hot air exposure in wastewater treatment systems.
 ***Viton® is a registered trademark of DuPont Dow Elastomers.
 Refer to Section 11 for temperature and service capabilities of pipe linings.
 Refer higher temperatures or other special requirements to AMERICAN for recommendations regarding suitable gasket material.
 †This gasket rubber is chemically resistant in the non-potable water uses shown but is not as resistant to permeation in potable water applications as FKM.
 All Fastite gaskets made from the materials in the above table are suitable for use with water containing normal concentrations of chloramine. Where increased resistance to chloramine is desired, neoprene or fluoroelastomer materials should be considered.



**AMERICAN Fastite® Joint
for Ductile Iron Pipe
ANSI/AWWA C111/A21.11
Standard Dimensions**

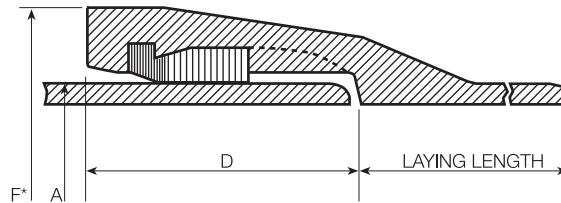


Table No. 2-2

Size in.	Nominal Laying Length ft.	Dimensions in Inches		
		A Outside Diameter	D Depth of Socket	F* Bell O.D.
4	20	4.80	3.31	6.40
6	20	6.90	3.38	8.60
8	20	9.05	3.75	10.96
10	20	11.10	3.75	13.12
12	20	13.20	3.75	15.22
14	20	15.30	5.23	17.61
16	20	17.40	5.23	19.74
18	20	19.50	5.50	22.16
20	20	21.60	5.50	24.28
24	20	25.80	5.50	28.50
30	20	32.00	6.50	34.95
36	20	38.30	6.50	41.37
42	20	44.50	7.50	48.27
48	20	50.80	8.00	54.71
54	20	57.56	8.50	61.65
60	20	61.61	8.75	65.80
64	20	65.67	9.00	70.04

*Dimensions subject to change at our option. Check AMERICAN if exact dimensions required.
See Section 3 for additional information on ductile iron pipe.
See Sections 4 and 7 for information on Fastite fittings.



AMERICAN Fastite® Joint Pipe
Allowable Joint Deflection

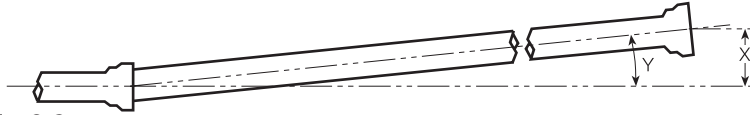


Table No. 2-3

Size in.	Nominal Laying Length ft.	Maximum Recommended Deflection†					
		Standard Bell			Special Deflection Bell		
		X Offset per Nominal Length in.	Y Deflection Angle	Radius of Curve* ft.	X Offset per Nominal Length in.	Y Deflection Angle	Radius of Curve* ft.
4	20	21	5°	230	—	—	—
6	20	21	5°	230	—	—	—
8	20	21	5°	230	—	—	—
10	20	21	5°	230	—	—	—
12	20	21	5°	230	—	—	—
14	20	21	5°	230	—	—	—
16	20	21	5°	230	—	—	—
18	20	21	5°	230	—	—	—
20	20	21	5°	230	—	—	—
24	20	21	5°	230	—	—	—
30	20	21	5°	230	—	—	—
36	20	17	4°	285	21	5°	230
42	20	12	3°	380	21	5°	230
48	20	12	3°	380	17	4°	285
54	20	12	3°	380	17	4°	285
60	20	12	3°	380	17	4°	285
64	20	12	3°	380	17	4°	285

*Approximate radius of curve produced by a succession of nominal lengths of pipe fully deflected.

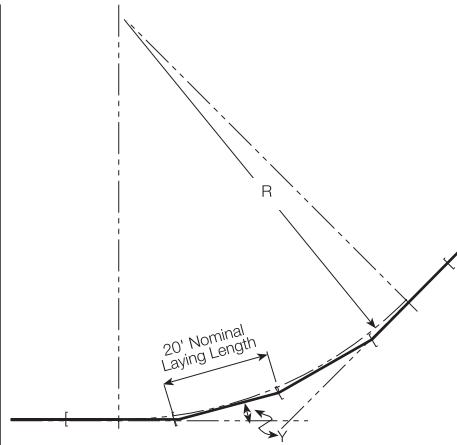
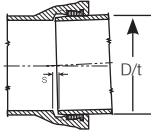
†Special Deflection Bells must be specifically ordered and will be marked with white bell face for easy identification.

For easiest assembly, the joints should be assembled with the pipe in reasonably straight alignment. After joint assembly, the pipe may be deflected up to the maximum shown above. Offset distances are based on 20-ft lengths.

Maximum Allowable Separation

Table No. 2-4

Size in.	S Separation in.
4	3/8
6	9/16
8	3/4
10	15/16
12	1 1/8
14	1 5/16
16	1 1/2
18	1 5/8
20	1 7/8
24	2 1/4
30	2 3/4
36	2 5/8
42	2 1/4
48	2 1/2
54	2 7/8
60	3 1/8
64	3 3/8



R = Radius of Curve (ft.)

Y = Deflection Angle (degrees)

$$\text{Radius of Curve} = \frac{\text{Nominal Laying Length}}{2 \times \text{Tangent}(Y \div 2)}$$

Maximum Allowable Separation, "S", in Standard Bell pipe is approximately equal to the median pipe diameter in inches times the sine of the deflection angle. This is provided for information only and should not be used to determine precise joint deflection.



AMERICAN Fastite® Joint Pipe Assembly Instructions

The AMERICAN Fastite Joint is a push-on type joint meeting all the rigorous requirements of AWWA C111. The ANSI/AWWA C600 Standard covers in detail the installation of ductile iron water mains, including assembly instructions for push-on joint pipe.

Field-cutting of AMERICAN Ductile Iron Pipe can be easily performed, thus eliminating the necessity for factory-made special lengths of Fastite pipe. The plain end of Fastite pipe cut in the field requires little or no preparation for assembly into the socket of a mechanical joint fitting. Where a cut pipe is to be assembled into a Fastite socket, the required beveling or rounding of the plain end can be easily accomplished by the use of a portable grinding wheel or other suitable apparatus. Methods of cutting ductile iron pipe are described in Section 3.

The AMERICAN Fastite Joint requires only one joint component, the rubber gasket*, which when properly installed, fits snugly in the gasket recess in the bell socket. A special lubricant supplied with the pipe is applied to the plain end and the inside surface of the gasket before assembly. The pipe end is tapered or rounded to provide self-centering of the plain end in the gasket and ease of assembly. A circumferential stripe on the plain end provides a visual indication for checking the proper insertion of the joint. The stripe, shown in the photographs illustrating assembly methods, passes fully into the bell when the plain end is fully inserted into the socket with the two lengths of pipe in straight align-

ment. Joints can then be safely deflected up to the extent shown in Table No. 2-3. In deflected joints, the stripe will typically be visible to some extent after assembly.

Easier assembly is effected if the pipe is suspended an inch or so off the bottom of the trench during the jointing operation.

The following instructions should be followed in order to properly assemble the joints and to fully realize the maximum speed and ease of assembly of the Fastite Joint:

1. Clean socket and plain end thoroughly, **removing mud, gravel, or any other matter that might cause the front of the gasket to protrude into the path of the entering spigot.**

2. Insert gasket fully into the gasket recess of the socket, large end of the gasket entering first. Gasket may be installed with one or two V-shaped folds as shown (Photo 1). After the gasket is in place at the bottom, the top of the gasket is positioned fully into the gasket recess. Gaskets and lubricant to be installed in very cold weather should be warmed first (as by storage in a heated equipment cab or pick-up, etc.) for optimum assembly.

3. Apply a thin film of regular AMERICAN Fastite Joint Lubricant to the rounded or tapered spigot end of the pipe, the immediate outside pipe surface between the stripe and the nose of the pipe (Photo 2), and also to the inside surface of the gasket. **Special AMERICAN Fastite Joint Lubricant intended specifically for underwater or very wet installations can be supplied when requested.**



Photo 1



Photo 2

*Gaskets not used immediately should be stored in a cool location, out of direct sunlight.



Caution: If a spigot end contacts the ground or trench side after lubrication, any adhering dirt or rocks should be cleaned off and the area re-lubricated prior to assembly.

4. Insert the plain end in the socket. For optimum assembly it is preferable that the entering pipe be in reasonably straight alignment; however, the Fastite Joint may be assembled if necessary with the pipe deflected within its rated deflection. (Exception: If Fast-Grip gaskets are being used, straight alignment must be maintained.) Push the plain end into the socket using any of the applicable assembly methods described hereinafter. If the joint cannot be assembled with a moderate force, remove the pipe and check for the cause of the difficulty, such as improper positioning of gasket, insufficient or wrong type lubricant, dirt under or behind the gasket, dirt adhering to the pipe, or any other cause which would result in obstruction or increased friction between pipe end and

gasket surface. **For assurance of proper assembly, a thin automotive, blade-type feeler gauge can also be used if desired for quick and easy probe confirmation of correctly installed axial gasket position around the joint.**

5. "Backwards" installation. AMERICAN does not recommend "backward laying" (bells assembled over spigots, rather than spigots inserted into bells as pictured in this literature) of large-diameter ductile iron pipe in buried installations. AMERICAN can furnish bell and plain end fittings to minimize the need for backward pipe laying. Other devices such as sleeves and couplings may also be employed for this reason. However, if this condition cannot be avoided, we strongly recommend that installers contact AMERICAN for instructions on how to reduce the potential for problems that could occur when assembling pipe in this manner.

AMERICAN Pipe Assembly Mechanisms

In general, Fastite joints or other Fastite gasketed pipes may be readily pushed or pulled together without the need for complicated tools or substantial manpower. This is most often accomplished with the procedures discussed on page 2-14. In general, the joints of AMERICAN push-on pipes are purposefully "tight," and most joints require an assembly force of about 100 to 200 pounds or more of assembly force per inch of pipe diameter (i.e. a 12" joint might require about 12 x 100 or 1,200 pounds of assembly force).

In pulling operations, simply wrap a sound wire rope choker cable or nylon sling around the barrel of the entering pipe. Secure the thimble eye or other end loop of the choker to a suitably anchored pulling device (e.g. backhoe, come-along, etc.). Use the mechanism to pull the cable taut in the

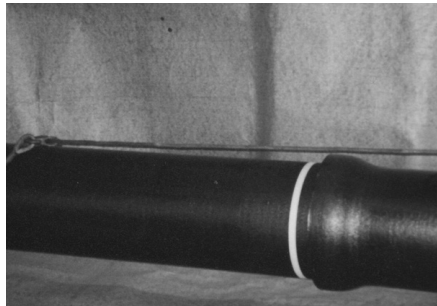


Photo 3

assembly direction (Photo 3). Continue pulling the cable in a smooth, continuous motion until the joint is in the fully assembled position. If desired for special conditions, AMERICAN can furnish suitable, simple come-alongs and choker cables for manpower assembly of

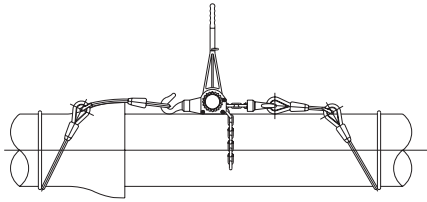


Figure 1
most 4"-24" pipes (See Figure 1 and specify pipe sizes involved).

The joints may normally be disassembled in a similar manner, reversing the direction of the pull with the choker cable (Photo 4). It is also sometimes helpful to use rebating or wiggling deflection to aid in the disassembly of push-on joint pipes, particularly when pipes have been installed for some time prior to removal.

30"-64" Pipe



Photo 4

Large pipes are most often readily pushed or pulled together with heavy excavating/earthmoving equipment available on-site (see page 2-14). In cases where assembly of pipes by manpower is desired, AMERICAN can provide special assembly tools and rigging which can be used for assembling most pipes of all sizes (Photo 5). These tools consist of a heavy-duty roller chain hoist, a steel pipe-end hook and snatch block, and associated wire



Photo 5

rope and chain tackle (Photo 5) to attach all the rigging together to effect "double line" assembly from the top of the pipe (Photo 6). The snatch block pulley and twin line rigging approximately doubles the assembly force from the strong come-along, making possible the assembly of up to 64" full-length pipe joints from the top of the pipe (Photo 7).



Photo 6

Fittings and Short Pipes

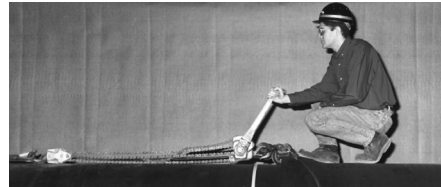


Photo 7

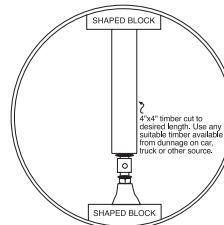
Push-on fitting or short pipe joint assembly is basically the same as that of standard length pipe, though special rigging may be necessary to hold these short items reasonably stable for assembly. See also Push-On Fittings Assembly Instructions in Section 4.

Field Rounding

Occasionally, field rounding of pipe ends may be necessary to accomplish assembly, particularly when large-diameter pipes are cut to be assembled into mechanical joints or couplings. Need for rounding in assembly of mechanical or stuffing-box-type joints can be predetermined by a difficulty in sliding the gland or end ring over the end of the pipe. Rounding may be accomplished in the following manner using a mechanical jack and shaped blocks. (Note: This procedure may also be used with the assemblies involving push-on joint pipe, fittings, valves, etc.; however, rounding is less frequently necessary for assembly of push-on joints.)



1. Measure/determine the minimum (minor) diameter of the ends to be rounded.
2. Place the jack and the shaped blocks in line with the minor diameter as shown in the attached sketch using a sound 4"x4" spacer timber cut square to the required length to take up the space.
3. Apply a load carefully with the jack only until the "minimum diameter equals the maximum diameter," or until the gland will easily slip over the end. No more jacking should be attempted or necessary - **DO NOT ATTEMPT TO PERMANENTLY ROUND END.**
4. When no mechanical joint restraint device is used, carefully relax and remove the jack and timbers from the pipe after joint assembly.
5. When using a mechanical joint restraint device not manufactured by AMERICAN, contact the applicable manufacturer of the restraint device regarding installation guidelines.



Note: Field rounding operations should be conducted without backfill on any part of large-diameter pipes and prior to encasing any part of pipe in concrete. If the inside of the pipe cannot be accessed to remove jacking materials, pipe ends can alternatively be rounded using external clamping means.

AMERICAN Fastite® Joint Lubricant Requirement by Size of Pipe



64" AMERICAN Fastite Joint pipe being installed in a wastewater application.

Table No. 2-5

Pipe Size in.	Approx. Pounds of Lubricant per Joint	Approx. No. of Joints per Pound of Lubricant
4	.03	33
6	.045	22
8	.06	17
10	.07	14
12	.08	12
14	.09	11
16	.11	9
18	.12	8
20	.14	7
24	.17	6
30	.30	3
36	.36	3
42	.44	2
48	.50	2
54	.59	2
60	.66	1
64	.71	1

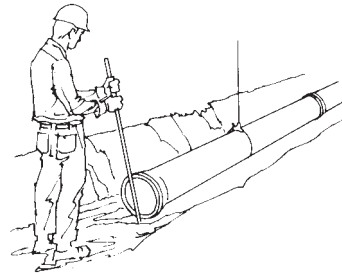


AMERICAN Fastite® Joint Common Assembly Methods

In seeking ways to take even greater advantage of the cost-reducing features of the Fastite Joint, utility contractors have developed other methods of assembling this joint without special tools. The following methods are described for the information of the user, who may elect to use them at his discretion, keeping in mind that these methods may not be effective for all installations and under all field conditions.

Spade or Crowbar Method

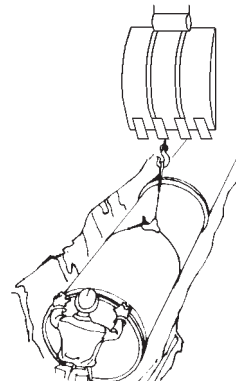
This is applicable to the smaller sizes of AMERICAN Fastite Joint Pipe, and consists of centering the lubricated end of the entering pipe in the gasket and then pushing against the bell face of the entering pipe with a spade or crowbar driven into the ground in front of the bell face. This method requires the trench bottom to be fairly firm soil. The method may not be effective in a rocky trench or with a trench that is soft, muddy or sandy. A wooden block between the bell face and the pry bar may increase the leverage. Easier assembly is effected if the pipe is suspended an inch or so off the bottom of the trench.



Spade or Crowbar Method

Backhoe and Heavy Equipment Methods

These methods are usually applicable to the intermediate and larger sizes of AMERICAN Fastite Joint Pipe where the bar method might not be effective. It consists of centering the end of the entering pipe in the gasket as the pipe to be assembled is suspended from the backhoe. Then it can be pulled into the adjoining socket with the pipe sling by moving the backhoe arm toward the previously assembled pipe. In other instances, the pipe may be assembled by placing the backhoe or other earth mover bucket or blade against the bell face of the entering pipe and pushing it into the socket. When pushing against the bell face, care should be taken to avoid very small contact areas and possible damage to the pipe bells or spigots. Wood cushions between the backhoe bucket and the pipe are particularly effective in preventing damage.



Backhoe and Heavy Equipment Methods