

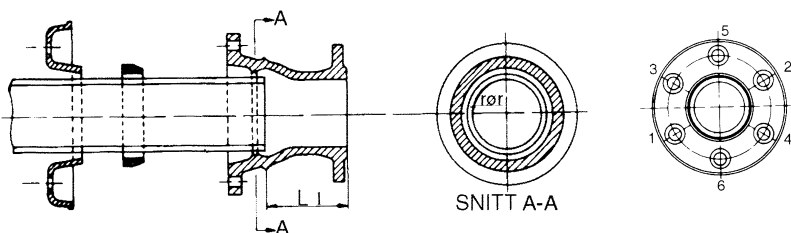
Assembly instructions

Heinco socket pipe fittings for cast iron and ductile iron pipes

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Specifications

1. Slide the gland and gasket over the end of the pipe.
2. Slide the pipe into the socket and centre it.
3. Insert the gasket into the socket, followed by the gland. Make sure the leading edge of the gland is symmetrically positioned around the entire periphery of the gasket.
4. Tighten bolts from one side to the other, as shown in the diagram. Use a torque wrench and tighten the bolts to an initial torque of 60 Nm, increasing this progressively up to 100 Nm for DN < 300, and 120 Nm for DN > 300.
5. Check that angular deviation does not exceed 4° in any direction.



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