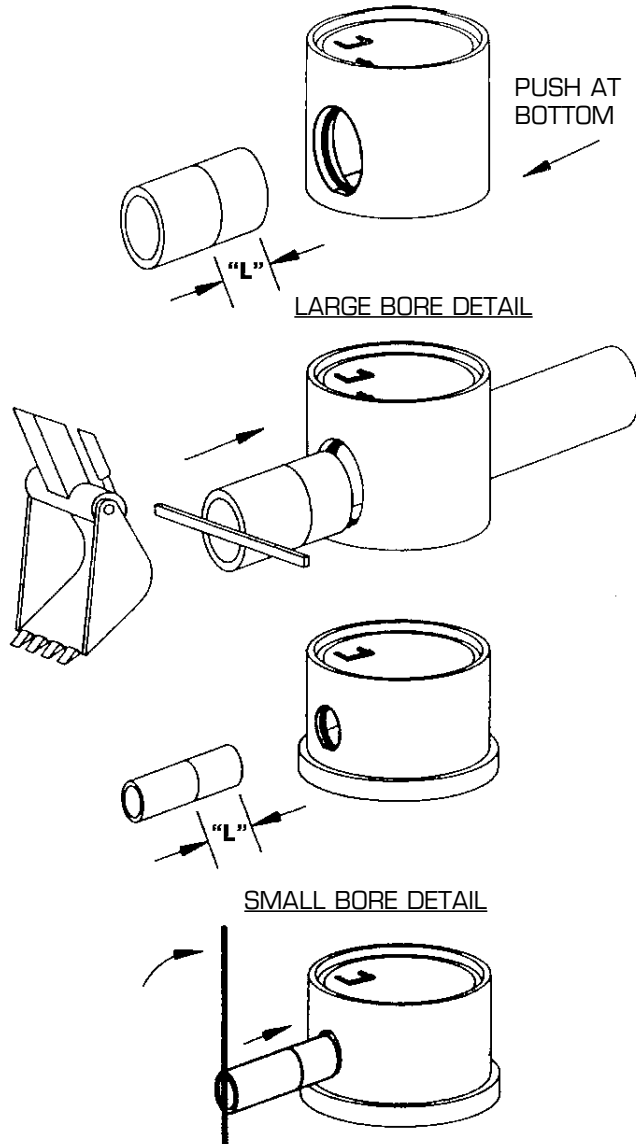


PIPE INSTALLATION INSTRUCTIONS FOR A•LOK CONNECTORS



STEP 1: CLEAN AND BEVEL

Confirm that pipe and connector are clean and free of foreign material. Confirm that pipe surface is relatively smooth and free of chips, gouges due to handling and form seams remaining from the manufacturing process. Slightly bevel sharp or blunt edges caused by cutting pipe. If there is a centering flat spot on the structure it should be located at the bottom of the gasket.

STEP 2: LUBRICATE

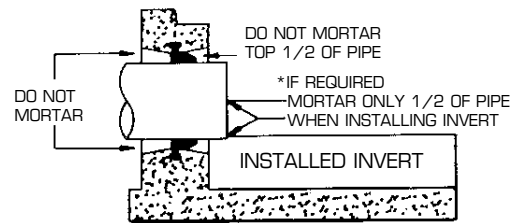
Lubricate the outside portion of the connector. Lubricate the entire section of the pipe which will slide through the A•LOK connector "L" inches from the end according to the accompanying chart.

STEP 3: CENTER

Center pipe square to structure or structure square to pipe and push home using bar or machine depending on size. If deflection is necessary, deflect pipe or structure after complete coupling.

WARNING

Because of the A•LOK connectors ability to insure a flexible, watertight joint, it is our strong recommendation that no mortar be placed around the connector at all on the outside of the structure and that no mortar be placed around the top half of the connector on the inside when completing the invert work. The use of mortar in either of these areas would eliminate the flexibility for which the connector was designed and cause problems of shear. Failure to follow proper installation could result in connector failure.



NOTE: To determine the sub-grade from the invert of the pipe, measure from the outside base of the structure to the junction of the connector and flat spot. Then add the wall thickness of the pipe plus 1/4 inch.

CAUTION: When installing pipe stubs for future pipeline, all stubs should be properly restrained to prevent any movement.

PIPE DIA.	"L" MIN.	PIPE DIA.	"L" MIN.
4"	12"	24"	24"
6"	12"	27"	24"
8"	12"	30"	24"
10"	12"	33"	24"
12"	12"	36"	24"
15"	12"	42"	24"
16"	18"	48"	24"
18"	18"	54"	24"
21"	24"	60"-80"	24"

A•LOK
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