

PRE-POUR INSPECTION

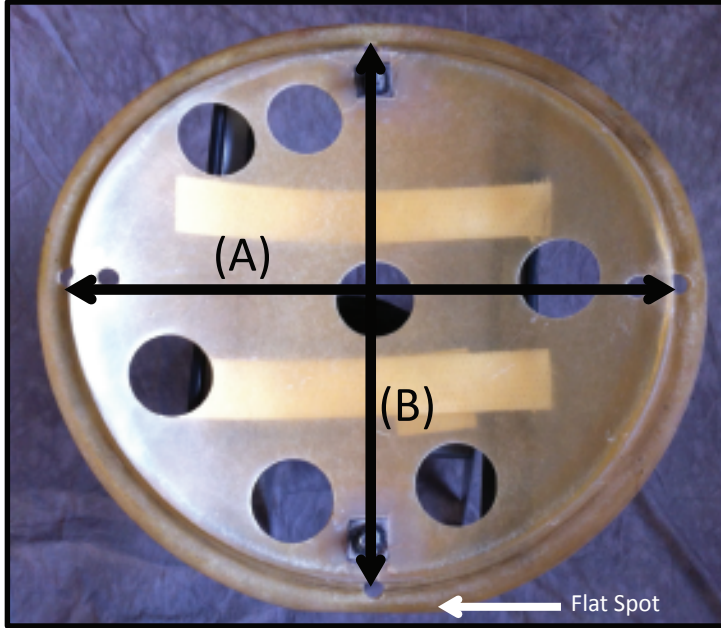


Fig.1 - Outside Mandrel Half

1. Determine your parts are correct by checking the pipe O.D. using the A-LOK Dimensional Data Sheet where you will find the correct connector and mandrel.
2. Measure the offset of the outside mandrel half at the 3 & 9 (A) and 6 & 12 (B) o'clock positions to check for roundness. These measurements should be within 1/4" of each other.
3. To identify the mandrel, locate the measurement from the 6 & 12 o'clock position (B) in the mandrel I.D. column on the A-LOK Dimensional Data Sheet. The connector and mandrel should have matching part numbers.
4. After the connector has been installed on the mandrel, measure the width of the mandrel at the 12 o'clock position (Fig. 2) to determine the wall thickness.
5. Check to make sure the mandrel locations, angles and heights match the plans.

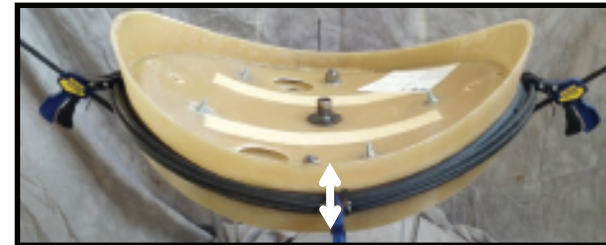
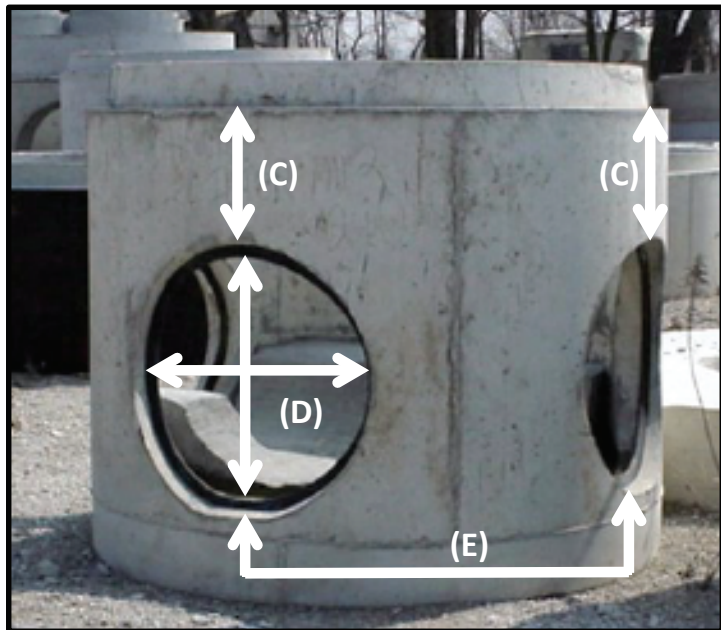


Fig. 2
A-LOK Connector
Mounted on Mandrel



A-LOK Connectors Cast-in Manhole

POST-POUR INSPECTION

1. After stripping from form, check correct placement and heights to make sure no movement or shifting has occurred by using a common reference point (C).
2. Measure the connector's inside dimension at 12 & 6 and 3 & 9 o'clock positions for concentricity (D). These measurements should be within 1/4" of each other. Compare measurements with our Dimensional Data Sheet.
3. Check angle placement of connectors by measuring the center-to-center dimensions of the connectors (E). The angle can be determined by using the following formula:

$$\frac{\text{Structure OD} \times \pi}{360} = \frac{\text{inches}}{\text{degree}}$$

4. Visually check connector for consistent embedment all the way around and to ensure it is not damaged. Make sure the flat spot is on the bottom (B).



Manhole Quality Assurance Worksheet

Manhole Number	Pipe Penetration Degree	Invert Elevation	Type of Pipe	Pipe OD	A-LOK Connector Number	A-LOK Ring ID Measurement	A-LOK Ring OD Measurement	Actual Mandrel ID Pre-pour		Date	Actual Connector ID Post-Pour		Date	PASS/FAIL and Initials
								12-6	3-9		12-6	3-9		

The back of this worksheet has detailed information and instructions depicting how to achieve the correct measurements regarding Pre-Pour and Post-Pour Quality Assurance.

Please call A-LOK with any questions at (800) 822-2565.