ROMAC INDUSTRIES, INC.

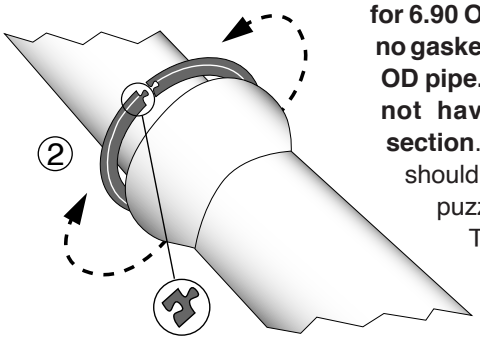
INSTALLATION INSTRUCTIONS

Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the clamp to ensure you have the proper size.

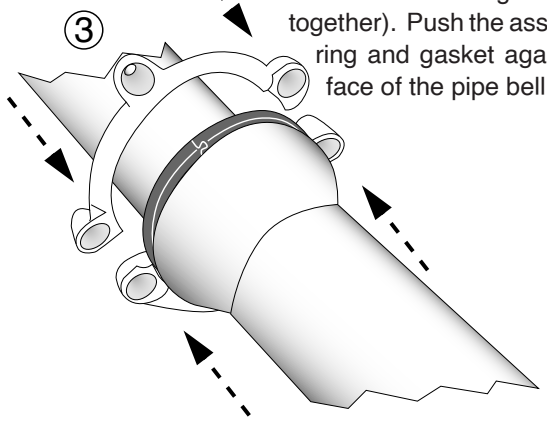
Style 516 Bell Joint Leak Clamp
4" & 6" Sizes

Step 1 • Check the BJLC parts to insure that no damage has occurred during transit. Clean all around the pipe and on the face of the bell where the gasket will contact. These surfaces must be free of all lead, dirt, etc.

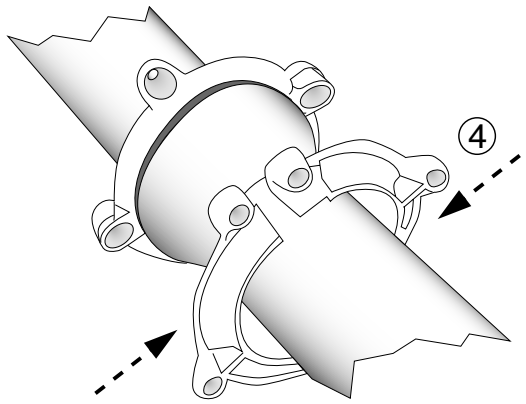
Step 2 • Lubricate the gasket with a suitable gasket lubricant. Wrap the gasket around the pipe (see arrow on ID of gasket for proper orientation). **(*Remove gasket section for 6.90 OD pipe. Remove no gasket section for 7.10 OD pipe. 4" gasket does not have a removable section.)** The gasket ends should meet so that the puzzle joint interlocks. The joint in the gasket should be 90° from the joint in the pipe ring.



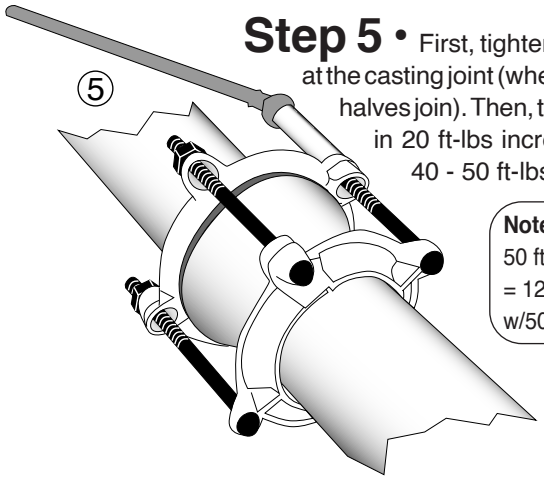
Step 3 • Assemble the pipe half around the pipe (it may be necessary to insert one bolt with nuts to hold ring segments together). Push the assembled ring and gasket against the face of the pipe bell.



Step 4 • Assemble the bell half around the pipe behind the bell. Insert bolts and hand tighten all nuts.



Step 5 • First, tighten the bolts at the casting joint (where the two halves join). Then, tighten bolt in 20 ft-lbs increments to 40 - 50 ft-lbs.



Note:
50 ft-lbs. torque = 12" wrench w/50 lbs. force

For best results, wait 10 minutes and re-torque.

Step 6 • Check for leaking. Re-tighten the bolts evenly around the pipe as necessary to stop leaking.

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ROMAC INDUSTRIES, INC.

INSTALLATION INSTRUCTIONS

Bell Joint Leak Clamp

Style 516

4" & 6" Sizes

PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correct size clamp; also check gasket to make sure it is the size you think it is.
2. Clean pipe to remove as much dirt and corrosion as possible from pipe surface and bell face where the gasket will contact. Lubricate gasket and pipe with soapy water or approved pipe lubricant per ANSI/AWWA C111/A21.11.
3. Make sure no foreign materials lodge between gasket and pipe.
4. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque.
5. Keep threads free of foreign material to allow proper tightening.
6. Take extra care to follow proper bolt tightening procedures and torque recommendations. Bolts are often not tightened enough when a torque wrench is not used.
7. The thick edge of the gasket should be facing the bell face.
8. The puzzle joint of the gasket should be between casting joints.
9. Pressure test for leaks before backfilling.
10. Backfill and compact carefully around pipe and fitting.
11. When reinstalling parts with stainless steel hardware there may be a loss in pressure holding ability due to worn or damaged threads during the original installation.

COMMON INSTALLATION PROBLEMS

1. Bolts are not tightened to the proper torque.
2. Rocks or debris between pipe and gasket.
3. Dirt on threads of bolts or nuts.
4. Puzzle joint in gasket not offset from casting joint.
5. Thick end of gasket not toward the bell face.
6. Too much pipe deflection.

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