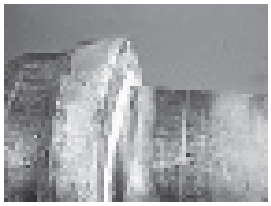
INSTALLATION INSTRUCTION 0001-0582-999

Style 60 Bell Joint Clamp

For Cast Iron Pipe Bell & Spigot Joints

1. Clean joint. By hand or with power tools thoroughly clean back of bell and on the spigot for a distance of six inches, and on the bell face. It is very important that all dirt, loose rust and scale be removed so that the gasket will seat on virtually bare metal.

2. Re-Calk. Drive back lead in calked joints if it protrudes beyond the bell face or is loose. If the joint is leaking badly, it is sometimes necessary to fill in gaps in the caulking with lead wool or similar material. Cement joints should be trimmed back, even with the bell face.



3. Face-up joint. If caulking is recessed 1/8 inch or more it should be brought up flush with the bell face. Lead wool is good for this purpose. Plaster of paris and cement are also used. It is important to remove excess plaster from the bell face and spigot.

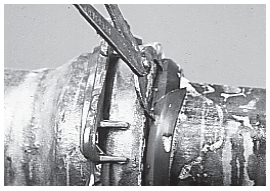
4. Install bell ring. The bell (or anchor) ring is now fitted to the bell so that it is snug all the way around. After the section bolts are given a final tightening, drive the ring to a firm anchorage on the bell with a hammer.

5. Mark gasket. The split Dresser gasket should be snugly fitted around the spigot and marked for cutting with a chalk or crayon. The mark for cutting should run parallel to the original cut. It should allow for cutting the gasket 1/4 inch short for clamps 12” and above, and 1/8 inch short for smaller clamps.

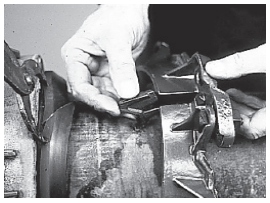
6. Cut gasket. Using a sharp knife or hack saw, cut the gasket parallel to the original cut as marked. A little water on knife and gasket makes cutting easier. While a sharp knife is usually all that is necessary, the use of a mitre box sometimes facilitates accurate cutting.

7. Soap joint area. Using soapy water (anti-freeze should be added in freezing weather), wash down the joint area, and face and spigot thoroughly where the gasket is to seat.

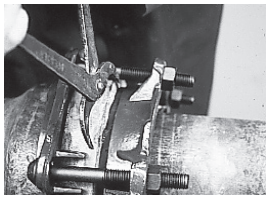
8. Soap gasket. A very important next step is to apply soapy water thoroughly over the entire gasket area. Oversoaping will not affect the joint area and actually aids in securing a tight pack through the proper positioning of clamp parts.



9. Position gasket. Stretch the gasket around the spigot so that it meets at the cut. Dresser gasket tongs provide a convenient means for holding the gasket in the proper position during installation of the clamp. If tongs are not available, the gasket can be tacked or cemented together.



10. Assemble spigot ring. Assemble the sections of the spigot ring for a close sliding fit on the pipe using fillers in the joiner clips as needed. To secure a uniform fit all around the joint, fillers should be spaced out as evenly as possible among all the clips. Complete assembly of spigot ring to a sliding fit on the pipe a short distance away from the gasket.



11. Insert bolts. Turn spigot ring sufficiently to line up bolt holes with the bell ring to assure a good even pull. Insert bolts starting through the bell ring and through the spigot ring. Run on nuts with the rounded edge toward the clamp ring. Tighten bolts starting at the clips and working on opposite bolts in the same manner used in tightening a wheel on a car.

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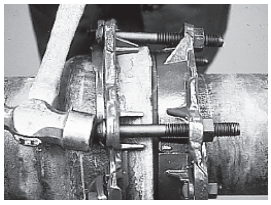
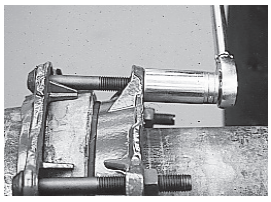
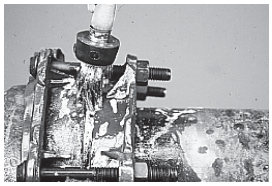


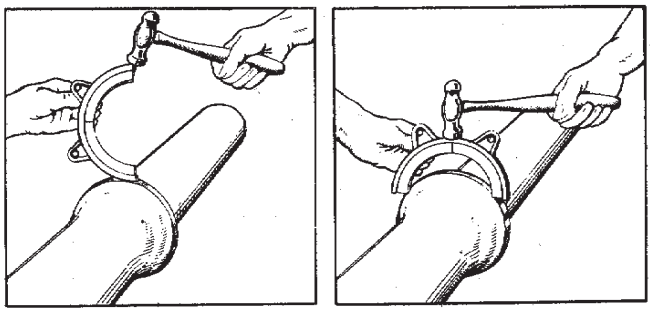
12. Hammer Bolts and Clips. When all bolts are fairly tight, make sure the bell ring has seated properly by tapping the top of the bolt heads. Also, hammer clips all the way around.



13. Final Tightening. Bolts should now be given a final tightening to the proper torque. A Dresser Torque-Limiting wrench can be used to double check correct tightening of the bolts. Recommended bolt torque for all sizes of clamps is 50 ft. lbs on 5/8" bolts and 65 ft. lbs. on 3/4" bolts.



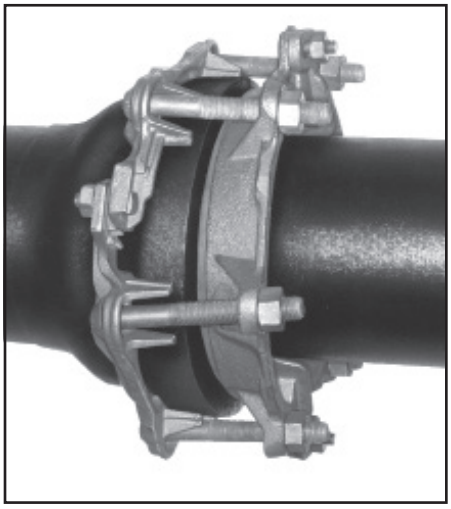
14. Test Installation. Soap joint and watch for bubbles. A good test also is to insert the tip end of a trowel under the gasket at different points. If more than 1/8 inch penetration is observed, it would be advisable to hammer the lugs once again and check the tightness of the bolts.



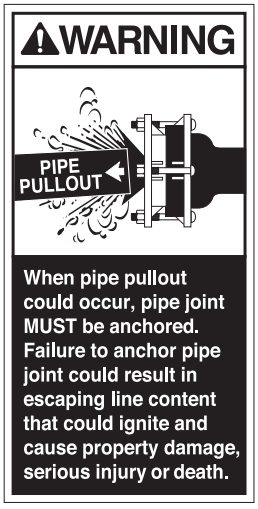
Style 60 clamps through 12" size can be adjusted to the ideal close fit to the curvature of undersize or oversize pipe by following this recommended procedure:

For Undersize Pipe: Tap on end with hammer (above left) to close section slightly.

For Oversize Pipe: Tap at middle of section (above right). The saw cut in the middle of this section makes this adjustment possible.



Completed Installation. This completes installation of the Style 60 Bell Joint Clamp and assures you of a permanently tight joint.



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