

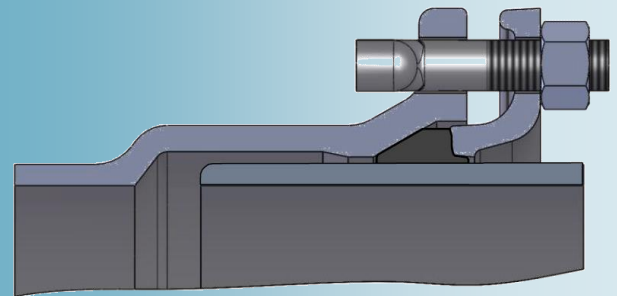
FITTINGS AND VALVES

DRAINAGE TECHNOLOGY

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JOBGING FOUNDRY



Laying Instructions

for ductile cast iron pressure pipes and fittings

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with bolted-gland socket joints
as per German standard DIN 28602

Laying Instructions for Bolted-Gland Socket Joints

Installation

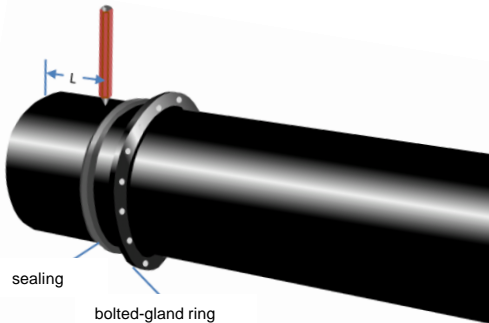
- Clean the socket (particularly the sealing seat), the spigot to be inserted, the sealing and the bolted-gland ring.
- Mark the distance measure:

Length of measure L in mm

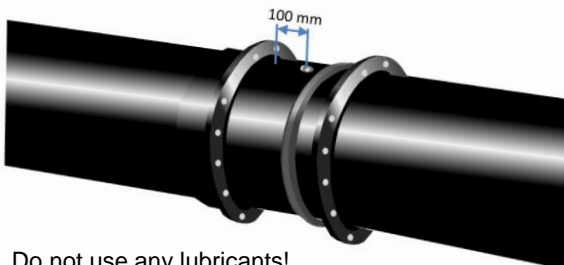
DN	100	125	150	200	250	300	350	400
L	160	160	160	162	162	165	165	170

DN	450	500	600	700	800	900	1000	1200
L	172	172	180	182	190	197	200	215

- Push the bolted-gland ring and sealing ring behind the marking.



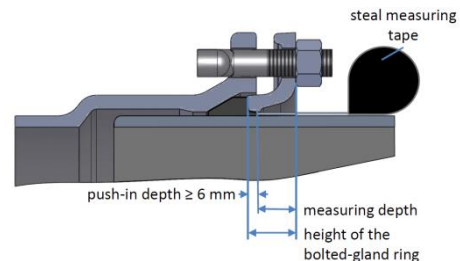
- Insert the spigot into the socket so a distance of 100 mm is kept between the mark and the flange.



Do not use any lubricants!

- Push the sealing into the sealing seat
- Push the bolted-gland ring onto the sealing and align it using hardwood wedges.
- Insert hammer head bolts into the bolted-gland flange and the bolted-gland ring.
- Screw on the nuts by hand as tightly as possible
- Tighten the nuts with ring spanners one by one (always two nuts facing each other) by a half or one turn each time

The tightening is correct when the bolted-gland ring has pushed itself at least 6 mm into the sealing. The depth can be determined by measuring the height of the bolted-gland ring, and the depth from the edge of the bolted-gland ring up to the sealing ring before and after tightening the bolts. The depth on one bolted-gland socket joint should be as uniform as possible.



Control the correct depth once more.

Angle

After tightening the joint in a centred and aligned position, the pipes can be put in an angle of up to 3°. An angle of 1° results in a deviation of a 6 m pipe from the axis of the connected pipe or fitting by approx. 10 cm; for 3° it is approx. 30 cm.