



JCM 106 Bell Joint Leak Clamp For IPS PVC Joints and Couplings INSTALLATION INSTRUCTIONS

Installation for IPS PVC Bell Joint

1. Clean pipe surface of all dirt, rust, mud or loose scale from pipe ends. Inspect the pipe surface where gaskets will contact the pipe for any gouges, grooves, irregularities or imperfections that will interfere with the gasket seal. Measure the cleaned pipe diameter to confirm proper size of bell joint leak clamp for application. Inspection of the pipe's integrity for product application is the responsibility of the end user. ***TIP*** *Difficult to reach or cramped areas on the backside or underside of the pipe can be visually checked by using a mirror.*
2. Install a gasket (key-locked for installation) on the spigot side of the joint. Slide the gasket toward the joint so that flat side of the gasket meets up with the face of the bell (the tapered side will fit into the iron pusher ring). Install the other gasket in the same manner on the bell side of the joint where the bell tapers down to the straight run of pipe. This gasket will protect the PVC pipe wall from the iron pusher ring at the bell.
3. Interlock the ductile iron clamp ring segments on the spigot side of the joint and install a track head bolt into the bolt holes to hold the segments together. On the bell side of the joint install the other clamp ring segments in the same manner behind the protective gasket. Interlock the segments and install a track head bolt through the bolts holes to hold the segments together. Starting from the bell side to the spigot side, install track head bolts through the segments and over the joint into the corresponding bolt holes of the opposite clamp rings. Loosely assemble nuts on the ends of the bolts.
4. Tighten the nuts evenly until the spigot gasket compresses against the joint and the leak stops. Tight nuts to approximately 20 - 30 ft. lbs. of torque.

Installation for IPS PVC Collar Joint

1. Follow steps above. During step 2, place the first and second gaskets in the same manner with the flat side meeting up against the lip of the collar.
2. Continue with installation of ductile iron clamp ring segments and position against gasket (taper facing out) and install bolts as described above.
3. JCM 106 Bell Joint Leak Clamp will repair (and prevent) any leaks on the collar joint on both sides of the joint.

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Lubricate the gasket with soapy-water solution. Do not use oil based pipe lubricant. Install the gasket (key locked cut for installation) on the spigot side of the joint with the flat side facing toward the pipe bell. Slide the gasket toward the joint so that flat side of the gasket meets up with the face of the bell (the tapered side will fit into the ductile iron pusher ring). Interlock the key locked cut. Install the other gasket in the same manner on the bell side of the joint where the bell tapers down to the straight run of pipe. This gasket will protect the PVC pipe wall from the iron pusher ring at the bell.

Interlock the ductile iron clamp ring segments on the spigot side of the joint. **Ensure that the ductile iron clamp ring joint is rotated 90° (1/4 turn) from the gasket joint.**

On the bell side of the joint install the second set of clamp ring segments in the same manner. Interlock the segments. To ensure proper gasket compression, rotate the bell side ductile iron clamp ring one bolt hole turn from the spigot ductile iron ring (*i.e. do not align clamp ring joints or gasket joints*). Starting from the bell side to the spigot side, install a track head bolt through the bolts holes to hold the segments together. Complete installation by inserting the track head bolts through the segments and over the joint into the corresponding bolt holes of the opposite clamp rings. Loosely assemble nuts on the ends of the bolts.

Hand tighten the nuts and ensure the ductile iron spigot ring is centered on the pipe and is making full contact with the face of the gasket. Tighten the nuts evenly until the spigot gasket compresses against the joint and the leak stops. Tighten nuts to approximately 20 - 30 ft. lbs. of torque.

To ensure integrity of installation, wait 15 minutes, inspect for leaking, and confirm bolt torque. If necessary, retighten bolts evenly as required to stop the leak.

