

HDPE CORRUGATED PIPE

Joining Guidelines

Our corrugated structured wall polyethylene pipes incorporate an advanced spigot and socket elastomeric joint, designed to meet the performance requirements of AS/NZS 5065.

Please note: Pipes are factory seconds. Rubber rings and lubricant not included



SEVEN STAR

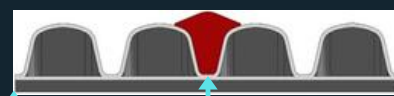
Step 1. >>>>

Insert seal into the correct valley/s as shown and are clean prior to joining.



Rubber ring

Sizes: DN225 to DN600, DN900



Spigot End

Ensure the rubber ring is installed correctly in the second valley

Sizes: DN225 to DN600, DN900



Spigot End

Ensure the rubber ring is installed correctly in the first and second valley

Step 2. >>>>

Once seals and jointing areas are clean, apply lubrication to the outside of the seal and inside socket area

Suggested approved Lubricant:
BK Bactericidal Pipe Lubricant

Insert spigot end of the pipe into the pipe socket:



Clean & lubricate surfaces with an approved lubricant (BK Bactericidal Pipe Lubricant recommended).

Clean & lubricate seal surface with an approved lubricant.



Spigot End

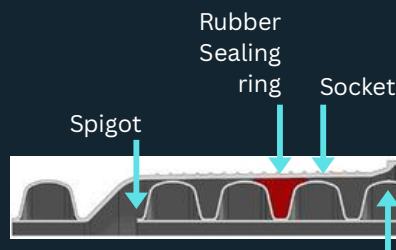
Step 3. >>>>

Ensure pipe spigot is aligned square to the socket during spigot insertion, whilst applying constant force.



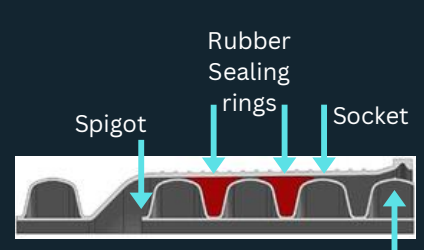
The witness mark is moulded on the pipe corrugation. The witness mark may sit slightly into the socket after installation.

Sizes: DN225 to DN600, DN900



Witness Mark.
Positioned on the 4th corrugation, except DN225 (on 5th)

Sizes: DN225 to DN600, DN900



Witness Mark.
Positioned on the 4th corrugation



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