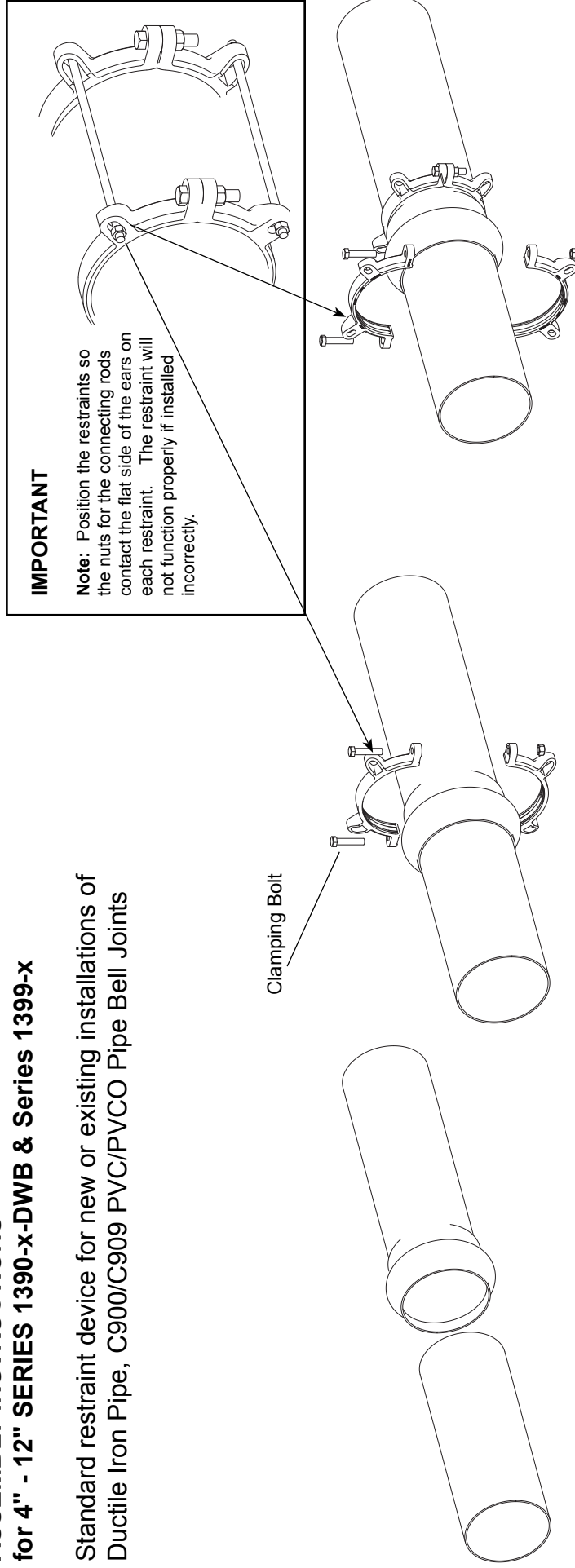


ASSEMBLY INSTRUCTIONS

for 4" - 12" SERIES 1390-x-DWB & Series 1399-x

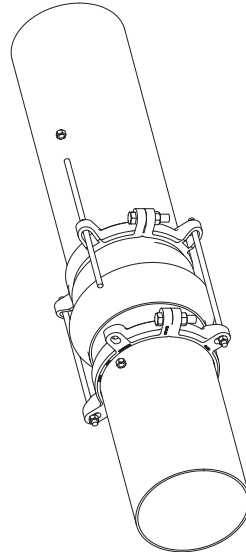
Standard restraint device for new or existing installations of Ductile Iron Pipe, C900/C909 PVC/PVCO Pipe Bell Joints



1. Assemble spigot pipe end to bell using standard procedure, following pipe manufacturer's recommendations.

2. Assemble 1/2 of the Series 1390-x-DWB / 1399-x serrated restraint directly behind the pipe bell. Evenly tighten the clamping bolts and nuts to the recommended torque for your pipe type as shown in Table 1.

3. Assemble the remaining serrated restraint onto the spigot end of the pipe using the connecting rods as a guide for position. Evenly tighten the clamping bolts to the recommended torque for your pipe type as shown in Table 1.



4. Insert connecting rods into the slots and snug connecting nuts hand tight. **Do not over-tighten the connecting nuts.**

Table 1

Recommended Clamping Bolt Torque		
	PVC/PVCO	DIP
4" and 6"	100 ft-lb	100 ft-lb
8" and 10"	150 ft-lb	150 ft-lb
12"	150 ft-lb	200 ft-lb



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