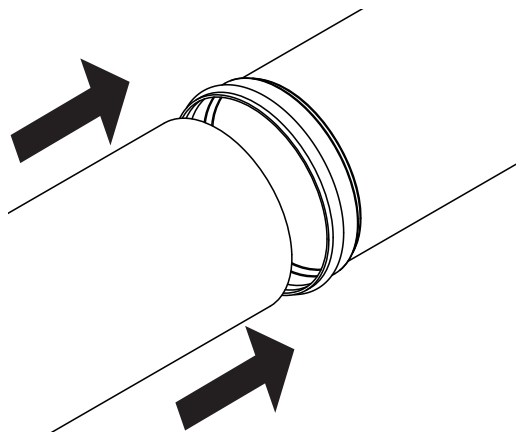
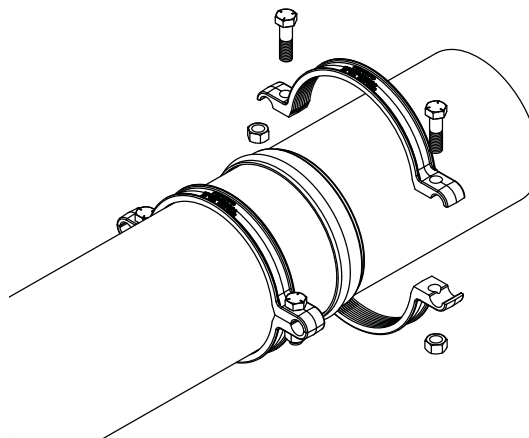


ASSEMBLY INSTRUCTIONS FOR 4" - 12" SERIES 1390-P

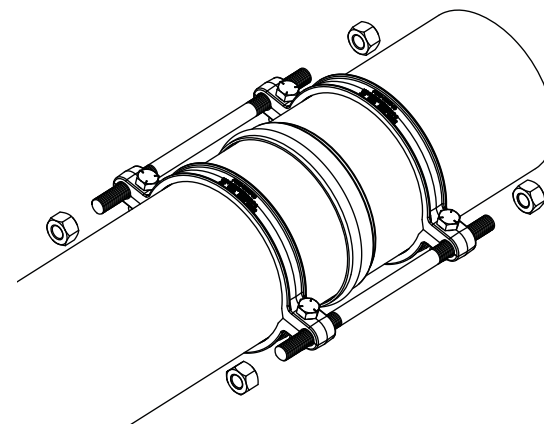
Standard restraint practice for bell and spigot joints of PVC
Pipe per ASTM D3034. (New or existing installations)



1. Assemble spigot pipe end to bell using standard procedure.



2. Assemble Series 1390-P clamping rings onto spigot pipe and just behind bell end as shown (use restraining rods as a guide to position and align restrainers) and tighten bolts and nuts evenly to the minimum recommended torque of 100 ft-lbs. A torque wrench is required to ensure proper torque.



3. Insert all provided connecting rods and nuts as shown and tighten nuts behind restrainers. **Do not over-tighten retaining nuts. SEE NOTES BELOW**

Notes:

Use all rods/T-Bolts provided for best results. The safety factor is derated on joints that do not use all of the 1300 T-Bolts/rods provided. Reduction in water pressure will increase the safety factor.