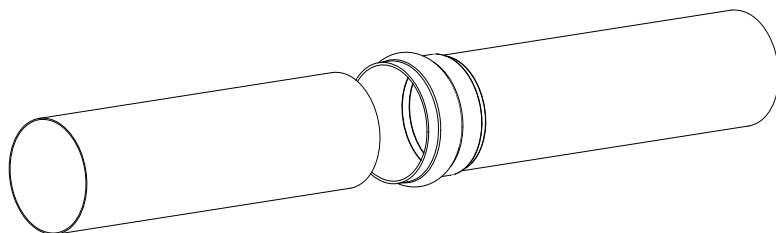


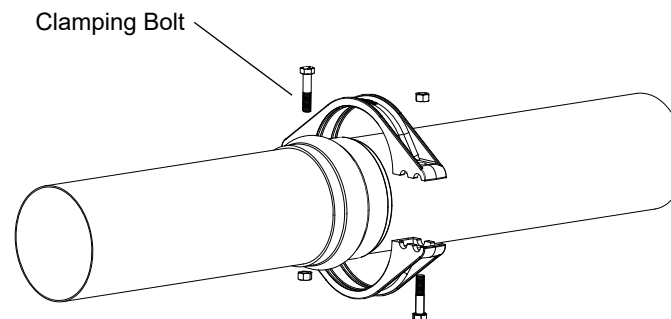
ASSEMBLY INSTRUCTIONS FOR 4" - 12" SERIES 1399-x

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

Refer to the Ford® website (www.fordmeterbox.com) for additional and most recent instructions and product information.



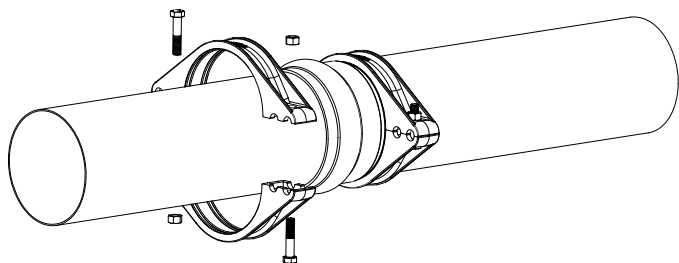
1. Assemble spigot pipe end to bell using standard procedure, following pipe manufacturer's recommendations.



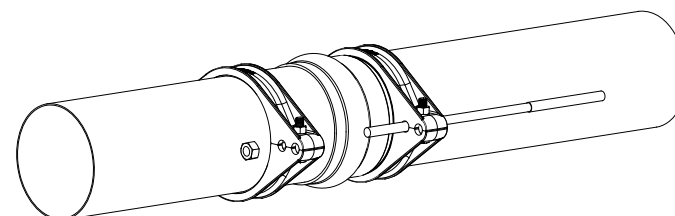
2. Assemble ½ of the Series 1399-x serrated restraint directly behind the pipe bell. Evenly tighten the clamping bolts and nuts to the recommended torque as shown in Table 1. The use of a torque wrench is highly recommended and required to ensure proper torque.

Table 1

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



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 as shown in Table 1. The use of a torque wrench is highly recommended and required to ensure proper torque.



4. Insert connecting rods into the slots and snug connecting nuts 1/2 revolution beyond hand tight. (For 10" & 12" use the outer two slots.) **Do not over-tighten the connecting nuts.**
Note: The clamps can be assembled around the rods to make restraint-to-restraint alignment easier. Use additional nuts (not included) on inside of retainer bolt holes if the pipe joint is suspected to contract.



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APPROVED
C900 4"-12"
C909 4"-8"