

# BOLT-LOK™ Flexible Restrained Joint Assembly Instructions

1. Inspect the bell gasket area on the pipe or fitting. Remove any foreign matter such as mud, gravel, sand, ice, etc. The gasket seating area should be thoroughly inspected to ensure that nothing will interfere with proper seating of the gasket. A wire brush or clean towel should be used to clean the gasket area. Inspect and clean the spigot end in a similar manner.



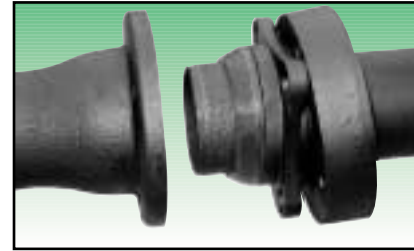
2. Using Griffin pipe joint lubricant, apply a film of the lubricant to the gasket seating area of the bell. Do not assemble the joint without lubrication! The lube allows the MJ gasket to flow into its proper position when compressed by the gland assembly.



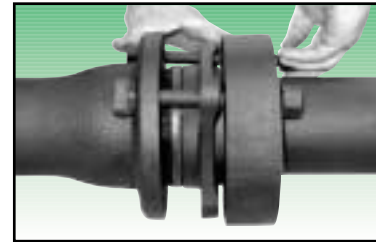
3. Place the MJ gasket over the spigot end of the pipe. Slide the gasket back against the MJ gland. The narrow end of the gasket should face the spigot end of the pipe. Apply joint lubricant to the gasket surface. Do not assemble the joint without lubrication!



4. Align the bell and spigot for assembly. The ends of the pipes should be in reasonably straight alignment during assembly. Deflections can be made after assembly. Make sure there is no dirt stuck to the lubricant in the bell or on the spigot. Insert the spigot end completely into the bell socket.

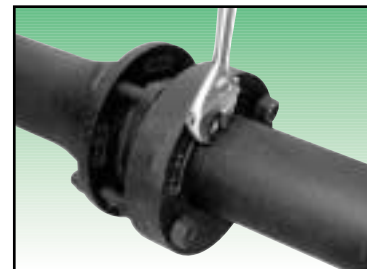


5. Insert the T-head bolts supplied with the assembly. Install the nuts and finger tighten.



6. After the bolts are in place, remove the two T-head bolts holding the MJ gland and **BOLT-LOK** ring together. Discard the spacers which are used only for shipping. Reinsert the two bolts from the opposite direction and install the nuts.

Tighten all of the bolts to 120-150 lbs of torque. Alternate the tightening sequence to maintain the same distance between the gland and the face of the bell flange until the proper torque range is obtained.



The **BOLT-LOK** joint requires longer than standard length bolts. In most cases these longer bolts can be inserted into a fitting flange in the usual manner. In some fitting configurations, one or more of the bolt holes of a given joint will not accept the long T-head bolts as shown in the sketch (right). For these fittings, a hex-head bolt and special hex nut is positioned behind the flange of the fitting. The appropriate number of hex bolts and special nuts are shipped with each **BOLT-LOK** spigot. Two hex head long bolts with special nuts are shipped with each 6", 8", 14" and 20" **BOLT-LOK** spigot. Four each are shipped with 10", 12", 16", 18", and 24" spigots.

