

# SNAP-LOK™ Flexible Restrained Joint Assembly Instructions

1. Visually inspect the socket area for cleanliness. Remove any foreign matter such as mud, gravel, sand, ice, etc. The gasket seating area should be thoroughly inspected to ensure nothing will interfere with the proper seating of the gasket. Do not lubricate the inside of the bell!



2. The gasket must be wiped clean with a clean cloth. Place the gasket into the socket with the rounded bulb-end entering first. Looping the gasket before the initial insertion will facilitate seating the gasket evenly around the retainer seat. Smaller sizes will require one loop while a larger gasket may require 2 loops. In cold weather (below 40°), the gaskets should be warmed for easier insertion.



3. Apply a thin film of pipe joint lubricant to the surface of the gasket that will contact the spigot end (plain end) of the pipe.



4. Remove any packing material from the pipe spigot. Clean dirt or debris from the outside of the large restraining ring. Clean the spigot end of the pipe and grind or file any sharp edges that may damage the gasket. Apply lubricant to the outside of the spigot end.



5. Place the spigot end into the companion bell socket. Maintain reasonably straight alignment. Push the pipe straight home with the aid of a pushbar or backhoe as necessary. If assembly is not achieved using reasonable force, dismantle the pipe and check for proper positioning of the gasket, adequate lubrication or debris in the joint.



6. Slide the large **SNAP-LOK** restraining ring(s) fully into the bell socket. With proper insertion, the full depth of the locking ring groove should be visible. This is the groove closest to the face of the bell end.

6" - 24" pipe sizes have one-piece **SNAP-LOK** rings which are pre-installed on the pipe. 30" - 48" pipes have segmented rings that are supplied separately with each shipment. 30" - 36" pipe have 4 segments per joint. 42" - 48" pipe have 5 segments per joint.



7. Insert the alloy steel locking ring into the groove. The ring may be forced into the groove if necessary. Once the ring is completely within the groove, the small wire-tie should be cut and removed. This will allow the locking ring to expand into place within the groove. This completes the **SNAP-LOK** assembly.

