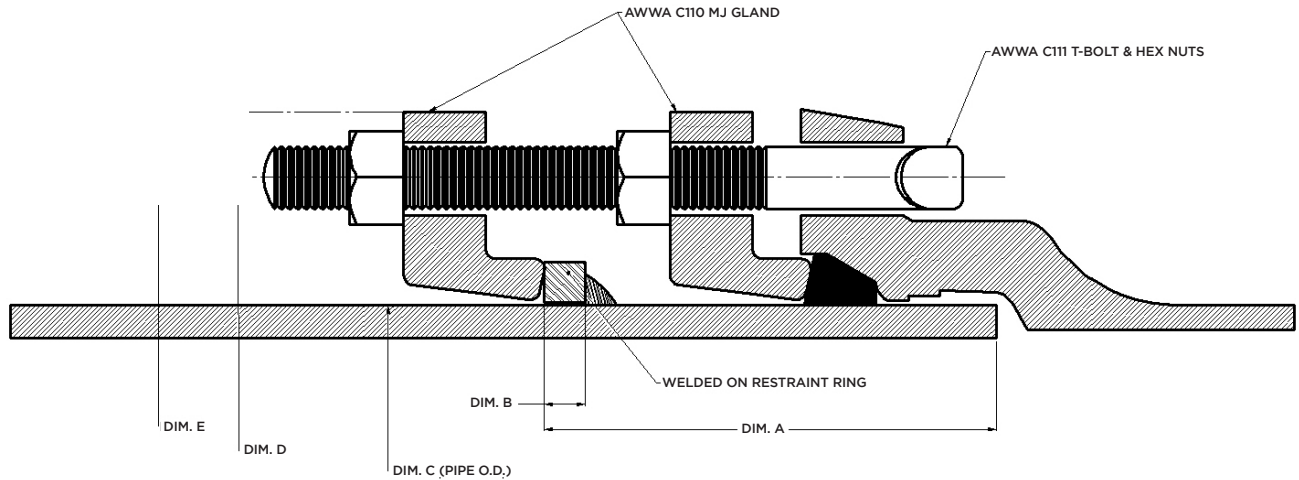




IRON STRONG

# DUCTILE IRON PIPE MECHANICAL JOINT LOCK JOINT 6"-30"



## ASSEMBLY INSTRUCTIONS

**STEP 1A.** Gather all necessary PPE, tools, and materials such as a wire brush, paint brush, pipe lube, and wrench.



STEP 1A

**STEP 1B.** Clean the bell socket and spigot end. Be sure to remove any dirt, ice, or foreign matter from the inside of the bell.



STEP 1B

**STEP 2A.** Place the gland on the plain end with the lip extension toward the plain end.



STEP 2A

**STEP 2B.** Lubricate both the gasket and plain end by brushing on approved pipe lubricant. Place the gasket on the plain end with the narrow edge facing the plain end.



STEP 2B

*Continued on next page...*

# ASSEMBLY INSTRUCTIONS CONTINUED...

**STEP 3A.** Insert the plain end of the pipe into the MJ bell until it rests against the back of the bell.



STEP 3A

**STEP 3B.** Press the gasket into the bell recess. Push the gland toward the socket and center it around the pipe with the gland lip against the gasket.



STEP 3B

**STEP 4A.** Slide the second gland away from the spigot end to allow enough room for the joint assembly with the first gland.



STEP 4A

**STEP 4B.** Insert T-head bolt and (1) nut in the first gland.



STEP 4B

**STEP 5A.** Snug the bolts by hand. It is important to maintain the same distance between the gland and the bell face at all times for a proper seal.



STEP 5A

**STEP 5B.** Tighten bolts using a torque wrench. Alternate side to side and top to bottom to achieve equal distance and torque.

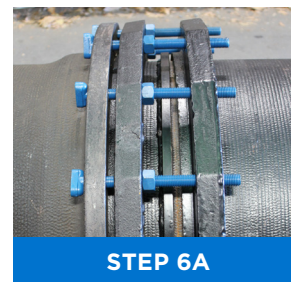


STEP 5B

**NOTE:** Achieving the recommended bolt torque, particularly with large diameter pipe, may require repeating Step 5B up to five times or more. Recommended bolt torque ranges are as follows:

Pipe Size in.	Bolt Diameter	Nut Across Flats in.	Torque Range Foot lbs.
6 – 24	3/4	1-1/4	75 to 90
30	1	1-5/8	100 to 120

**STEP 6A.** Slide second gland onto the bolts and attach the second set of nuts.



STEP 6A

**NOTE:** If deflection is needed, apply deflection at this point before tightening the outer hex nuts.



STEP 6B

**STEP 6B.** These will be tightened to 20 foot pounds of torque.



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Rev. June 2022