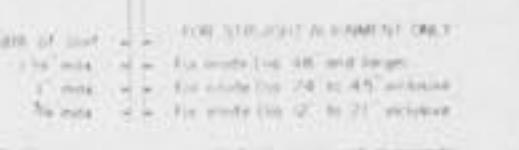
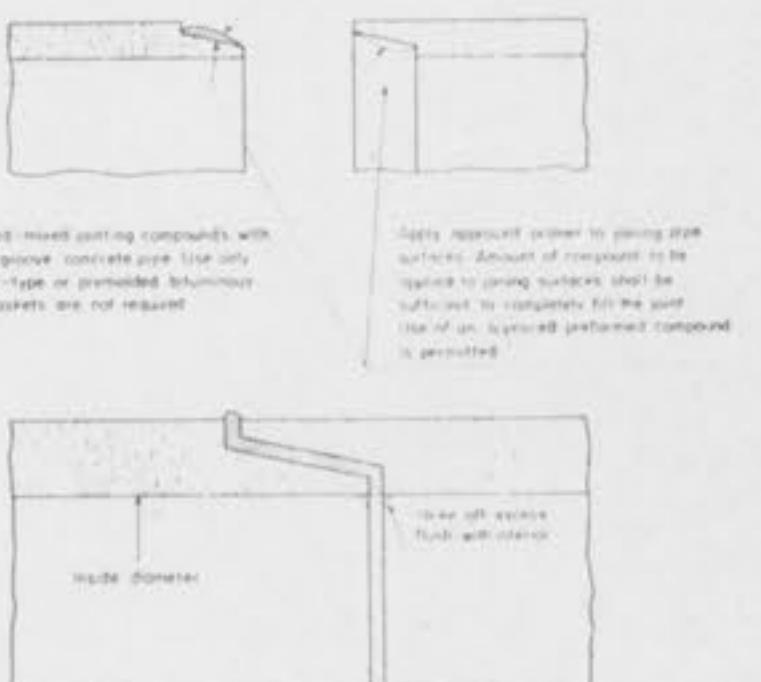
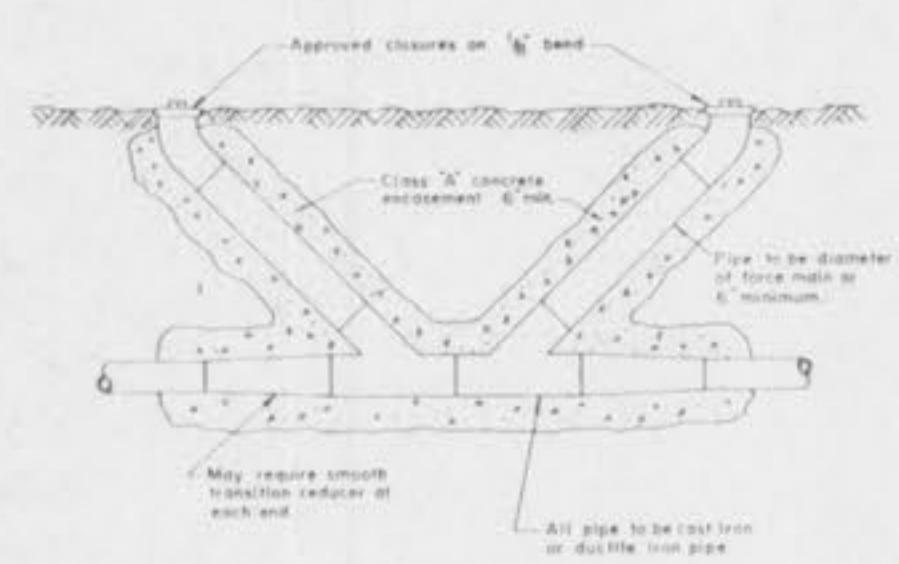


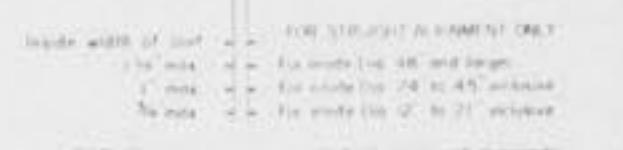
After backfilling, after digging and backfilling of
soil into a bottom surface which will hold compacted
without sagging and not move more than 5 hours after
grout has been applied.



After applying grout to piping surfaces. Amount of compound to be applied to piping surfaces shall be determined by the user. Use of an approved preferred compound is permitted.

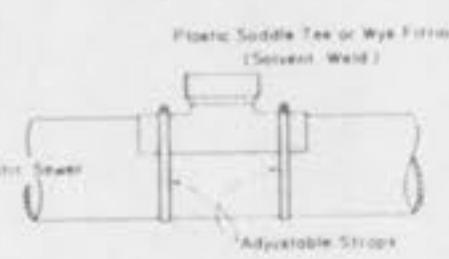


700' MAXIMUM SPACING
FORCE MAIN CLEANOUT



Inside width of joint = 100% of required joint width.
The min. = 100% of required joint width.
The max. = 100% to 45% increased.
The min. = 100% to 45% decreased.
The max. = 100% to 25% increased.

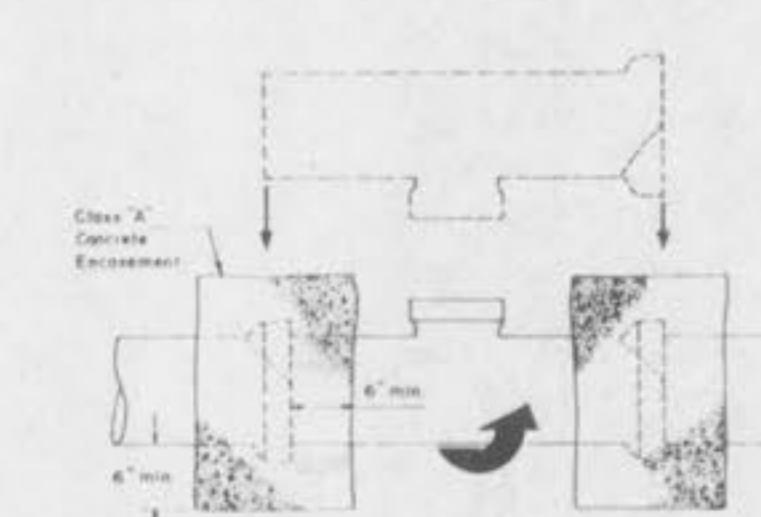
50% Maximum increase permitted only on force main segments.



When a connection to a plastic pipe is allowed and the connection is larger than 6" in diameter, a saddle saddle or tee fitting of a heavier material must be used. Example: 6" x 6".
This is accomplished by carefully cutting a hole with a saw in the side of the required connection, prior to cutting and welding the saddle. The saddle, when welded, must be welded to the side of the connection.

1. Clean and dry pipe joints, saddle and connection to be welded.
2. Apply flux. Apply a heavy, thin, uniform coat of flux to the inside surface of the saddle and to the outside surface of the pipe to be welded.
3. When welding, wear the welding arc shield. Weld slowly and heat the joint slowly. Avoid overheating the saddle by being careful not to let the heat from the torch fall directly upon the saddle.
4. Letting a gas-torch flame burn out on any connection causes damage to pipe and saddle.
5. Allow 30 - 60 minutes for setting time and an additional 100% time depends on size and fit of materials being connected and welding conditions.
6. Heat and cut the saddle if it becomes welded to the pipe.
7. Knock off the welded material as required around the connection. Clean before re-welding. The bedding material shall be used. The 6" D.O.
8. M.S.D. No. 1 Bedding
9. 1/2" S cement and sand mix
10. PRE-MIX concrete

**6"(B LARGER) CONNECTION
TO PLASTIC MAIN**



**CONNECTIONS TO
LARGE SEWERS**