

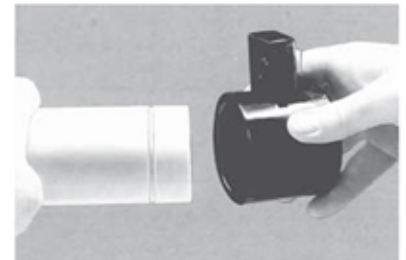
## Installation Procedures

### Points to Remember

- a. NEW BLUE ELASTOLIVE DOES NOT REQUIRE PRE-HEATING.  
(If heated, maximum temperature should not exceed 175°F.)
- b. The pipe end should be clean and there should be no deep longitudinal grooves in it.
- c. It is desirable to use a chain vise to hold 3" and 4" pipe firmly during cutting and grooving operations. When grooving 3" and 4" pipe, a strap wrench should be used to hold the pipe, to prevent its rotation, while the groove is being cut.
- d. After grooving, the pipe should be kept clean so that foreign material is not introduced into the groove.
- e. The cutting blade should always be fully retracted whenever the tool is put on or taken off the pipe. If any resistance is felt when putting the tool onto the pipe or taking it off, the blade position should be checked.
- f. Each nut must be fully tightened as the installation progresses. Do not assemble the system loosely and tighten nuts last, as layout length errors will go undiscovered until such time as the nuts are finally tightened. Avoid misalignment.
- g. Ensure the grooving tool has a sharp blade to make a clean-shouldered groove.

### Procedure:

1. Each fitting is supplied with the correct number of blue elastolive® (sealing rings) and nuts.
2. Verify the grooving tool is sharp. Cut the pipe to the desired length using a tubing cutter fitted with a wheel designed for plastic pipe. A handsaw and miter box may also be used. Ensure pipe ends are square and trimmed free of burrs.



### GROOVING TOOL BLADE POSITIONING

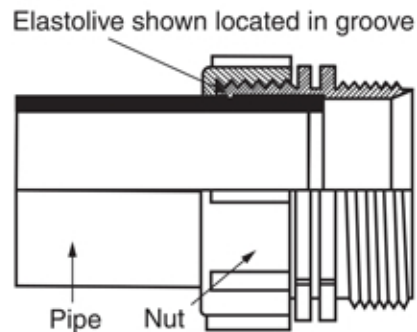


3. Examine the grooving tool to ensure that the cutting blade is fully retracted. Insert the pipe into the grooving tool.
4. Set the grooving blade at the half-depth position and rotate the tool in a counter-clockwise direction. After one complete turn, set the blade at the full-depth position and again rotate the tool one full turn counter-clockwise. Fully retract the blade and remove the tool from the pipe. A shallow groove has now been formed around the pipe.

Any material left as a feather edge in the groove should be removed. Care should be taken not to damage the square edge (shoulder) of the groove, particularly at the edge near the spigot end of the pipe as this is the primary sealing surface.

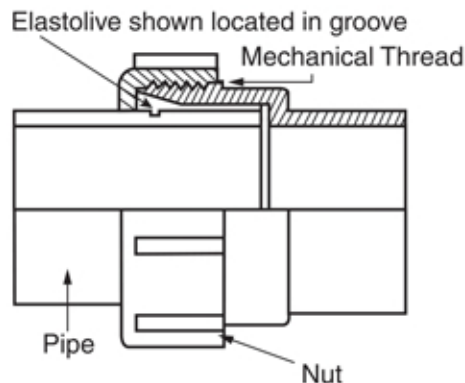
Feathered or rounded edges may indicate a worn tool and may result in possible leakage. Make sure the groove shoulders are sharp.

### 1 1/2" & 2" Labline Joint Details



Once engaged in the groove, the elastolive virtually becomes part of the pipe and when the nut is tightened, the pipe is locked into the fitting.

### 3" & 4" Labline Joint Details



The 3" and 4" joint design differ from smaller versions in that the sealing ridges are located on the fitting and the elastolive extends to the end of the pipe.

5. Place the nut onto the pipe with the threaded side to the spigot end of the pipe. Take the blue elastolive, stretch it and pull it over the pipe with the thick edge first and the taper pointing to the spigot end of the pipe. Slide down the pipe and onto the groove. Once on the groove "work it" a bit to make sure that the rib on the underside of the elastolive engages the full circumference of the groove.

## Installation Procedures

6. Apply a non-hydrocarbon based lubricant to both the thread and the elastolive, then push the pipe squarely into the fitting. The lubrication permits easy threading of the nuts and also allows the elastolive to glide smoothly into position against the fitting sealing area.

Hand-tighten the nut, then tighten, 1/4 to 1/2 turn using a spanner wrench.

7. The joint is now ready for testing.

