Jointing Procedure - Mechanical Joint

1) Joint Preparation

a. Care must be taken to ensure that after cutting the pipe end is not oval.

b. All spigot ends must be chamfered prior to assembly.

c. Clean both the spigot end of the pipe and the inside of the socket prior to assembly.

Size NB mm	No. of Bolts Per Socket
80	3
100	3
125	4
150	4
200	5
250	6
300	7
400	9

Number of bolts per joint by nominal bore

2) Joining

- Push the gland over the spigot and position approximately 300mm from the end of the spigot.
- Fit the gasket over the spigot approximately 150mm from the end of the spigot.
- Support the pipe just clear of the bottom of the trench.
- Insert the spigot into the socket of the fitting.
- Press the gasket into its seating in the socket.
- Ensure the gasket is centralized.
- Tap the gasket taking care not damage any coatings.
- Lubricate the visible face of the gasket.
- Slip the gland ring up against the gasket face.
- Rotate to locate the bolts into the lugs.
- Lubricate threads of the bolts and hand tighten nuts.
- progressively tighten nuts in the recommended sequence, to the recommended torque.
- The recommended bolt torque is 150Nm (110lb ft)

This figure shows a pipe being joined to a Rotating Flange & MJ Socket piece.