

INSTALLATION GUIDE

WaterStop™ Gasket

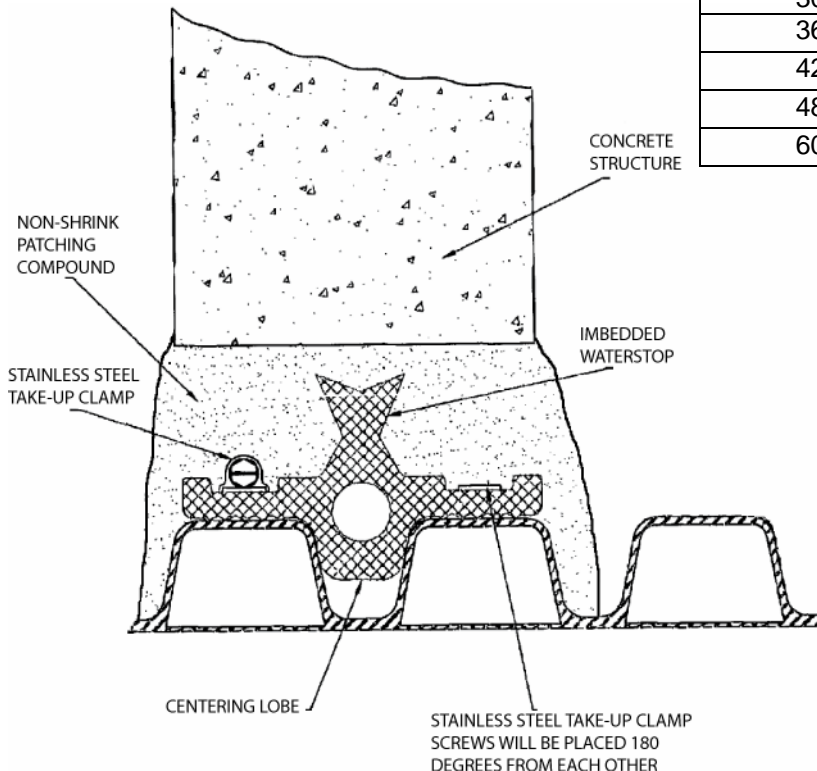
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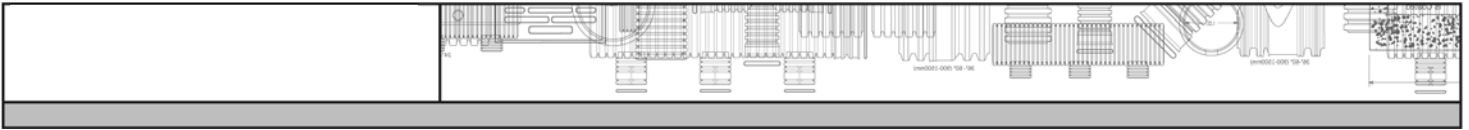
The WaterStop Gasket is intended to provide a cost-effective, watertight seal between HDPE pipe and concrete structures. It is currently available for pipe diameters of 12" through 60".

The WaterStop Gasket is a convenient field-installed seal that prevents water infiltration and exfiltration at manhole connections. It meets the performance requirements of ASTM C923 (Standard Specification for Resilient Connectors Between Reinforced Concrete Manhole Structures, Pipes and Laterals). The WaterStop Gasket, when grouted, becomes a monolithic part of the manhole.

When ordering concrete structures, use the table below to select the minimum hole diameter needed to accommodate the WaterStop Gasket.

HDPE Pipe Diameter (in)	Recommended Minimum Hole Diameter (in)	Min. Distance, Pipe Invert to Structure Invert (in)
12	19.50	3.7
15	23.00	4.0
18	26.50	4.2
24	33.25	4.5
30	40.50	5.2
36	47.00	5.5
42	53.00	5.75
48	59.00	5.75
60	72.00	6.4





Instructions For Installing WaterStop Gasket to HDPE Pipe

1. Thoroughly clean 2 feet of pipe section at the insertion end of the pipe.
2. Position the WaterStop Gasket so the center lobe is in the valley of the corrugation.
3. Place the stainless steel take-up clamps in the grooves on each side of the center lobe. Insure that both clamps lie on the crest of the pipe corrugations.
4. Position the take-up clamp screws 180° from each other. Using a torque ratchet or torque wrench, gradually tighten both screws of each clamp to 60lbs./inch torque. Do not overtighten. A screwdriver will not tighten clamps adequately.
5. Apply a good quality concrete bonding agent to the structure opening.
6. Insert pipe into the structure opening. Make sure that the WaterStop is fully within the plane of the structure's wall.

If mortaring in place, apply and compact non-shrink grout around the WaterStop and between the pipe and the opening, taking care to fill the voids. Make sure that the WaterStop Gasket does not contact the bare structure walls.

If pouring in place, use concrete of sufficient slump to permit complete flow around the pipe and WaterStop. Thoroughly vibrate all around the pipe and WaterStop Gasket to complete compaction and to release any trapped air.

7. Allow concrete or mortar to fully cure before testing or backfilling. If the system is to be tested, testing should be completed prior to backfilling around the structure, following all recommendations and requirements of the test system manufacturer. Plug any vent holes in the HDPE pipe prior to testing.
8. Backfill the HDPE pipe following the manufacturers recommendations.

