

NPC Internal Joint Seal

Installation Instructions

Tools Needed to Install the NPC Internal Joint Seal

The NPC Internal Joint Seal is easily installed using a minimum of special tools. We recommend having the following tools available.

1. Wire Bristle Brush
2. Chipping Hammer
3. 3/8" Allen Head Socket in either 3/8" or 1/2" drive.
4. Torque Wrench capable of measuring 45 – 75 Foot Pound
5. Pop Rivet Gun & Pop Rivets (supplied with Joint Seal Assembly where bands require more than one WedgeLock assembly)

Components Included with the NPC Internal Joint Seal Assembly

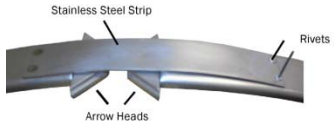
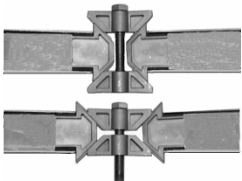

The NPC Internal Joint Seal Assembly comes unassembled with the components listed below.

1. Rubber Seal
2. Expansion Bands
3. WedgeLock Assemblies

Pop Rivet Gun, Rivets and Safety Caps also included in each shipment where bands require more than one WedgeLock assembly



Assembling the Internal Seal

1. Each Expansion Band section has a stainless steel strip at one end which allows the band sections to be riveted together. Position the arrow heads as shown and fasten with rivets.
 
2. After all sections of the Expansion Band have been riveted together insert the WedgeLock Assemblies. Tighten enough to keep them in place.
 
3. Repeat steps 1 & 2 for the other Expansion Band.
4. Place the assembled Expansion Bands into the Seal as shown. The Expansion Bands should be seated in the band track on either side of the Seal. Position the WedgeLocks in the areas cut out for them in the tracks. Make sure the bolt heads on the WedgeLocks face the outside of the seal.
 
5. Apply a drop of lubricant (pipe lube, liquid soap) between the Expansion Bands and rubber seal halfway between each of the WedgeLocks. This will allow the bands to slide freely against the Seal as they expand.

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Recommended Torque Values

Minimum: 45 Foot Pounds
Maximum: 75 Foot Pounds

Installing the NPC Internal Seal

1. Prior to putting the Seal in place, mark the pipe on either side of the joint. If you are using a 10.5" Seal mark the pipe 5.25" from the joint, for a 7.5" Seal mark the pipe 3.75" from the joint. Doing this in a few places around the inside of the pipe will make it easier to position the Seal over the center of the joint.
2. Move the Seal into place over the center of the joint.
3. Alternate tightening each of the WedgeLocks to begin expanding the bands inside the Seal. You will feel the rivets break as you tighten the WedgeLocks (the rivets are only used to aid in assembly and are no longer necessary). Continue alternately tightening each of the WedgeLocks until you have reached the recommended torque value shown above. It is important to check the torque after 30 minutes and tighten if necessary.
4. When using the 10.5" wide seal we recommend using a third Centerband Assembly for applications where ground water head pressure is greater than 5 ft.