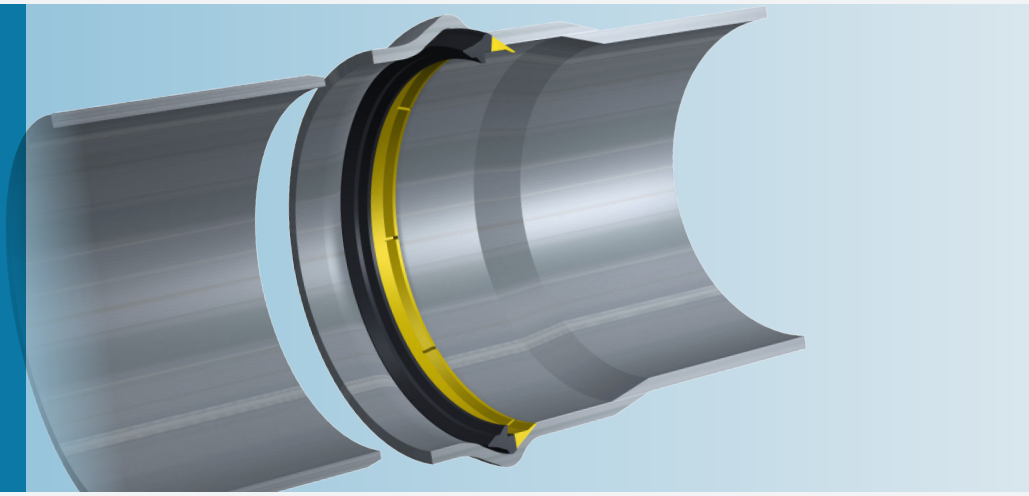
Forsheda 601 Power-Lock™

Integrated sealing system for plastic pressure pipes



SEAL DESIGN AND FUNCTION

The Forsheda 601 Power-Lock™ integrated system uses the mandrel together with the seal as a tool to form the pipe socket during the manufacturing process. The Power-Lock™ is a composite seal consisting of:

A flexible rubber element to seal effectively against spigot and socket

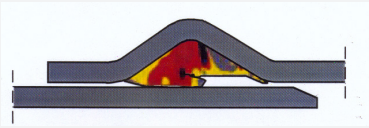
A polypropylene reinforcement element, bonded to the rubber, which holds the seal firmly in place

The seal becomes part of the socket forming tool used to shape its own seal groove reducing irregularities and tolerances in the socket.

The seal is equally effective under both positive and negative pipe pressure (vacuum). Under positive pressure the higher the pressure the greater the sealing force.

Under vacuum the seal maintains a positive sealing force against spigot and socket to prevent sand or soil entering the joint.

SEAL PERFORMANCE



F-601 Power-Lock™ seal meets or exceeds current European and ISO standards for pressure, vacuum, deflection and shear load. The seal design gives low assembly forces making pipe jointing easier. Improved productivity and lower scrap during belling process for the pipe producer when compare to traditional integrated seals.

Power-Lock™ tolerates ovality effects caused by transportation or storage of the pipe better than other integrated seals. Eliminates the risk of corrosion by removing metal inserts. Test reports are available from Trelleborg Pipe Seals on request.

MATERIAL

Synthetic EPDM rubber

Hardness 50 ± IRDH

Approved in accordance with EN 681-1

Ozone resistant

Approved for contact with cold potable water

QUALITY ASSURANCE

CE-marking

BSI (Kitemark)

KIWA/Swedcert

Watermark

STANDARDS

EN 681-1 WC, WA

AS 1646

BS 6920 (WRAS)

AFNOR XP P 41-250 (ACS)

AS/NZS 4020

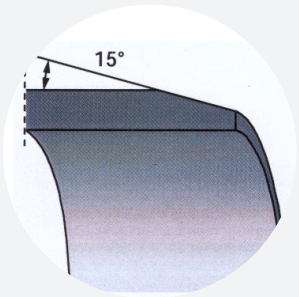
JOINT ASSEMBLY

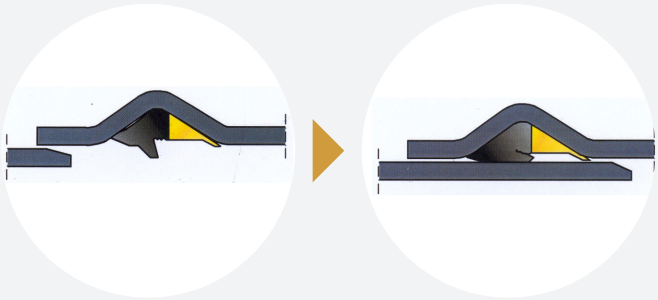
Chamfer the spigot end

Clean the socket

Apply lubricant on the spigot before assembly

Slide the spigot into the socket, thus compressing the sealing lip



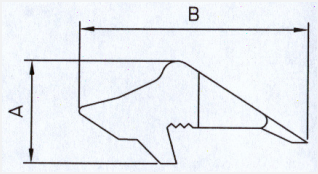


Pipes with F-601 shall always be laid in accordance with applicable standards and regulations.

Please contact Trelleborg Pipe Seals for technical advice and joint design recommendations to meet your performance requirements.

SEAL MARKING AND BOX LABELS

Each seal is marked with seal dimension and period of manufacture. The box is labelled with corresponding data.



EXAMPLES OF SIZES (MM)

PIPE SIZE	A	B
50	8.0	17.2
63	8.0	17.3
75	9.0	20.0
90	11.0	24.3
100-S2	14.0	32.3
110	12.0	26.6
125	14.0	32.3
140	14.0	32.0
150-S2	16.0	35.9
160	15.0	33.5
200	16.0	35.9
200-S2	17.0	37.1
225	17.0	37.1
250	19.0	42.9
250-S2	20.0	43.6
280	20.0	43.6
315	21.0	45.8
355	23.0	50.2
400	25.0	54.5
450	23.5	58.2
500	30.0	65.4
630	37.0	83.9
710	41.0	92.3

Examples of authori-

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