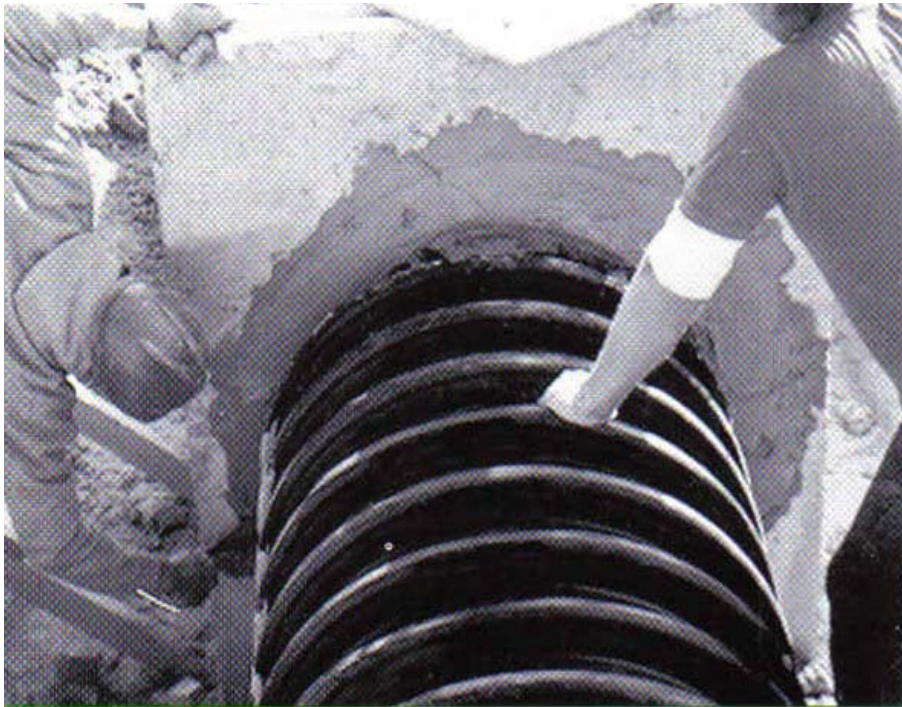




HDPE WATERSTOP - Installation Guide

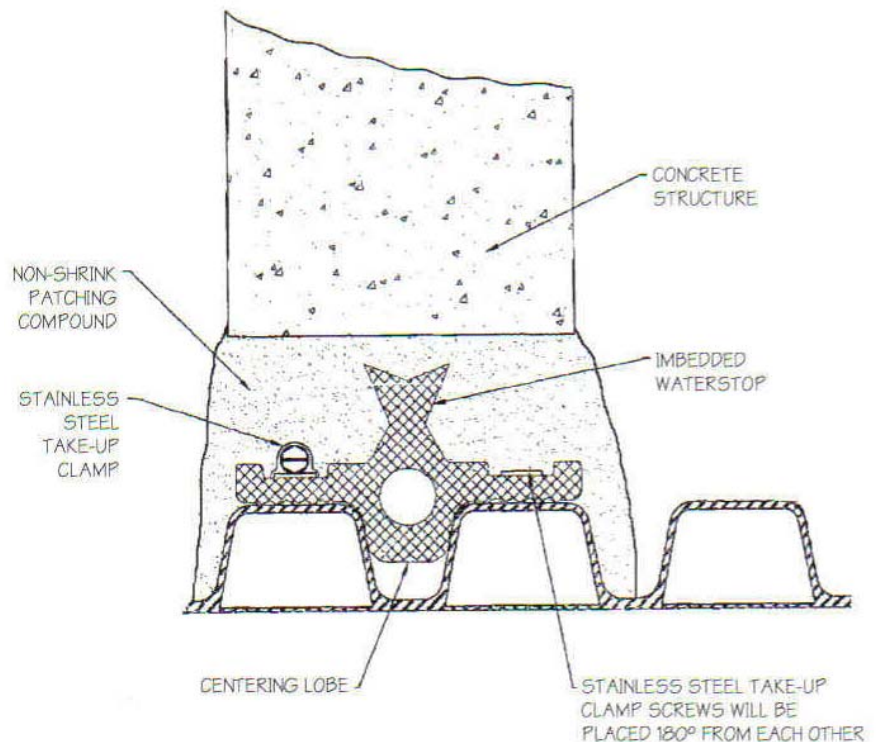
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The Press-Seal HDPE Waterstop Gasket is a convenient field-installed seal that prevents water infiltration and exfiltration at manhole connections. It meets the material requirements of ASTM C 923, ASTM C 1478, and ASTM F 2510 for pipe-to-structure connections. It also meets the connector requirements of ASTM D 2321 for installation of thermoplastic pipe. The HDPE Waterstop, when grouted, becomes a monolithic part of the manhole.

When ordering concrete structures, use the table below to select the minimum hole diameter needed. The HDPE Waterstop Gasket is available to fit almost any corrugated HDPE pipe. Call Press-Seal Customer Service for complete information.

HDPE Pipe Diameter (Inches)	Recommended Minimum Hole Diameter (Inches)	Min. Distance, Pipe Invert to Structure Invert (Inches)
12	19.50	3.7
15	23.00	4.0
18	26.50	4.2
24	33.25	4.5
30	40.50	4.2
36	47.00	5.5
42	53.00	5.75
48	59.00	5.75
54	65.00	6.1
60	72.00	6.4



PRESS-SEAL GASKET CORPORATION

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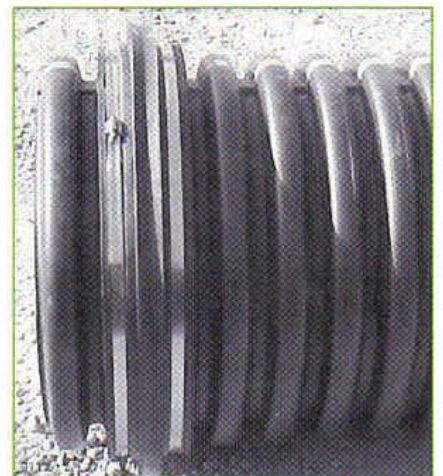
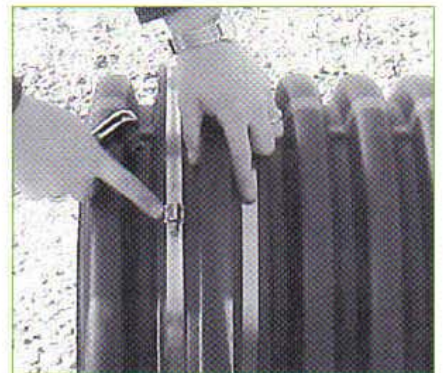
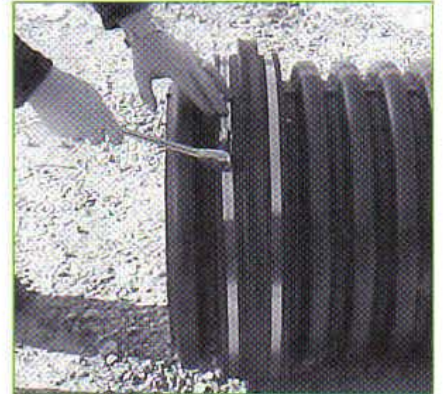


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1. Thoroughly clean 2 feet of pipe section at the insertion end of the pipe.
2. Position the Waterstop Gasket so the center lobe is in the valley of the corrugation.
3. Place the stainless steel take-up clamps in the grooves on each side of the center lobe. Insure that both clamps lie on the crest of the pipe corrugations.
4. Position the take-up clamp screws 180 degrees from each other. Using a torque ratchet or torque wrench, gradually tighten both screws of each clamp to 60 in/lbs 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 wall.
7. If mortaring in place, apply and compact non-shrink grout around the Waterstop between the pipe and the opening, taking care to fill all 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.

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 of the test system manufacturer. Plug any vent holes in the HDPE pipe prior to testing.

Backfill the HDPE pipe and structure following the pipe manufacturer's recommended practices.



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