

CAST-A-SEAL 964

PIPE TO MANHOLE & TANK CONNECTOR



What It Is

The Cast-A-Seal 964 is a simple cast-in pipe-to-manhole connector for pipe O.D. 4.21" - 6.9" (107 - 175MM) that offers a watertight flexible connector that is cast into the structure when the concrete is poured.

The key lock is integrally cast-in during the production process providing a secure seal for storm water and sanitary collection systems.

How It Works

- The connector is folded into the casting position.
- It is placed on the reusable mandrel and then placed on the form.
- After curing, the mandrel is removed.
- The connector is then simply unfolded at the jobsite.
- Take-up clamps made from series 304 stainless steel with quick adjusting screws secure the connector to the pipe.

Where To Use

- Manholes (48" & 60")
- Wet wells
- Square pump and lift stations
- Stormwater structures
- On-site treatment structures
- Junction chambers
- Grease interceptors



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Why It's Better

- Two step design fits a variety of pipe OD's.
- Straight wall or manhole casting mandrels.
- Available in either open or closed end face.
- Adapts easily to pipe size changes or if the connector gets damaged.
- Contractor can save time and money by backfilling immediately.

CAUTION: GREASE INTERCEPTORS THAT COULD CONTAIN PETROLEUM OILS SHOULD USE OUR NITRILE PSX: DIRECT DRIVE 8QRS 4" PIPES AND 12Y FOR 6"

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SUBMITTAL SPECIFICATIONS

A flexible pipe-to-manhole connector shall be employed in the connection of the sanitary and storm drain sewer pipe to precast manholes or other structures. The connector shall be Cast-A-Seal® 964 as manufactured by Press-Seal Corporation, Fort Wayne, Indiana, or approved equal. The connector shall be the sole element relied on to assure a flexible, watertight seal of the pipe to manhole. The connector shall consist of a rubber gasket and one or two external take-up clamp(s).

The rubber gasket element shall be constructed solely of synthetic or natural rubber, and shall meet or exceed the requirements of ASTM C 923. The connector casting mandrel system shall include a precisely-formed opening in the concrete for installation of a replacement connector in the event that the cast-in connector is damaged.

The external take-up clamp shall be constructed of Series 300 non-magnetic stainless

steel and shall utilize no welds in its construction. The clamp shall be installed by torquing the adjusting screw using a torque-setting wrench available from the connector manufacturer.

Selection of the proper size connector for the structure and pipe requirement, and installation thereof, shall be in strict conformance with the recommendations of the connector manufacturer. Any dead end pipe stubs installed in connectors shall be restrained from movement per ASTM C 923.

The finished connection shall provide sealing to 13 psi (minimum) and shall accommodate deflection of the pipe to 7 degrees (minimum) without loss of seal.

Vacuum testing shall be conducted in strict conformance with ASTM C 1244 prior to backfill. Other testing shall be conducted in strict conformance with the requirements of the connector manufacturer.

Product Performance

Cast-A-Seal 964 meets and/or exceeds all requirements of ASTM C 923, including physical properties of materials and performance testing, including:

- 13 PSI minimum in straight alignment
- 10 PSI at minimum 7° angle
- 10 PSI minimum under ultimate shear load of 150 lbs/in. pipe diameter

Cast-A-Seal 964 meets the requirements of the following Standards, Specifications, Codes, and Test Methods:

- ASTM C 923 Standard Specification for Resilient Connectors Between Reinforced Concrete Manhole Structures, Pipes, and Laterals
- ASTM C 1644 Standard Specification for Resilient Connectors Between Reinforced Concrete On-Site Wastewater Tanks and Pipes
- ASTM C 1478 Standard Specification for Storm Drain Resilient Connectors Between Reinforced Concrete Storm Sewer Structures, Pipes, and Laterals
- ASTM C 1244 Standard Test Method for Concrete Sewer Manholes by the Negative Air Pressure (Vacuum) Test
- ASTM F 2510 Standard Specification for Resilient Connectors Between Reinforced Concrete Manhole Structures and Corrugated



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APPLICATION GUIDE

PIPE O.D. 4.21" - 6.9" (107 - 175MM)

PIPE DESCRIPTION	PIPE O.D. Inch/mm	CAS 964 Step
4" 100 mm PVC D3033 OR D3034	4.21" 107 mm	4" Outer
4" 100 mm TRUSS	4.30" 109 mm	4" Outer
4" 100 mm Sched 40/80 PVC	4.50" 114 mm	4" Outer
4" 100 mm CI/DI 4" 100 mm C900 4" 100 mm HDPE	4.80" 122 mm	4" Outer
6" 150 mm PVC 3033 OR D3034	6.275" 159 mm	6" Inner
6" 150 mm)TRUSS	6.30" 160 mm	6" Inner
6" 150 mm Sched 40/80 PVC	6.50" 165 mm	6" Inner
6" 150 mm PVC D3033 OR D3034	6.625" 168 mm	6" Inner
6" 150 mm CI/DI 6" 150 mm C900 6" 150 mm HDPE	6.90" 175 mm	6" Inner



CAS 964 STEP - 4" Outer

CAS 964 STEP - 6" Inner

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