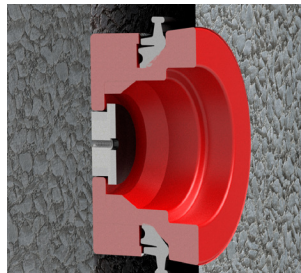


# ECONOSEAL

## PIPE TO MANHOLE & TANK CONNECTOR



### Where To Use

- Manholes
- Wet wells
- Stormwater structures



PAGE 5

### What It Is

The Econoseal is a simple cast-in pipe-to-manhole connector that offers an easy installation process in precast production facilities and in the field for contractors.

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

- Reusable mandrel tool holds the connector in place during the casting process.
- Connector is folded inward towards center of structure before shipping to job site.
- The pipe is beveled at the job site.
- Lubricant is applied to the connector and the pipe barrel.
- Pipe is inserted into connector by contractor.

### Why It's Better

- No special torque tools or take-up clamps required.
- Durable and reusable mandrel forms.
- Integrally cast into the structure at time of casting.
- Contractor can save time and money by backfilling immediately.

### Molded Econoseal

- New durable urethane mandrel
- Flipping gasket after casting not required
- Brand new molded gasket technology
- Designed for easier magnet installation
- Meets ASTM C923, C1478 & C1244
- Additional sizes are available upon request (see selection guide)

**TIP:** To ensure that the Econoseal continues to provide a watertight seal, we highly recommend not putting mortar between the connector and the wall. This decreases the ability of the connection to compensate for shear in ground movement.

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# ECONOSEAL

## SUBMITTAL SPECIFICATIONS

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A watertight flexible pipe-to-manhole connector shall be employed in the connection of the sanitary sewer and/or storm water pipe to precast manholes or other structures.

The connector shall be Econoseal 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 the structure. The rubber connector shall be constructed solely of synthetic or natural rubber, shall meet/exceed the requirements of ASTM C 923, and shall have a minimum tensile strength of 1600 psi.

The connector shall be directly cast into the structure using casting accessories available from the connector manufacturer.

Selection of the proper casting accessories for the manhole 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 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.

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### Product Performance

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Econoseal meets and/or exceeds all requirements of ASTM C 923, including physical properties of materials and performance testing. Performance testing includes:

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



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Web: [www.press-seal.com](http://www.press-seal.com)

# ECONOSEAL

## PVC, HDPE, NYLOPLAST® PVC & HARCO PVC SELECTION GUIDE

Pipe OD 4.21" - 32.00" (107 mm - 813 mm)

PVC/HDPE					
PIPE DESCRIPTION	PIPE O.D.	CONNECTOR NUMBER	MANDREL NUMBER	CASTING RING	STRUCTURE SIZE OPTIONS
4" (100 mm) PVC	4.210" 107 mm	770.0421 770.0421.M	227.420471 227.0471 227.0471.M**	258.471	42" MH - 4.5" WALL 48" MH - 5" WALL
6" (150 mm) PVC SDR35	6.275" 159 mm	770.0627	227.0677.30 227.420677 227.0677 227.0677.M**	258.677	30" MH - 4.5" WALL 42" MH - 4.5" WALL 48" MH - 5" WALL
8" (200mm) PVC SDR35	8.400" 213 mm	770.0840	227.420915 227.0915	258.915	30" MH - 4.5" WALL 42" MH - 4.5" WALL 48" MH - 5" WALL 60" MH - 6" WALL
10" (250 mm) PVC SDR35 OR 10" ADS Nyloplast® + Harco PVC Adapters	10.500" 267 mm	770.1050	227.421125 227.1125	258.1125	42" MH - 4.5" WALL 48" MH - 5" WALL
12" (300 mm) PVC SDR35 OR 12" ADS Nyloplast® + Harco PVC Adapters	12.500" 318 mm	770.1250	227.421325 227.1325	258.1325	42" MH - 4.5" WALL 48" MH - 5" WALL
15" (375 mm ) PVC SDR3 OR 15" ADS Nyloplast® + Harco PVC Adapters	15.300" 389 mm	770.1530	227.421605 227.1605	258.1605	42" MH - 4.5" WALL 48" MH - 5" WALL
18" PVC SDR35 OR 18" ADS Nyloplast® + Harco PVC Adapters	18.701" 475 mm	770.18701.42450 770.18701.48500 770.18701.60600 770.18701.72700	227.18701.42450 227.18701.48500 227.18701.60600 227.18701.72700	N/A	42" MH - 4.5" WALL 48" MH - 5" WALL 60" MH - 6" WALL 70" MH - 7" WALL
21" PVC SDR35 OR 21" ADS Nyloplast® + Harco PVC Adapters	22.047" 560 mm	770.22047.42450 770.22047.48500 770.22047.60600 770.22047.72700	227.22047.42450 227.22047.48500 227.22047.60600 227.22047.72700	N/A	42" MH - 4.5" WALL 48" MH - 5" WALL 60" MH - 6" WALL 70" MH - 7" WALL
24" PVC SDR35 OR 24" ADS Nyloplast® + Harco PVC Adapters	24.803" 630 mm	770.24803.42450 770.24803.48500 770.24803.60600 770.24803.72700	227.24803.42450 227.24803.48500 227.24803.60600 227.24803.72700	N/A	42" MH - 4.5" WALL 48" MH - 5" WALL 60" MH - 6" WALL 72" MH - 7" WALL
27" PVC SDR35	27.953" 710 mm	770.27953.48500	227.27953.48500	N/A	48" MH - 5" WALL
30" PVC SDR35	32.000" 813 mm	770.32000.48500	227.32000.48500	N/A	48" MH - 5" WALL

**NOTE:** Additional sizes are available upon request. Please contact customer service for more information

**\*\* These part numbers indicate a molded Econoseal with durable urethane mandrel**

**ORDERING DISCLAIMER:** Adapters and fittings are supplied by pipe manufacturers to provide a smooth and level surface on the outside diameter of the pipe so that boot-style connectors can be used. These adapters and/or fittings may differ from the sizes and types listed above. It is the sole responsibility of the customer to verify the correct OD of the fitting and/or adapter which will be used.

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# ECONOSEAL

RCP, CI/DI, TRUSS

Pipe OD 4.30" - 32.00" (109 mm - 813 mm)

RCP					
PIPE DESCRIPTION	PIPE O.D.	CONNECTOR NUMBER	MANDREL NUMBER	CASTING RING	STRUCTURE SIZE OPTIONS
18" (450 mm) RCP WALL B	23.00" (584 mm)	770.23000.48500	227.23000.48500	N/A	48" MH - 5" WALL

CAST IRON / DUCTILE IRON					
PIPE DESCRIPTION	PIPE O.D.	CONNECTOR NUMBER	MANDREL NUMBER	CASTING RING	STRUCTURE SIZE OPTIONS
4" (100 mm) DI	4.800" 122 mm	770.0480	227.0530	258.0530	48" MH - 5" WALL
6" (150 mm) DI	6.900" 175 mm	770.0690	227.420765 227.0765	258.0765	42" MH - 4.5" WALL 48" MH - 5" WALL
8" (200 mm) DI	9.050" 230 mm	770.0905	227.420980 227.0980	258.0980	42" MH - 4.5" WALL 48" MH - 5" WALL
10" (250 mm) DI	11.100" 282 mm	770.1110	227.421185 227.01185	258.01185	42" MH - 4.5" WALL 48" MH - 5" WALL
12" (300 mm) DI	13.200" 335 mm	770.1320	227.421395 227.1395	258.01395	42" MH - 4.5" WALL 48" MH - 5" WALL
14" (350 mm) DI	15.300" 389 mm	770.1530	227.421605 227.1605	258.01605	42" MH - 4.5" WALL 48" MH - 5" WALL
18" (457 mm) DI	19.50" 495 mm	19500.48500	19500.48500	N/A	48" MH - 5" WALL
30" (762 mm) DI	32.000" 813 mm	32000.48500	32000.48500	N/A	48" MH - 5" WALL

TRUSS					
PIPE DESCRIPTION	PIPE O.D.	CONNECTOR NUMBER	MANDREL NUMBER	CASTING RING	STRUCTURE SIZE OPTIONS
4" (100mm) TRUSS	4.300" 109 mm	770.0430	227.420477 227.0477	258.0480	42" MH - 4.5" WALL 48" MH - 5" WALL
6" (150 mm) TRUSS	6.300" 160 mm	770.0630	227.420677 227.0677	258.0677	42" MH - 4.5" WALL 48" MH - 5" WALL

Additional sizes are available upon request. Please contact customer service for more information

**NOTE:**

The Econoseal requires Press-Seal supplied mandrel system for integrally casting into the structure. Please contact your territory manager or customer service department for details.



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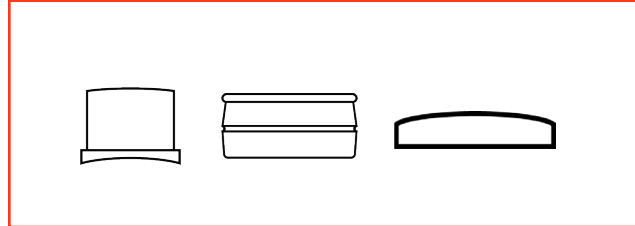
Email: sales @press-seal.com  
Web: www.press-seal.com

# ECONOSEAL 4" - 15"

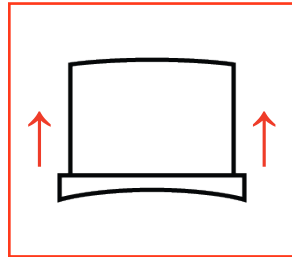
## INSTALLATION INSTRUCTIONS

### ITEMS NEEDED

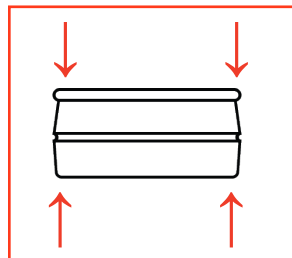
MANDREL, ECONOSEAL AND CASTING RING



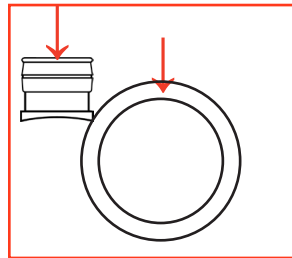
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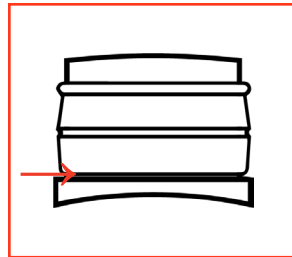
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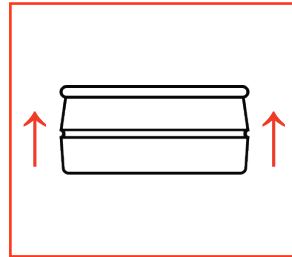
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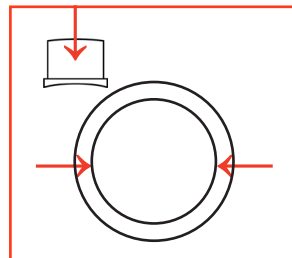
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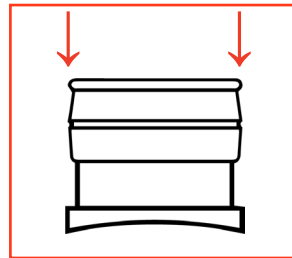
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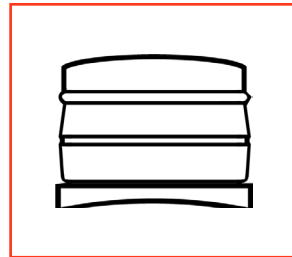
4.



6.



8.



### INSTALLATION

1. Start by placing your mandrel face up
2. Place Econoseal connector key lock up
  - a. Remember face up/key up and you'll always have our connector in the proper position
3. Start by pinching the seal so that you create a flat surface on the inside of the Econoseal connector
4. Start over the 3:00 and 9:00 position (high side) of the mandrel
5. Then stretch the connector over the 12:00 position
6. Seat and equalize the seal with a pushing motion down towards the step around the entire seal
7. Ensure the seal is seated all the way against the step of the mandrel
8. Install the casting ring by aligning the thick and thin areas of the casting ring with the thick and thin areas of the mandrel

### QUALITY CONTROL

9. Start by examining where the sealing lobe meets the step of the mandrel. You want that to be as tight as possible around the entire circumference of the mandrel
10. Now examine casting ring so that it is seated up against the seal around the entire circumference of the seal

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# ECONOSEAL 18" - 30"

## INSTALLATION INSTRUCTIONS

### INSTALLATION

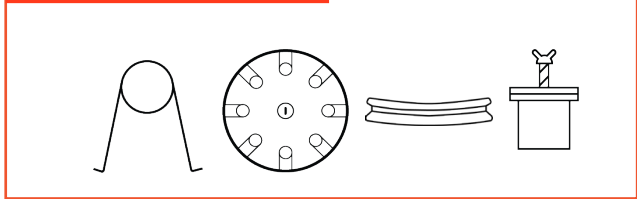
1. Start by placing your mandrel face up
2. Place Econoseal connector key lock up
  - a. Remember face up/key up and you'll always have our connector in the proper position n every time
3. Start by pinching the seal so that you create a flat surface on the inside of the Econoseal connector
4. Start over the 3:00 and 9:00 positions (high side) of the mandrel
5. Continue to pinch the seal and work around to the 12:00 and the 6:00 position of the mandrel
6. Repeat this until you've started the seal past the first initial face of the mandrel
7. Now flip the mandrel over to gain access to the spring slots
8. Start by inserting at the 3:00 and the 9:00 springs
9. Shift the seal forward toward the open face of the mandrel until you feel springs engage
10. Now work the seal toward the open face little at a time
11. Insert a torsion spring into the 10:00 position until you feel it engage with the groove
12. Now insert a torsion spring at the 2:00 position
13. Finish this side by inserting torsion spring at the 12:00 position
14. Rotate mandrel 180 degrees and repeat steps 10-13

### QUALITY CONTROL

15. Look at the 12:00 and 6:00 sealing position for the sealing lobe to be flush or just over flush with the open face of the mandrel
16. Next at the 3:00 and 9:00 position look for a small gap with some exposed aluminum
17. Finally pull back the key lock and see that the spring actually protrudes into the groove of the connector

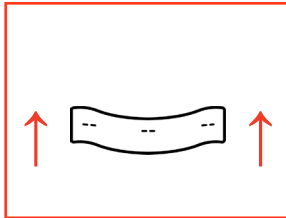
### ITEMS NEEDED

#### SPRING TO MANDREL

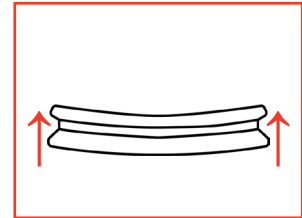


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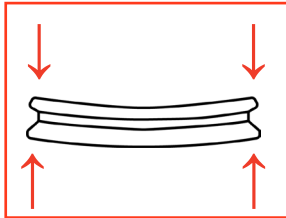
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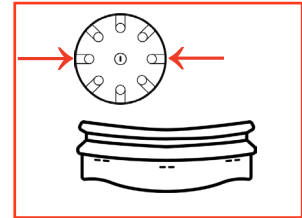
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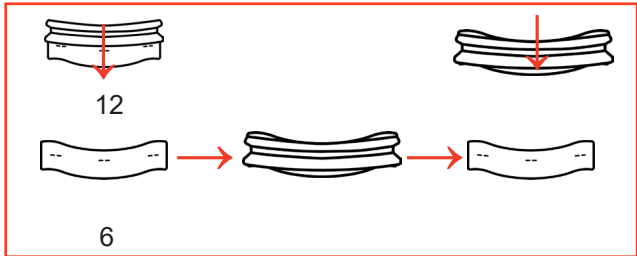


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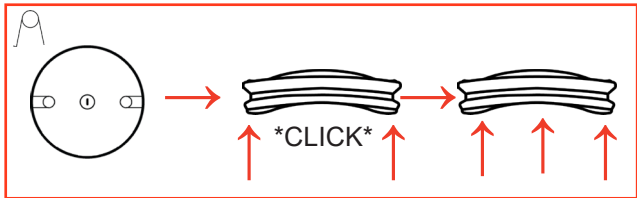


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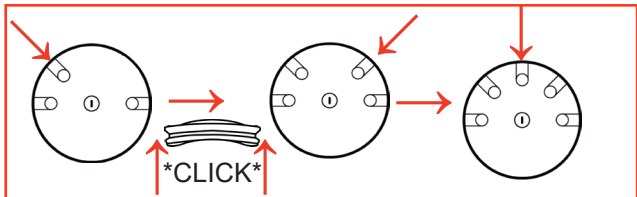
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11.

12.

13.



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