

## INSTALLATION GUIDE

CERTA-COM<sup>®</sup> TRENCHLESS CONDUIT PVC PIPE

## GENERAL NOTES

- For questions regarding assembly, consult your local sales expert or Technical Services at 484-435-7474 or email [technical@westlakepipe.com](mailto:technical@westlakepipe.com).
- For additional instructions regarding pipe handling, installation, and other topics, consult applicable industry standards or product information on [westlakepipe.com](http://westlakepipe.com) or watch our [video](#).

## INSTRUCTIONS

## 1. Inspect &amp; Clean Female Bell End

- Before assembling pipe joints, remove all grit and dirt from the bell end of the pipe. If grit or dirt is located at the O-ring, remove the O-ring and clean the foreign matter from the grooves and the O-ring. Replace the O-ring. Take care to ensure the O-ring is fully and evenly seated in the O-ring groove.
- Using a wet rag, clean out all dirt and other material from inside the bell including the spline and O-ring grooves.



## 2. Inspect O-ring for Defects

- Inspect the O-ring for any tears, gouges, cracking, or other defects. For products with O-rings (shipped separately in kits), inspect before installing in the bell end of the pipe.
- Install the O-ring in the second groove of the bell—this is the groove that does not have a spline hole drilled. The O-ring should fit in the groove without falling out, bunching up, or becoming twisted.
- Contact the Distributor for replacement of any questionable O-rings. Do not install pipe with questionable or deformed O-rings.

## 3. Inspect &amp; Clean Male Spigot End

- Using a wet rag, clean off all dirt and other material from the outside surface of the pipe spigot, up to and including the spline groove.
- Inspect the spigot edge for a consistent, undamaged bevel. Do not use pipe spigots with disfigured bevels that could damage the O-ring when inserted into the bell.

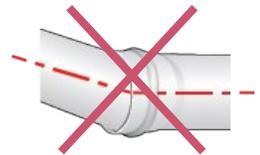
## 4. Lubricate

- IMPORTANT: Use a pipe lubricant only!
- Spigot End – Using a brush, apply lubricant to the pipe exterior from the beveled edge back to the spline groove. DO NOT lubricate the spigot spline groove.
- Bell End – Apply lubricant to the exposed surfaces of the installed O-ring. DO NOT lubricate the bell spline groove.
- Wipe off any excess lubricant.



## 5. Assemble Joint

- Rotate the bell so the spline hole is accessible for spline insertion.
- Align the spigot and bell ends of the pipe so that the spigot is entering the center of the bell and the two pieces of pipe are in straight alignment. The spigot must not be inserted into the bell at an angle; this may damage or dislodge the O-ring.
- Push the spigot straight into the bell so the spigot stops in the back of the bell and the spline grooves align. The bar and block method of assembly is recommended, although larger pipe may require mechanical assistance.
- If the pipe does not easily insert - STOP - check the bell, spigot, and O-ring for issues. Clean or lubricate as necessary.



## 6. Insert Spline

- DO NOT lubricate the spline!
- Insert the pointed end of the spline into the bell spline hole. For rectangular splines, the wider face should be parallel to the length of the pipe. For square splines, either face can be parallel to the length of the pipe.
- Push the spline into the spline hole until the spline "bottoms out". It may be necessary to use a Westlake Pipe & Fittings Spline Insertion Tool or mallet. Approximately, 1" to 3" of the spline should extend beyond the connected pipe joint.
- It is not necessary to trim the excess spline "tail". Trimming the tail will not affect the strength of serviceability of the joint but will make it difficult to grab the spline for removal.