

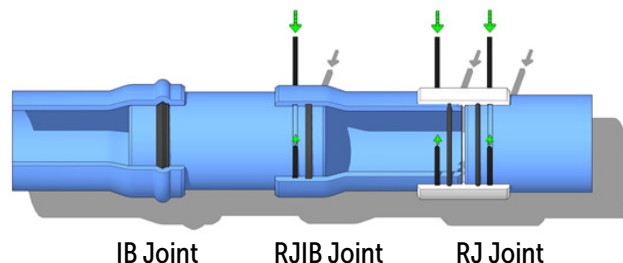
TECHNICAL BULLETIN

CONNECTING DIFFERENT JOINT STYLES OF AWWA C900 PVC PIPE

PIPE JOINT STYLES

Westlake Pipe & Fittings produces AWWA C900 pipe products in three different joint styles: Gasketed Integral Bell (IB), Certa-Lok® Restrained Joint (RJ), and Certa-Lok Restrained Joint Integral Bell (RJIB).

For a variety of reasons, it may be necessary for the contractor to transition from one joint style to another for the same given size.



PIPE JOINT STYLES			
Joint Style	Restrained Joint?	Pipe	Coupling
IB	No	Male Plain End Spigot X Female Gasketed Bell	N/A
Certa-Lok RJ	Yes	Certa-Lok Male Spigot X Certa-Lok Male Spigot	Certa-Lok Female X Certa-Lok Female
Certa-Lok RJIB	Yes	Certa-Lok Male Spigot X Certa-Lok Female Bell	N/A

GENERAL REQUIREMENTS

1. Joining products must conform to the same product standard (AWWA C900), nominal size, and diameter scheme (CIOD).
2. Joining products of different pressure classes will lower the pipeline to the lowest rating of the two pipe segments and coupling, if used.
3. Follow all normal joint assembly instructions per other Westlake Pipe & Fittings installation guides and AWWA C605. This includes, but is not limited to cleaning, lubrication, and assembly methods.
4. Refer to the Certa-Lok product specifications for the part numbers of appropriate beveling tools, grooving bits, grooving jigs, and Certa-Lok groove dimensions.

C900/IB & C900/RJ CERTA-LOK – UNRESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
IB Spigot X RJ Spigot	4" - 12"	<ul style="list-style-type: none"> • Fluid-Tite® Repair or High-Deflection Coupling • Saw • Beveling tool • Marker 	<ol style="list-style-type: none"> 1. Cut off several inches from the end of the RJ pipe spigot to remove the Certa-Lok groove. 2. Bevel the modified RJ pipe and install both segments in the Fluid-Tite Coupling per the Fluid-Tite Coupling Installation Guide.
	14" - 24"	<ul style="list-style-type: none"> • Third-Party Repair, Stop, or High-Deflection Coupling • Saw • Beveling tool • Marker 	<ol style="list-style-type: none"> 1. Cut off several inches from the end of the RJ pipe spigot to remove the Certa-Lok groove. 2. Bevel the modified RJ pipe and install both segments in the third-party coupling per the manufacturer's instructions.
IB Bell X RJ Spigot	4" - 24"	<ul style="list-style-type: none"> • Saw • Beveling tool • Marker 	<ol style="list-style-type: none"> 1. Cut off several inches from the end of the RJ pipe spigot to remove the Certa-Lok groove. 2. Bevel the outer edge of the modified RJ pipe. Use a factory-finished IB spigot end as a guide for proper bevel angle and depth. 3. Draw new insertion marks on the modified RJ pipe at the same distance as the factory-finished IB pipe. 4. Install modified RJ pipe into IB Bell.

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C900/IB & C900/RJIB – UNRESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
IB Spigot X RJIB Spigot	6" - 16"	<ul style="list-style-type: none"> Fluid-Tite Repair or High-Deflection Coupling Saw Beveling tool 	<ol style="list-style-type: none"> Cut off several inches from the end of the RJIB pipe spigot to remove the Certa-Lok groove. Bevel the modified RJIB pipe and install both segments in the Fluid-Tite Coupling per the Fluid-Tite Coupling Installation Guide.
IB Spigot X RJIB Bell	6" - 16"	<ul style="list-style-type: none"> Fluid-Tite Repair or High-Deflection Coupling Saw Beveling tool 	<ol style="list-style-type: none"> Cut off the RJIB pipe bell. Bevel the modified RJIB pipe and install both segments in the Fluid-Tite Coupling per the Fluid-Tite Coupling Installation Guide.
IB Bell X RJIB Spigot	6" - 16"	<ul style="list-style-type: none"> Saw Beveling tool Marker 	<ol style="list-style-type: none"> Cut off several inches from the end of the RJIB pipe spigot to remove the Certa-Lok groove. Bevel the outer edge of the modified RJIB pipe. Use a factory-finished IB spigot end as a guide for proper bevel angle and depth. Draw new insertion marks on the modified RJIB pipe at the same distance as the factory-finished IB pipe. Install modified RJIB pipe into IB Bell.
IB Bell X RJIB Bell	6" - 16"	<ul style="list-style-type: none"> Saw Beveling tool Marker 	<ol style="list-style-type: none"> Cut off the RJIB pipe bell. Bevel the outer edge of the modified RJIB pipe. Use a factory-finished IB spigot end as a guide for proper bevel angle and depth. Draw new insertion marks on the modified RJIB pipe at the same distance as the factory-finished IB pipe. Install modified RJIB pipe into IB Bell.

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C900/RJ & C900/RJIB – RESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
RJ Spigot X RJIB Spigot	4" ¹	<ul style="list-style-type: none"> 4" C900/RJ x 4" C900/RJIB Certa-Lok Adapter 	<ol style="list-style-type: none"> 1. Install 4" C900/RJ pipe into side of adapter having matching spline groove width. Insert S0418SN0, 0.250"x0.250" Certa-Lok-Spline into common pipe/coupling groove. 2. Install 4" C900/RJIB pipe into side of adapter having matching spline groove width. Insert S0518TN0, 0.170"x0.350" Certa-Lok-Spline into common pipe/coupling groove.
	6" - 16"	<ul style="list-style-type: none"> C900/RJ Certa-Lok Coupling 	<ol style="list-style-type: none"> 1. Install RJ pipe spigot into one side of C900/RJ Coupling. Insert spline from C900/RJ Coupling's kit into common pipe/coupling groove. 2. Install RJIB pipe spigot into other side of C900/RJ Coupling. Insert spline from C900/RJ Coupling's kit into common pipe/coupling groove.
RJ Spigot X RJIB Bell	6" - 16"	<ul style="list-style-type: none"> C900/RJ Certa-Lok Coupling Saw Router C900/RJ Field Grooving Jig C900/RJ Grooving Bit C900/RJ Beveling Bit 	<ol style="list-style-type: none"> 1. Install RJ pipe spigot into one side of C900/RJ Coupling. Insert spline from Coupling's into common pipe/coupling groove. 2. Cut off the RJIB pipe bell. 3. Using a router, appropriate C900/RJ Field Grooving Jig, and appropriate C900/RJ Field Grooving Bit, cut a new Certa-Lok groove in the RJIB pipe. 4. Using a router and the C900/RJ Beveling Bit, cut a fresh beveled edge on the RJIB pipe. 5. Install modified RJIB pipe into other side of C900/RJ Coupling. Insert spline from C900/RJ Coupling's kit into common pipe/coupling groove.

¹ 4" RJIB is no longer manufactured as of 12/2019.

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