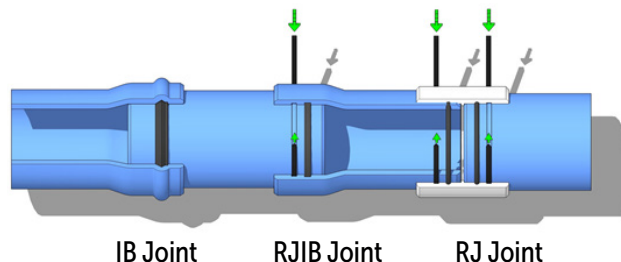


TECHNICAL BULLETIN

CONNECTING DIFFERENT JOINT STYLES OF ASTM D2241 PVC PIPE

PIPE JOINT STYLES

Westlake Pipe & Fittings produces ASTM D2241 pipe products in three different joint styles: Gasketed Integral Bell (IB), Certa-Lok® Restrained Joint (RJ), and Certa-Lok Restrained Joint Integral Bell (RJIB). The Certa-Lok products containing our Yelomine® compound and are sometimes referred to by that name alone.



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 (ASTM D2241), nominal size, and diameter scheme (IPS).
2. Joining products of different pressure classes will lower the pipeline to the lowest rating of the two pipe segments and coupling/adaptor, if used.
3. Follow all normal joint assembly instructions per other Westlake Pipe & Fittings installation guides and ASTM D2774. 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

D2241/IB & D2241/RJ CERTA-LOK YELOMINE – UNRESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
IB Spigot X RJ Spigot	2" - 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" - 16"	<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	2" - 16"	<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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ASTM D2241 PVC PIPE

D2241/IB & D2241/RJIB CERTA-LOK YELOMINE – UNRESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
IB Spigot X RJIB Spigot	4" - 8"	<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	4" - 8"	<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	4" - 8"	<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 & 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	4" - 8"	<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.

TECHNICAL BULLETIN

CONNECTING DIFFERENT JOINT STYLES OF
ASTM D2241 PVC PIPE

D2241/RJ CERTA-LOK YELOMINE & D2241/RJIB CERTA-LOK YELOMINE – RESTRAINED JOINT			
Scenario	Nominal Sizes	Supplies Needed	Method
RJ Spigot X RJIB Spigot	4" All Classes	<ul style="list-style-type: none"> D2241/RJ Certa-Lok Yelomine Class 250 or Class 350 Coupling 	1. Install RJ pipe spigot into one side of D2241/RJ Coupling. Insert spline from D2241/RJ Coupling's kit into common pipe/coupling groove.
	6" – 8" SDR 26, SDR 21, SDR 17, SDR 13.5	<ul style="list-style-type: none"> D2241/RJ Certa-Lok Yelomine Class 250 or Class 315 Coupling 	2. Install RJIB pipe spigot into other side of D2241/RJ Coupling. Insert spline from D2241/RJIB pipe's spline kit into common pipe/coupling groove.
	6" – 8" DR 12.43 RJ Spigot mixed with any other class RJIB Spigot	<ul style="list-style-type: none"> D2241 Certa-Lok Female x Solvent Weld Female Yelomine Adapter Saw 	<ol style="list-style-type: none"> 1. Install RJIB pipe spigot into the Certa-Lok female side of the adapter. Insert spline from RJIB pipe into common pipe/adapter groove. 2. Cut off several inches from the end of the RJ pipe spigot to remove the Certa-Lok groove. 3. Using proper ASTM D2855 solvent cement procedures, solvent weld the modified RJ pipe spigot into the female solvent weld side of the adapter.
RJ Spigot X RJIB Bell	4" – 8" All Classes	<ul style="list-style-type: none"> D2241 Certa-Lok Female x Solvent Weld Female Yelomine Adapter Saw 	<ol style="list-style-type: none"> 1. Install RJ pipe spigot into the Certa-Lok female side of the adapter. Insert spline from RJ pipe into common pipe/adapter groove. 2. Cut off the RJIB pipe bell. 3. Using proper ASTM D2855 solvent cement procedures, solvent weld the modified RJIB pipe spigot into the female solvent weld side of the adapter.

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