



WT+, WT & ST Series

Tylox® Cast-in, Compression-Fit Connector Installation Instructions

Tylox® WT+ and WT connectors are designed to meet, and have been factory tested to, the watertight requirements of ASTM C923: 13 psig (90 kPa or 30ft head) in straight alignment and 10 psig (41 kPa or 23 ft head) @ 7° deflection. Tylox® ST is watertight to 6 psig. Proper care and attention must be given to the installation of the connecting pipe in order to achieve these results in the field.

1. Ensure pipe end is free from physical defects, cracks or burrs.
2. Ensure that pipe end is beveled to a minimum of 3/4" (19 cm), de-burred and cleaned. For concrete pipe, care must be taken to ensure a clean cut is obtained - broken or dam-



aged ends must NEVER be used as they have the potential to tear the rubber connector.



***Making Infrastructure Watertight Today
for a **Greener**, Sustainable Tomorrow***

3. It is important that concrete pipe molding lines be smoothed. This can best be done using a piece of re-bar as a file. (Power tools have the potential to leave a “flat” spot on the pipes circumference.)
4. Clean loose debris, dust and dirt from hole I.D., connector surface and pipe O.D.
5. Lubricate both connector surface and pipe-end O.D. with suitable Tylox® Pipe Lube.



Pipe-end O.D. should be lubricated to a length 6” longer than the insertion length. **(With connectors rated for standard service, hydrocarbon-based lubricants must NOT be used, as these have a detrimental effect on the connector material and its watertightness rating.)**



6. Insert pipe into connector to an insertion length sufficient to ensure that pipe wall is in touch with gasket around the complete circumference, and a minimum length of 6” (subject to benching dimensions) protrudes beyond the gasket sealing surface. Pipe must always be inserted “straight”. Any required deflection should be applied after pipe has been inserted into connector.

Note:

- a) **NO MORTAR SHOULD BE PLACED AGAINST THE CONNECTOR** between the structure wall and the pipe O.D. Doing so will negate the ability of the pipe/connector to compensate for differential settlement and may degrade the watertightness of the joint.
- b) Where pipe stubs are installed to accommodate future expansion, **ALL PIPE STUBS MUST BE PHYSICALLY RESTRAINED TO PREVENT MOVEMENT.** Pipe stub restraints must remain in place until future tie-in of the line is completed.



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