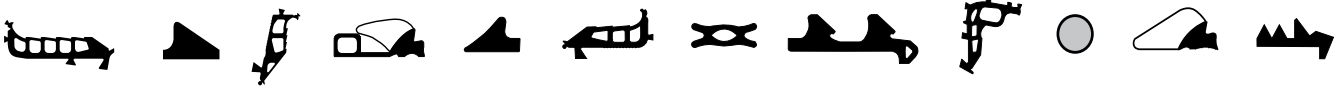


## REQUIRED ASSEMBLY FORCES FOR PIPES



### REQUIRED ASSEMBLY FORCES FOR PIPES WITH DS BL AND ANKERPLUS SEALS

The level of assembly force for pipes with DS BL and ANKERPLUS seals depends on different factors such as:

- Temperature during installation (hardness of rubber increases with cold temperatures)
- Surface condition of the spigot ends (rough spigot ends cause higher friction to the rubber)
- Deformation of the seal (most important factor: with increasing deformation the necessary assembly force increases)
- Kind and amount of the lubricant (with rougher spigot end more lubricant is needed. With higher degree of deformation more lubricant with better shear resistance is necessary)
- Method of pipe laying (if the pipe is put down on the floor and pulled or pushed during assembly, the frictional resistance of the pipe on the floor increases the assembly force required).

Fully considering all factors, the following minimum assembly forces should be available for laying pipes using DS BL AND ANKERPLUS seals.

DN	Assembly Forces
300	15 KN
400	20 KN
500	25 KN
600	30 KN
700	60 KN
800	70 KN
900	80 KN
1000	90 KN
1100	100 KN
1200	110 KN