

- C. The joint ring shall be in accordance with the requirements of the appropriate part of BS2494 and the physical characteristics appropriate to the type pipe and joint supplied.
- D. Where applicable, the joints for flanged pipes shall incorporate an annular gasket. In horizontal lengths of pipelines, use gaskets that cover the full face of the flange with holes cut in them vertically. Plain ring covering the flange between the bolt circle and the bore of the pipe may be used if approved by the Engineer. The gaskets shall be 3mm thick of first quality rubber incorporating two layers of cotton fabric insertion evenly spaced in the gaskets. When flanged joints are to be made, insert the bolts and the nuts turned to finger tightness. The final tightening of the nuts shall be effected by spanners in such sequence that diametrically opposite nuts are tightened together.
- E. Joints shall be made in accordance with the manufacturer's instructions.
- F. Provide the spigot and socket flexible joints with annular space between the pipe and socket. Seal the annular space with an approved flexible joint sealant immediately upon completion of a satisfactory initial hydraulic test and prior to concreting or backfilling but not prior to testing.

24.2.4 Fabrication and Fabrication Tolerances

- A. Reinforced Concrete Pipe: The minimum nominal length is 2.5 meters and the maximum length is 6 meters unless otherwise specified for special purposes such as curves or closures.
 - 1. Use steel made forms with butt joints throughout when casting pipes.
 - a. The surfaces of the forms adjacent to the pipe walls shall be smooth and true.
 - b. Forms shall be sufficiently tight with suitable gaskets provided at all form joints to prevent leakage of mortar.
 - c. The forms shall be braced and sufficiently stiff to withstand without detrimental deformation all operations incidental to the placement and compaction of concrete within the form.
 - d. The form and end rings shall be constructed so that the pipe when manufactured have circular and cylindrical inner surfaces and maybe stripped from the pipe without damage to the pipe or its surfaces.
 - e. Clean and oil the forms at the start of each continuous production.