

6 EASY STEPS TO USING THE FIELD ROUNDING KIT



McWaneDuctile.com



DO IT RIGHT IN THE FIELD

KIT INCLUDES: Jack, block for jack, chain, OD (Outside Diameter) tape, and instructions.

The purpose of this rounding kit is to provide a simple method to change the shape of your Ductile iron pipe – from the outside – in plain view, during joint assembly. The kit is designed for 36-inch pipe and down. The kit is not intended for pipe sizes above 36-inch diameter. Heavy wall pipe (wall thickness ≥ 0.50 inches) may require internal rounding.



1. MEASURE PIPE

Always measure the Outside Diameter of the pipe prior to cutting. Only cut pipe that measure within AWWA acceptable standard tolerances. The rounding kit will “round” the shape of the barrel – not the size. **REMINDER: Measure twice / Cut once!**



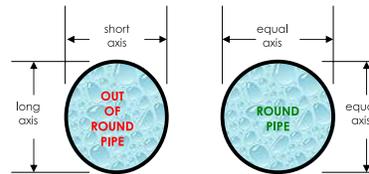
2. CUT PIPE

Use a pipe saw with a carbide abrasive or diamond-tipped blade to safely cut the pipe at the location previously confirmed with the OD tape. See our helpful blog on how to cut DI pipe in the field at McWaneDuctile.com/blog.



3. BEVEL SPIGOT

Use a metal file or rotary angle grinder to apply chamfered relief to the spigot end. Square or sharp edges may cause damage or displace a gasket during assembly.



4. PLACE LONG AXIS VERTICAL

Place the long axis in the vertical position and the jack at the 12 o'clock position / on the top side of pipe. Locate jack clear of the finished joint's insertion potential.

See our helpful blog with video on how to use the McWane Ductile Field Rounding kit at McWaneDuctile.com/blog.



5. WRAP CHAIN

The chain should be initially wrapped and hooked around the pipe in mild tension, thereby staying in place on its own. This makes each stroke of the jack more effective.



6. ROUND PIPE

Operate the jack to round the pipe to desired ovality. Each pipe will require different amounts of adjustment based upon the pipe size, wall thickness, and degree of original ovality.

SPOKEN Diameter	MINIMUM Outside Diameter	NOMINAL Outside Diameter	MAXIMUM Outside Diameter	MAXIMUM Diameter Closest 16th
6	6.84	6.90	6.96	6.9375
8	8.99	9.05	9.11	9.125
10	11.04	11.10	11.16	11.25
12	13.14	13.20	13.26	13.25
14	15.22	15.30	15.35	15.9375
16	17.32	17.40	17.45	17.4375
18	19.42	19.50	19.55	19.5625
20	21.52	21.60	21.65	21.625
24	25.72	25.80	25.85	25.8125
30	31.94	32.00	32.08	32.0625
36	38.24	38.30	38.38	38.375

AWWA C151 DUCTILE IRON PIPE DIMENSIONS (shown in inches)

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