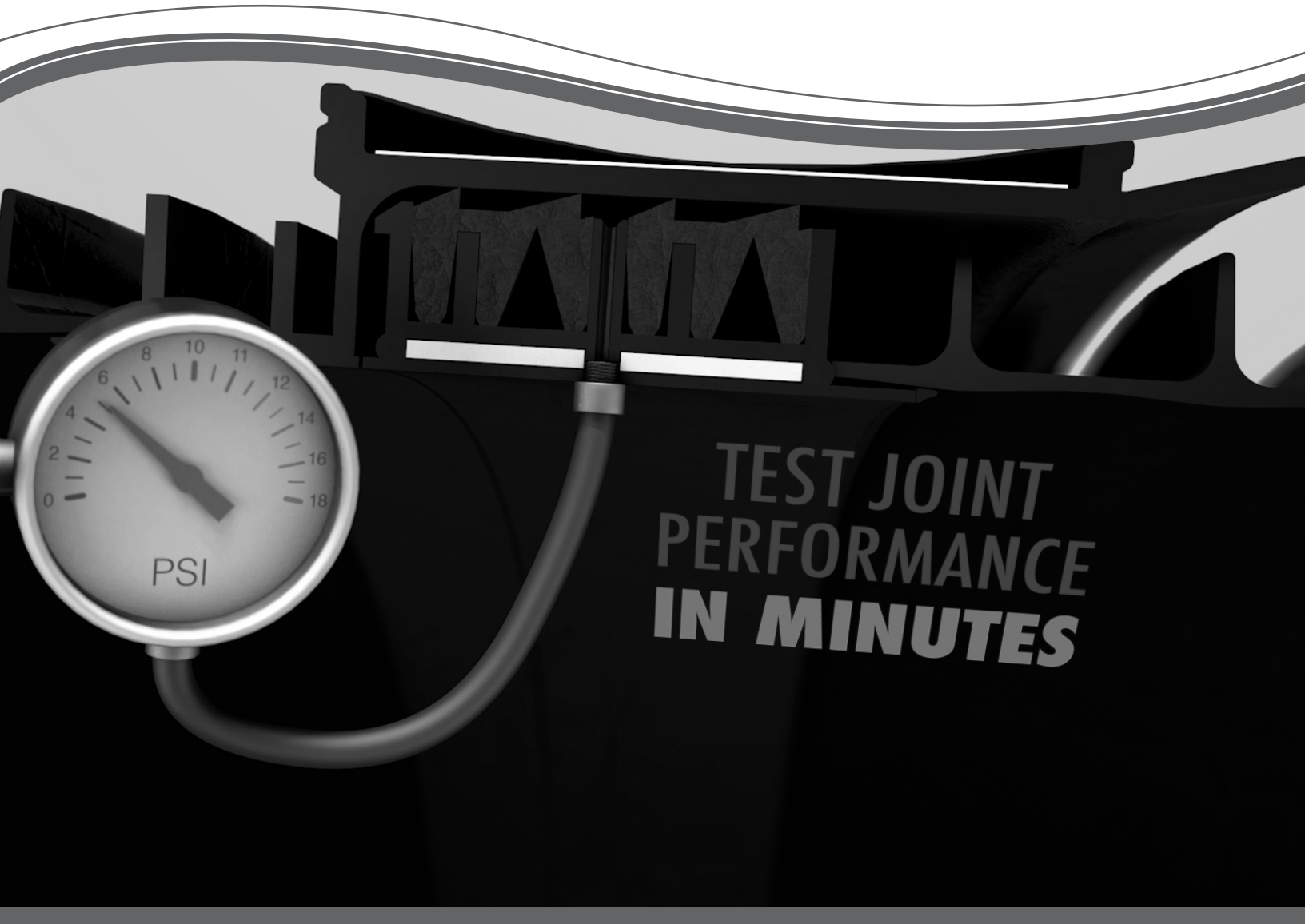
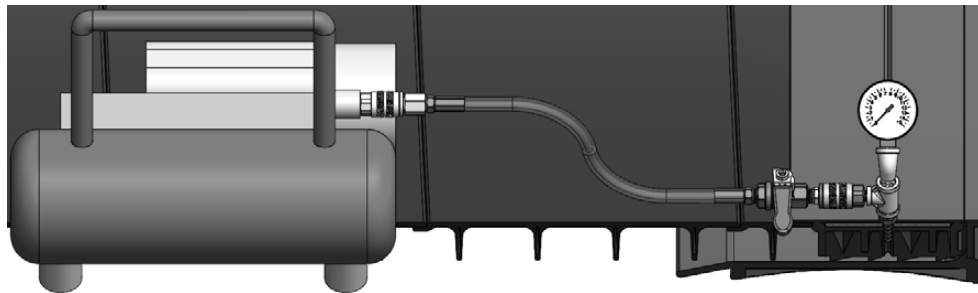


QuikJoint[®] Testing
Process



Equipment Checklist

- ☑ [Air Compressor - 18V Cordless Air Compressor w/ Battery](#)
- ☑ [Hand Drill - 18V Cordless Drill with Battery](#)
- ☑ [Drill Bit - Size B Drill Bit 4" Length](#)
- ☑ [Quick Disconnect Plug Female - 1/4 Coupling Industrial Plug, 1/4 NPTF Fitting](#)
- ☑ [Air Hose - 25 ft Polyurethane Hose with 1/4 NPT Male Fittings](#)
- ☑ [On/Off Valve - 1/4 NPTF On/Off Valve with Lever Handle](#)
- ☑ [Quick Disconnect Plug Male - 1/4 Coupling Industrial Plug, 1/4 NPT Male Fitting](#)
- ☑ [Quick Disconnect Socket - 1/4 Coupling Industrial Socket, 1/8 NPT Male Fitting](#)
- ☑ [Inline Tee Reducer - 1/4 NPTF, 1/8 NPTF, 1/4 NPTF Inline Tee Reducer](#)
- ☑ [45 Degree Elbow - 1/4 NPTF, 1/4 NPT Male 45 Degree Elbow Adapter](#)
- ☑ [Pressure Gauge - 1/4 NPT Male 15 Psi Pressure Gauge](#)
- ☑ [Press Fit Barbed Fitting - 1/4 NPT Male, 1/4" Barbed Fitting for Hose, Pack of 10](#)
- ☑ [Thread Sealant Tape - 0.0032" Thick, 1/2" Wide PTFE Sealant Tape](#)



Test Procedure

- Drill Test Port (Skip if Test Port drilled at plant).



- Mark location for test port centered on V-Notch in center of Spigot Profile.
- Drill size "B" hole being careful to maintain perpendicularity to profile wall.
- Assemble test apparatus
 - Assemble test apparatus components per Figure 1.
 - Be sure to use adequate Thread Sealant Tape to ensure airtight connections at all points.
 - Attach test apparatus to threaded test port using thread sealant tape.
 - Attach compressed air hose to test apparatus.

- Perform Pressure Test

- Ensure air valve is in the open position.
- Gradually increase air pressure until required test pressure is achieved on gauge, maximum 3.5 psi.
- Close air valve.
- Successful test is achieved when gauge pressure remains at required pressure for required time.
- If pressure holds, or drops less than 1 psi in the 5 seconds, the joint passes. Practically, the test is a go/no go test.

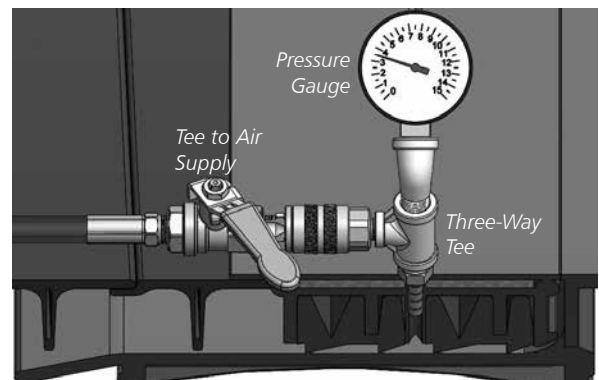


Figure 1

Install Spin Plug

Installation of a spin plug (Figure 2) is optional. The spin plug serves to plug the test port sealing the annular space between the gaskets from the interior of the pipe. If a spin plug is not applied, then water from inside the pipe could flow into the annulus but should not be allowed to exit the pipe. Likewise, water from outside of the pipe should not be able to penetrate the pipe.

- If a spin plug is desired or required, attach the shaft of the spin plug into a cordless drill.
- Align the point of the spin plug into the opening of the test port.
- Spin the plug into the test port using firm and even pressure on the cordless drill.
- Continue to drill the plug into the test port until the flat face of the plug interacts with the wall of the spigot.
- With continued pressure and spinning friction will melt the spin plug into the test port.
- Continue with even pressure until the shaft of the plug breaks at the breakaway point.



Figure 2

Notes on Potential Failed Air Tests

- The air test is considered as failed if the gauge pressure falls below the required level within the required time frame.
- A failed Annular Space pressure test does not mean that the joint is not leak free. To pass the test, both gaskets must function as designed. However, if one gasket does not function as designed but the other does then the joint will still be leak free.
- Reasons for failure of one or both gaskets would be related to damage to one or more components or obstruction within the joint by debris or other materials.



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