

Product Notes



Product Note 3.105

Re: Integral Bell Transition

Date: Updated February 6, 2000

Advanced Drainage Systems, Inc. offers a wide variety of coupler systems to meet the specific project requirements specified by the Engineer. When ADS became the first manufacturer of HDPE pipe to offer an in-line integral bell (N-12 Pro-Link Ultra), end users realized faster, easier installations with superior joint performance.

N-12 Pro-Link Ultra is an in-line integral bell which maintains a constant pipe outside diameter. This constant OD eliminates the need for bell holes and makes it easier to maintain line and grade. The gasketed bell and spigot design, with an elastomeric rubber gasket meeting ASTM F477, is for silt tight, gravity flow storm sewer applications.

With the variety of couplers available, connecting to existing pipe runs or to fabricated fittings may necessitate a transition to other ADS joints. This product note will give guidance in selecting the proper method of making these connections.

Whenever using integral bell products with other ADS pipe systems, always position the integral bell pipe lengths at the end of the project.

Following is a brief summary of the possible combinations of ADS products and the recommended method of transitioning.

- **12" through 42" integral bell pipe to split couplers (Series 95):**

Remove the mini-corrugations from the spigot end of the pipe. Utilize a split coupler to make the transition (see Figure 1).

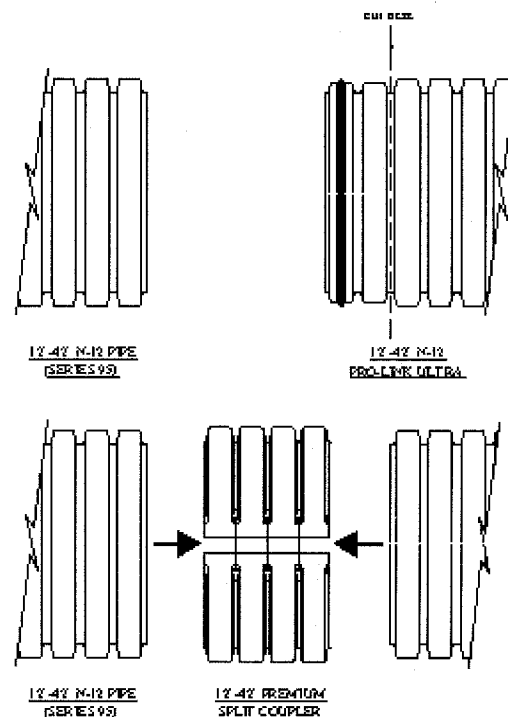


Figure 1

- **12" through 24" integral bell pipe to cleated bell-bell couplers (Series 85)**

Remove the mini-corrugation from the spigot end of the pipe. Insert this end into the female end of the cleated bell-bell coupler (see Figure 2).

- **30" and 36" integral bell pipe to pipe with a welded bell utilizing a factory provided transition length.**

Some orders will be provided with a transition length from the factory. This transition length will have the new integral bell without the mini-corrugations on the spigot end. These mini-corrugations have been removed at the factory. An O-ring gasket has been installed on the spigot end of this transition length. Simply lube this joint to transition to the welded bell.

- **42" integral bell pipe to 42" N-12 HC pipe.**

Remove the mini-corrugations from the spigot end of the pipe. Insert this end into the bell of the HC pipe. Install ADS watertight field coupler around the HC bell and the N-12 pipe end.

- **Field splices of 30" and 36" integral bell pipe to welded bell pipe.**

- *Option I (Split coupler):*

Remove the mini-corrugation of the pipe and the welded bell. Utilize a split coupler to make the transition (similar to Figure 1).

- *Option II (Gasket):*

Remove the mini-corrugations from the spigot end of the integral bell pipe. Install a gasket on the first standard length corrugation. Lube the joint and insert into the welded bell (see Figure 3).

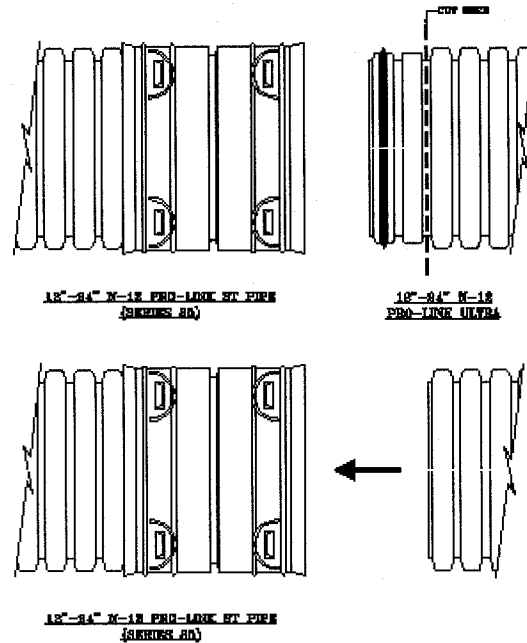


Figure 2

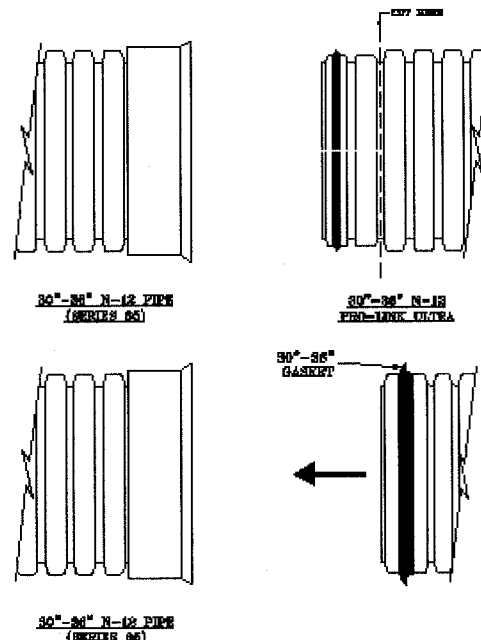


Figure 3

Should you have any questions or require further assistance, please contact your local ADS salesperson.