

Assembly Instructions

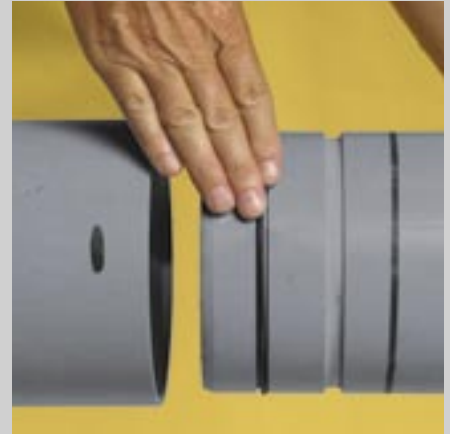
1. Do not use pipe with cracks and damaged grooves.
2. Approved lubricant should be used for easier joint assembly.
3. Use only PWEagle supplied O-rings and splines. Failure to use an O-ring on every spigot may cause leakage.



1. Clean the bell socket and spigot surfaces. Visually inspect the pipe ends for cracks, damaged grooves, etc. Do not use pipe with visible damage. Verify that the spigot end is chamfered.



2. Place the rubber O-ring in the first groove from the spigot end of the pipe. Place the O-ring in one side of the groove. Hold the O-ring in place and pull down on the other sides until it is completely in the groove. Do not roll the O-ring or excessively stretch it into place. Improper installation of O-ring may cause the joint to leak.



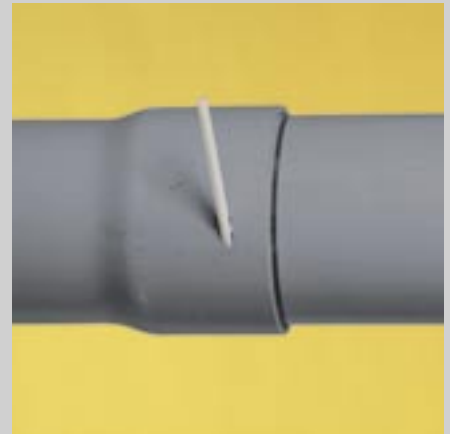
3. Apply a generous amount of lubricant around the inside of the bell lip and to the spigot end of the pipe, including the O-ring. Align the spigot to the bell and insert the spigot into the bell until the bell spline groove and spigot spline grooves are aligned. An insertion line provides an aid to the alignment process.



4. The spline groove in the spigot end of the pipe and the spline groove in the bell socket align to form a circular locking path for spline insertion.



5. Insert the pointed end of the spline into the slotted hole in the bell until the spline end is visible in the hole. Tapping the end of the spline with a hammer may be required to achieve full spline assembly.



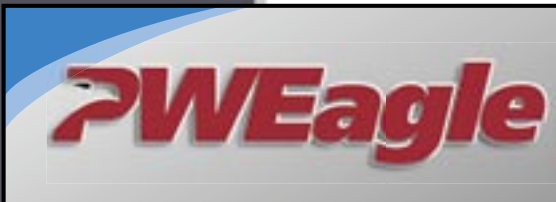
6. This completes the joint assembly and readies the pipe for installation.

PWEagle manufactures PVC pipe for a variety of applications servicing the potable water, well casing, sewer, agriculture, turf, plumbing, communications and electrical markets.

PWEagle products are available from distributors throughout the United States and parts of Western Canada. Our eleven PVC facilities in Washington, Oregon, California, Utah, Nebraska, Texas, Missouri and West Virginia assure on-time delivery.

P.O. Box 10049, Eugene, OR 97440 • (800) 347-0200 • (541) 343-0200 • FAX (541) 686-9257 • www.pweagleinc.com





Eagle-Loc™ Conduit

**SPLINE-LOCKING SYSTEM FOR
TRENCHLESS RACEWAY APPLICATIONS**



Electrical
Products

**Eagle-Loc™ Conduit
Engineered for
Horizontal
Directional-Drilling
Applications**



Eagle-Loc™ Conduit

Eagle-Loc™ Features...

Eagle-Loc™ can be utilized in any raceway application where solvent-weld PVC conduit is used.

Provides high pulling capacity with less chance of joint separation.

Unique spline-locking system forms a strong water-tight joint without cement.

Totally corrosion-free.

Spigot end is chamfered for easy assembly.

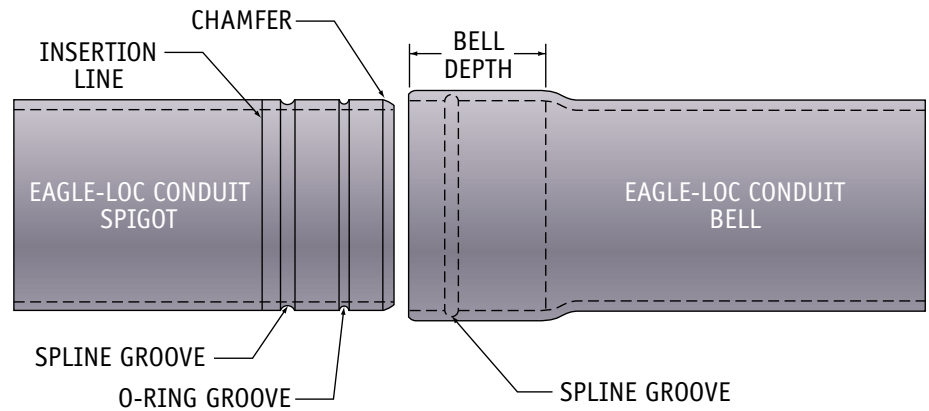
Short lengths of 10' or 20' conform to tight spaces.

Easily disassembled for reuse.

Insertion line on spigot end aids the alignment process.

Approved lubricant, splines and O-rings provided with every order.

Strong, Reliab



Schedule 40 Dimensions

Nominal Pipe Size (inches)	Average Outside Diameter (inches)	Approximate Inside Diameter (inches)	Minimum Wall Thickness (inches)	Approximate Weight (lbs/100 ft)
4	4.500	3.99	0.237	228
5	5.563	5.01	0.258	314
6	6.625	6.02	0.280	410

Schedule 40 Performance Data

Nominal Pipe Size (inches)	Typical Stiffness @ 5% deflection (lb/in/in)	Insertion Force (lbs)	Seal Pressure Rating (psi)	Joint Pull Rating (lbs)
4	326	45	75	8,500
5	219	60	75	11,500
6	154	85	75	14,500

Item and Packaging Information

Item Number	Description	Length (ft)	Feet per Crate	Feet per Truckload
460400010307	4" Sch 40 Eagle-Loc™ Conduit	10	290	16,240
460400020307	4" Sch 40 Eagle-Loc™ Conduit	20	580	16,240
460500010307	5" Sch 40 Eagle-Loc™ Conduit	10	230	11,040
460500020307	5" Sch 40 Eagle-Loc™ Conduit	20	460	11,040
460600010307	6" Sch 40 Eagle-Loc™ Conduit	10	200	8,000
460600020307	6" Sch 40 Eagle-Loc™ Conduit	20	400	8,000

le and Easy to Install

Eagle-Loc™ Conduit Accessories

Nominal Pipe Size (inches)	Pkg Qty per bag	Item Number		
		Splines	O-Rings	Combo Bag*
4"	29	4" Spline Bag	4" O-Ring Bag	4" Combo Bag
5"	23	5" Spline Bag	5" O-Ring Bag	5" Combo Bag
6"	20	6" Spline Bag	6" O-Ring Bag	6" Combo Bag

Bell Length

Nominal Pipe Size (inches)	Typical Bell Length (inches)
4	4%
5	4%
6	4%

Lubricant

Volume	Item Number
Pint	821063
Quart	821062

* Includes splines, O-rings and lube/brush.

**Ideal for trenchless
raceway applications
including:**

- **Electrical**
- **Datacom**
- **Street Lighting**
- **Traffic Signals**

Eagle-Loc™ Advantages Over Conventional HDPE

- 4" Eagle-Loc™ has a 5% larger inside diameter than 4" HDPE SDR 13.5.
- Eliminates fusion-welding each joint.
- Short lengths (10' - 20') eliminate the need for reels, providing easier transportation and safer handling with less weight and scrap waste.
- More resistant to ovalizing.
- Standard Schedule 40 dimensions of Eagle-Loc™ make it simple to terminate the run using standard solvent-cemented Schedule 40 fittings.



The splines, O-rings & lube needed for each crate of Eagle-Loc™ Conduit are packaged together and installation instructions are included. The package is then attached to the pipe crate, assuring all parts needed for assembly will arrive with the pipe.

