

Checklist of Proper Connector Installation

A•LOK STM, X•CEL, or PREMIUM CONNECTORS



Flat Spot on bottom



**Check the invert elevations
by using a common
reference point.**

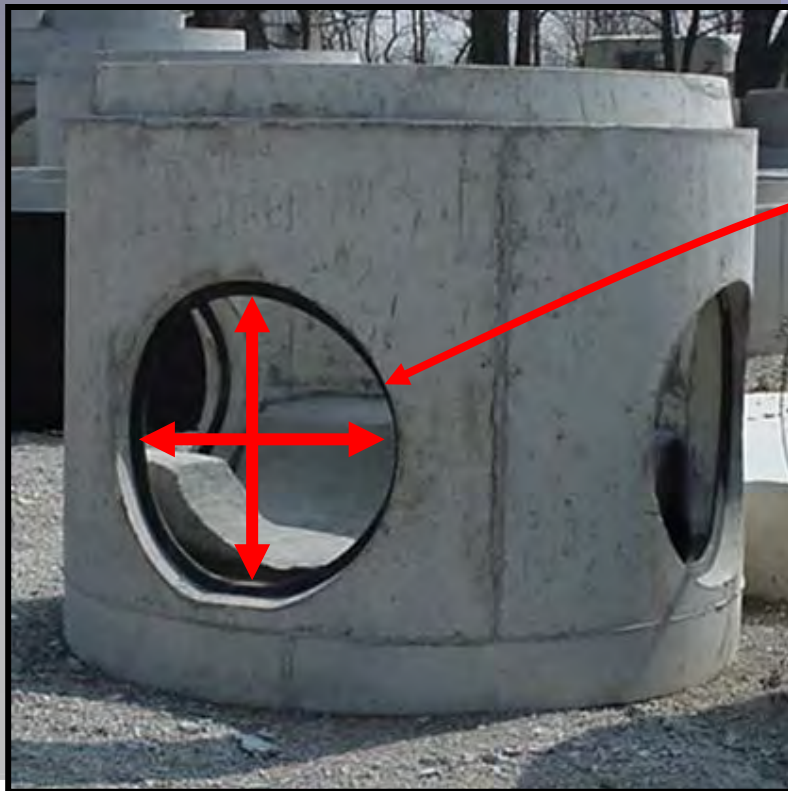
Checking Proper Embedment

A•LOK STM, X•CEL, or PREMIUM CONNECTORS

Measure the connector's inside dimension at 12 & 6 and 3 & 9 o'clock positions for concentricity

Compare measurements with our Dimensional Data Sheet

(you can click the sheet below)



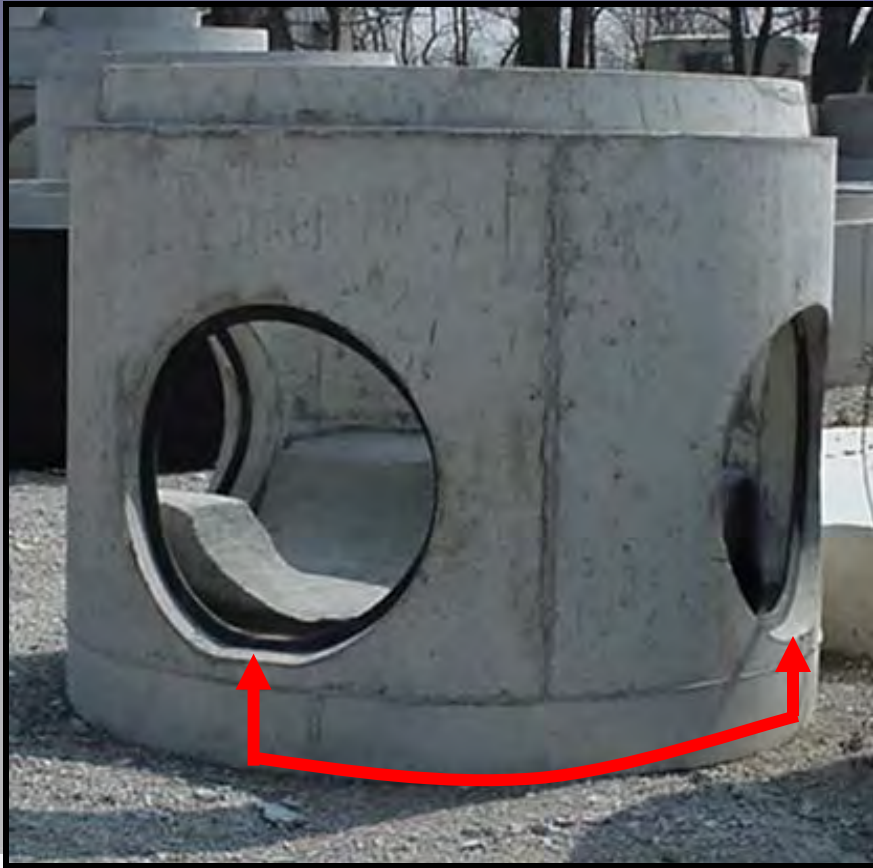
(These two measurements should be within ¼" of each other)

A•LOK PRODUCTS, INCORPORATED
DIMENSIONAL DATA SHEET

A-LOK® RING NO.	NOM. PIPE O.D. ± .25"	RING DIA. — A-LOK® I.D.	USE AS A GUIDE ONLY CHECK PIPE O.D. WITH MANUFACTURER PIPE TYPES
970	30.00"	28.00"	24" RC'B
980	30.50"	28.50"	24" SPECIAL
1000	30.75"	28.75"	24" RC (B+ .375)
1020	31.25"	29.25"	30" PVC
1030	31.50"	29.50"	24" RC'C; 30" PVC (F679)
1035	31.625"	29.625"	24" SPECIAL
1040	32.00"	30.00"	30" PVC (F794); 30" DI
1050	32.375"	30.375"	27" VC
1070	32.875"	30.875"	24" RC (C+.750)
1090	33.50"	31.50"	27" RC'B
1100	33.80"	31.75"	30" PVC (A-2000)
1110	34.25"	32.25"	27" RC (B+.375)
1130	35.00"	33.00"	27" RC'C
1140	35.25"	33.25"	27" RC; 33" PVC (F679)
1160	35.75"	33.75"	30" SP 5
1200	37.00"	35.00"	30" RC'B
1210	37.50"	35.50"	30" RC (B+.250)
1220	37.70"	35.70"	36" PVC
1230	38.00"	36.00"	30" RC (B+.50)
1235	38.375"	36.375"	36" PVC (F794)
1240	38.50"	36.50"	30" RC'C; 36" DI
1250	38.75"	36.75"	30" RC
1260	39.00"	37.00"	30" RC (C+.25); 36" PVC (F679)
1280	39.50"	37.50"	30" RC
1310	40.50"	38.50"	33" RC'B; 36" (PSCP) TYPE B
1320	40.75"	38.75"	36" PSCP
1330	41.125"	39.125"	36" SP
1350	42.00"	40.00"	33" RC'C
1360	42.25"	40.25"	33" RC + .25
1370	42.50"	40.50"	36" SP 5
1390	43.25"	41.25"	42" FIBERGLASS

Checking Proper Angle Placement

A•LOK STM, X•CEL, or PREMIUM CONNECTORS



Check angle placement of connectors by measuring the center to center dimension of the connectors.

The angle can be determined by the following formula:

$$\frac{\text{Structure OD} * \pi}{360} = \frac{\text{inches}}{\text{degree}}$$



PRE-POUR INSPECTION

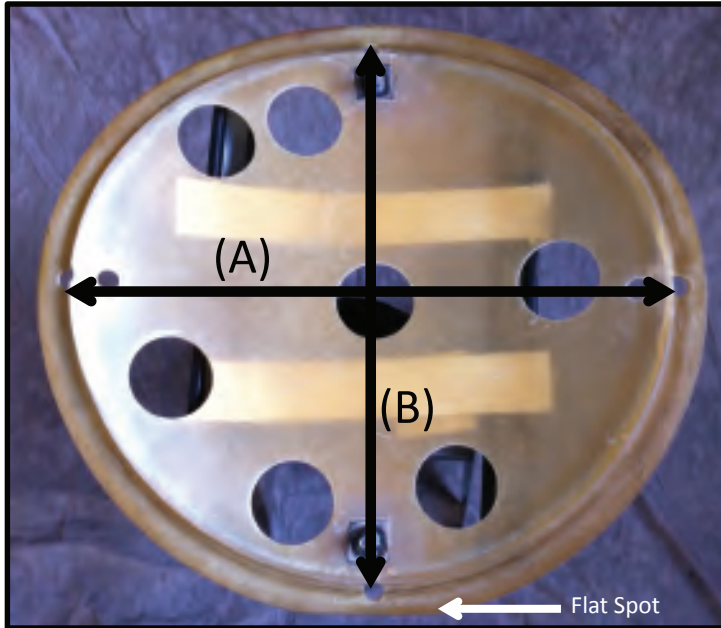
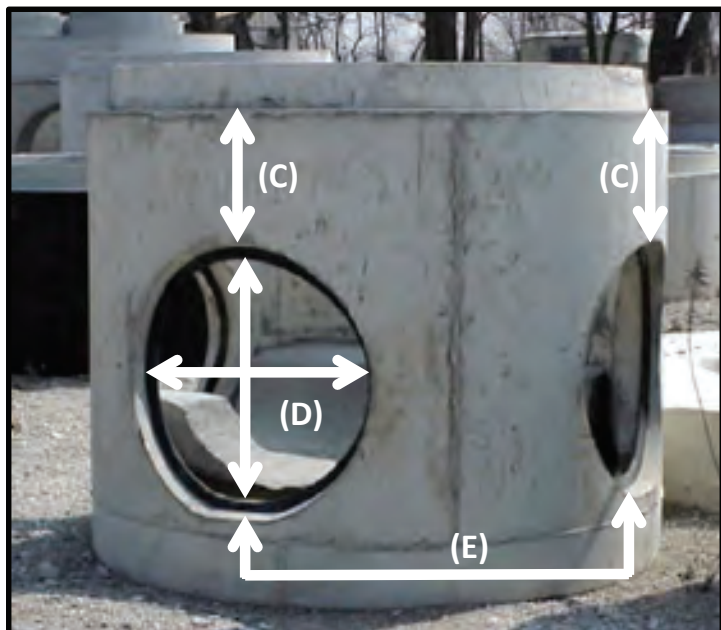


Fig.1 - Outside Mandrel Half

1. Determine your parts are correct by checking the pipe O.D. using the A-LOK Dimensional Data Sheet where you will find the correct connector and mandrel.
2. Measure the offset of the outside mandrel half at the 3 & 9 (A) and 6 & 12 (B) o'clock positions to check for roundness. These measurements should be within 1/4" of each other.
3. To identify the mandrel, locate the measurement from the 6 & 12 o'clock position (B) in the mandrel I.D. column on the A-LOK Dimensional Data Sheet. The connector and mandrel should have matching part numbers.
4. After the connector has been installed on the mandrel, measure the width of the mandrel at the 12 o'clock position (Fig. 2) to determine the wall thickness.
5. Check to make sure the mandrel locations, angles and heights match the plans.



Fig. 2
A-LOK Connector
Mounted on Mandrel



A-LOK Connectors Cast-in Manhole

POST-POUR INSPECTION

1. After stripping from form, check correct placement and heights to make sure no movement or shifting has occurred by using a common reference point (C).
2. Measure the connector's inside dimension at 12 & 6 and 3 & 9 o'clock positions for concentricity (D). These measurements should be within 1/4" of each other. Compare measurements with our Dimensional Data Sheet.
3. Check angle placement of connectors by measuring the center-to-center dimensions of the connectors (E). The angle can be determined by using the following formula:

$$\frac{\text{Structure OD} \times \pi}{360} = \frac{\text{inches}}{\text{degree}}$$

4. Visually check connector for consistent embedment all the way around and to ensure it is not damaged. Make sure the flat spot is on the bottom (B).



Manhole Quality Assurance Worksheet

Manhole Number	Pipe Penetration Degree	Invert Elevation	Type of Pipe	Pipe OD	A-LOK Connector Number	A-LOK Ring ID Measurement	A-LOK Ring OD Measurement	Actual Mandrel ID Pre-pour		Date	Actual Connector ID Post-Pour		Date	PASS/FAIL and Initials
								12-6	3-9		12-6	3-9		

The back of this worksheet has detailed information and instructions depicting how to achieve the correct measurements regarding Pre-Pour and Post-Pour Quality Assurance.

Please call A-LOK with any questions at (800) 822-2565.