

## **Rubber Expansion Joints - Onsite Drilling Procedure**

1. Install the expansion joint between pipe flanges and temporarily secure/support in place.
2. Align one of the drilled flanges of the expansion joint with the pipe flange. For proper alignment insert bolts every 2nd or 3rd bolthole.
3. Align the opposite flange of the expansion joint with the pipe flange. For proper positioning, the flange OD of the expansion joint must be aligned with the OD of the pipe flange all the way around.
4. If lateral misalignment is present it may be necessary to rotate and/or pull the expansion joint slightly to align flanges. Wrap a 3" wide cloth sling at the base of the undrilled flange. Gradually pull the expansion joint until OD's are aligned.
5. Mark the boltholes in the flange of the expansion joint.
6. Mark the orientation of the expansion joint in reference to the pipe flange.
7. Remove the expansion joint and drill the boltholes by placing the joint on a smooth and level surface. Place wooden blocks between the flanges to support the top flange. Cautiously use a fine tooth keyhole saw drill bit, at slow speed in the reverse direction, using a soap and water solution to reduce friction.
8. If necessary, coat the drilled boltholes with black elastomeric cement and allow two hours minimum to dry.
9. If necessary, coat the bolt holes with blue, acrylic, ozone resistant, paint and allow two hours minimum to dry.
10. Install expansion joint utilizing the proper bolting sequence.
11. Inspect the exterior of the expansion joint for any areas stripped of blue paint and touch up.