



## Cutting pipes

PREIS® SML socketless cast iron pipes are delivered with a length of 3m to be cut at any length directly from the personnel working with the material. The cuts must be carried out bearing in mind the function of the joint that will be made. The cut must be perpendicular to the pipe length, smooth, clean and even. If necessary the cut face should be deburred to ensure a perfect seal for the connector.

Some form of clamping jig will be needed to ensure that the cut is truly perpendicular. This will establish the positioning and clamping of the pipe. The following tools are suggestions of common cutting methods:

- **Bandsaw/circular saw/mechanical hacksaw:** Transportable electrical saws with clamping jig ensure a nearly perfect perpendicular cut.
- **Angle grinder:** An angle grinder with a cutting disc for cast iron should only be used in conjunction with a suitable clamping jig.
- **Pipe cutter:** The pipe cutter has the clamping jig integrated in the tool and allows a fast, clean and perpendicular cut. The tool needs no electrical connection, but there is the risk of damage to the pipe due to high pressures caused by worn cutting discs and excessive feed rates.

### NOTE:

- Appropriate protective clothing must be worn whilst working!
- The relevant safety regulations must be obeyed!
- Saw blades and cutting wheels must be changed regularly!
- The appropriate assembly instructions must be considered (e.g. protection of the cut edges).



## PREIS®PEP (Pipe Edge Protection)

### Fields of application:

Cut edge protection for PREIS® cast iron drainage pipe system, during tests for PREIS® KML according DIN EN877 and RAL-GZ 698 successful practice-tested.

### Advantages:

- liner release with finger-lift for quick and easy removal of the backing paper
- quick and easy application to the cut edge
- no drying time, therefore quick installation without delays

### Materials:

- butyl rubber with special polyethylene foil
- parts separated by silicone foil with finger tabs for easy use

### Characteristics:

- largely resistant to chemicals
- good adhesion
- permanently flexible
- impermeable
- aging resistant

### Warehousing:

- cool (+5°C to +25°C), dry and protected from UV light
- minimum storage life 24 months (+5°C to +25°C)

### Temperature for use:

applicable at +5 ° C to +40 ° C

### Instructions for use:

- first read and follow installation instructions
- use PREIS® PEP according application instructions



## Application pipe edge protection

### PREIS® PEP application instructions:

1.

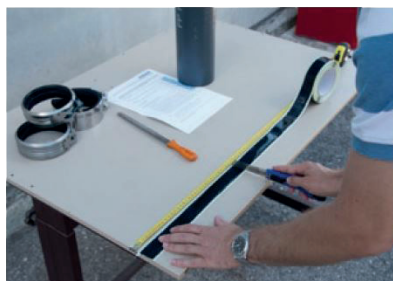


2.



Clean the pipe surface inside and outside 3 cm wide until it is dry and free from grease and dust.

3.



Roll up **PREIS® PEP** and cut the length according to the DN in table on the last page.

4.



Expose half of the adhesive side of the tape.

5.



Apply **PREIS® PEP** to the inside of the cut pipe, taking care that the application is straight, so half the width (about 15 mm) extends beyond the pipe edge.

6.



Taking care to avoid creases, press **PREIS® PEP** firmly to the inner surface and remove remaining protection.

7.



Firmly press **PREIS® PEP** on to full internal pipe circumference taking care to avoid creases or tension.

**Attention: PREIS® PEP must not be stretched – avoid any tension!**

8.



The ends of **PREIS® PEP** should overlap about 10 mm, an open gap is not allowed.

9.



Fold **PREIS® PEP** from the inside out and firmly press to the whole circumference of the outside of the tube until the cut edge is completely covered by **PREIS® PEP**.

10.

If necessary loosen the clamping screw, apply the coupling on the pipe end and tighten the screw.



**DONE!**

*Technical modifications and printing errors excepted.*

## Assembly and installation instructions

**PREIS® SML pipes, fittings and coupling systems are produced and inspected according to EN 877. The SML pipes are cut to the required length directly from the personnel working with the material. Pipes and fittings are joined with suitable pipe clamps.**

Horizontal pipes have to be adequately fastened at all turns and branches. Downpipes have to be fastened at a maximum distance of 2 m. In buildings with 5 floors or more, the downpipes of DN 100 or larger should be secured against sinking by means of a downpipe support. Additionally, for higher buildings a downpipe support should be fitted at every subsequent fifth storey.

Drainage pipes are planned as unpressurized gravity flow lines. However, this does not exclude the pipe to be under pressure if certain operating conditions occur. As drainage and ventilation pipes are subject to possible interactions between the pipes and their environment, they have to be permanently leak-tight against internal and external pressure of between 0 and 0.5 bar. To sustain this pressure, those pipe parts subject to longitudinal movement must be fitted along the longitudinal axis, properly supported and secured.

This kind of fitting has to be used whenever interior pressure exceeding 0.5 bar may arise in the drainage pipes, such as in the following cases:

- **Rainwater pipes**
- **Pipes in the backwater area**
- **Wastewater pipes which run through more than one basement without further outlet**
- **Pressure pipes at wastewater pumps.**

Non-friction-fitted pipelines subject to possible internal pressure or pressure developing during operation. These pipes must be provided with a suitable fixture, above all along the turns, to secure the axes from slipping apart and separating.

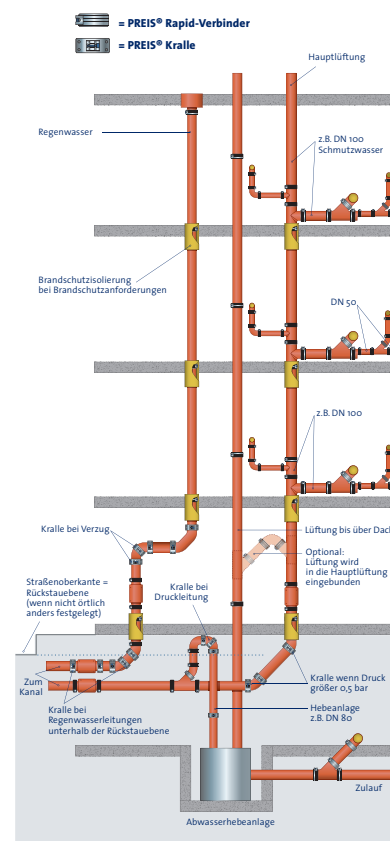
The required resistance of the pipe and fitting connections to longitudinal forces is achieved by installing additional clamps (internal pressure load up to 10 bar possible) at the joints.

*Further information on technical issues can be found in our brochure for technical specifications and details.*

### Note:

- PREIS® PEP is not resistant to oils and organic solvents (e.g. fuel).
- If necessary, loosen the clamping screw of the connector before application.
- PREIS® PEP must always be used for cut edges in KML pipes.
- PREIS® PEP is also recommended as cut edge protection for SML pipes.
- Keep out of reach of children!

*More information on proper handling of PREIS® drainage system can be found in our technical documentation under [www.preisgroup.com](http://www.preisgroup.com).*



**Table cut length**

DN	cut length PREIS®PEP [mm]	yield PREIS®PEP [edges/tape]
50	170	58
70	230	43
75	220	45
80	250	40
100	330	30
125	410	24
150	490	20
200	640	15
250	840	11
300	1000	10