

Installation Guide — AB&I Foundry Caulking Instructions

Caulking Instructions

1. Insert the spigot end of pipe or fitting into the hub of pipe or fitting to be joined after wiping the hub and spigot with a clean cloth to assure the hub and spigot are clean and dry.

2. Yarn the oakum into the joint using a yarning iron. Some oakum comes in twisted lengths and may need to be separated into individual strands before yarning. Yarn and pack the oakum tightly using a packing iron to a depth of one inch below the top of the joint. Tightly packed oakum is essential for a leak free joint.

Note: After packing, make sure that no oakum fibers are sticking up into the area the lead will occupy. Fibers in the lead area can cause leaks.

3. After heating lead pot to a cherry red color, clean dross off the top of the lead and fill your ladle with clean, molten lead. Quickly pour the lead into the joint with one continuous pour, filling the joint completely.

4. After the lead has solidified, the joint must be caulked to “set” the lead. Using your outside caulking iron, place the iron against the inner edge of the hub and caulk the lead completely around the circumference of the joint. After caulking with the outside iron, you are ready to caulk using the inside iron. The inside iron should be placed against the pipe. Caulk the lead completely around its circumference.

Note: Care should be taken to not crack the hub by caulking too heavily. Proper safety equipment and attire are required. AB&I Foundry does not recommend the use of lead as it has been found to be hazardous to health and the environment.

