

## X-GATE™ LOW HEAD CANAL GATES

### Low Head Spigot Back Gate

#### Installation Guide for Spigot Back Gate to Corrugated Pipe

- 1 - Place spigot back gate over corrugated pipe, making sure the pipe and gate are perpendicular.
- 2 - Drill holes through corrugated pipe using holes in spigot back gate as a template (13/32" or 7/16" drill bit).
- 3 - Secure the gate to corrugated pipe using either galvanized Grade 5 steel bolts or stainless 304 bolts and nuts. *Forcing Bolt May Cause Damage to Gate.*
- 4 - Apply a mastic sealant to joint in between corrugated pipe and gate (See Detail X).
- 5 - Brace both pipe and gate as necessary. Deflection and distortion of corrugated pipe may cause the gate to leak.
- 6 - Place braced coupled gate and corrugated pipe into ditch or trench, then back fill or pour as required ensuring that gate is vertical from the centerline opening.
- 7 - Remove bracing, check and clean gate seat to make sure proper full periphery seating is achieved. (Use .004 feeler gauge.)
- 8 - Check the gate for any type of damage or irregularities.
- 9 - Gate is now ready for operation.

**NOTE: Gates and Pipe Are Heavy! Use Care and Good Working Practice in Assembly and Installation.**

