



Title	Guidelines for Pressure Cleaning the Internal Diameter of Ductile Iron Fittings
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SIP Industries does not recommend the use of pressure washing for cleaning the internal diameter of ductile iron fittings. Although research shows no significant damage in testing, the decision to pressure wash, if made by the customer, engineer or installer, may present some risk of damage to the sealcoat and/or cement-mortar lining or any other special lining or internal coating such as Protecto™ 401. Any such risk is dependent on water pressure, speed, jet design and angle to the lining, distance of the jet from the lining, and other factors. SIP Industries does not warrant or guarantee the result or assume any risk or liability associated with pressure washing the internal diameter of ductile iron fittings.

If the customer, engineer or installer decides to use pressure washing for cleaning the internal diameter of ductile iron fittings and assumes all risk and liability, SIP suggests you review the guidelines below by the Ductile Iron Pipe Research Association Guideline for Pressure Cleaning the Internal Diameter of Ductile Iron Pipe Technical Advisory (May 2016):

Guidelines are as follows:

1. The nozzle shall be configured with fan jets only (no round jets).
2. The fan jets should be oriented at a maximum angle of 30 degrees to the fitting wall.
3. The nozzle shall be a minimum of 2-inches standoff from the fitting surface.
4. The nozzle assembly shall be self-rotation and incorporate a rotational control mechanism – with a target speed of 30 rpm.
5. The water pressure at the nozzles shall be no more than 1,800 psi.
6. The nozzle assembly shall have non-abrasive wheels and/or UHMW (ultra-high molecular weight) polyethylene skids positioned so that at no time does the nozzle assembly contact the lining of the pipe.
7. The nozzle assembly shall continually move when pressure washing with no hesitation in the pipe.
8. All hose couplings, hoses, etc. shall be smooth to facilitate movement across the pipe joints without creating damage to the lining. Fitting diameters of 24-inch and larger may require additional passes for effective cleaning.

Note: Even after following these guidelines SIP Industries does not warrant or guarantee the result or assume any risk or liability associated with pressure washing the internal diameter of ductile iron fittings.

