



FREQUENTLY ASKED QUESTIONS

CERTA-SET® GENERAL

Q: Can you install Certa-Set from any direction?

A: Yes. You can install Certa-Set from either direction. The O-ring seal works flawlessly, regardless of the direction of flow.

Q: Can you remove Certa-Set from any direction?

A: Yes. The Certa-Set coupling does not have a distinct direction. You can simply remove the spline on the side you wish to remove and separate the joint of pipe.

Q: Do you have an end plug that would allow me to flush my lines?

A: Yes. Contact your distributor or local Certa-Set Territory Manager for the proper solution.

Q: Is system automation possible?

A: Yes. With the Nelson TWIG system, you can even run your system from your smartphone. Contact your distributor for more information.

Q: Do I need to use an AIM retriever machine to remove pipe from a field?

A: No. Although the AIM system is the easiest way, you can also pull pipe to an adjacent field using a tractor with a strap.

Q: Why does the Certa-Set system have valves every 80' instead of every 40'?

A: With the efficiency of the Nelson Valve, you can run twice the laterals using half of the valves you would normally use. This allows you to use swing joints to make the pipe easier to disconnect and reconnect for mechanization.

Q: Can I use both sprinkler and drip for my high value crops?

A: There are many growers that germinate a crop or transplant and then establish the crop, and then shift to drip to finish the crop.

Q: Can I modify or repair the pipe?

A: For 3" Certa-Set, use a Pipe Repair Fitting (PN 715877) to repair damaged pipe or to create customized lengths. Field grooving and beveling are not recommended.

It is acceptable to cut and bevel 8" pipe and larger. For 6" pipe and smaller, use a Pipe Repair Fitting (PN 705335) to repair damaged pipe or create customized lengths. Field grooving and beveling are not recommended for 6" pipe and smaller.

Q: Do I need to lubricate the O-rings?

A: Although all rings are Teflon®-coated to ease assembly and disassembly, Westlake Pipe & Fittings recommends that a small amount of pipe lubricant be applied to the rubber O-rings and pipe ends when assembling Certa-Set pipe.

IMPORTANT – At no time should any oil-based lubricant be applied to the spline or placed in the spline groove. Oil-based lubricants placed in those areas will reduce the strength of the restrained joint and potentially cause the spline to swell, causing premature breakage.

Q: Can I use rotator-type sprinkler heads?

A: The Certa-Set solid set system is designed to use rotator sprinklers installed on risers. You may use Certa-Set risers safely for this application.



FREQUENTLY ASKED QUESTIONS

CERTA-SET® MAINLINE

Q: Is the main line difficult to install and remove?

A: No. While it is different than its aluminum counterpart, it is a watertight seal and therefore requires a different level of force to seal and unseal. It can be assembled and disassembled using standard equipment. Consult the Main Line Installation Guide for further information.

- Pipe can be shallow-buried and farmed around on a semi-permanent basis.
- Pipe can be plowed out, the ground can be worked, and the pipe can be reburied — all mechanically.

Q: How deep should I bury my main line?

A: While some people drive directly on top of the pipe, it is recommended that you have $\frac{3}{4}$ of the pipe diameter cover over the pipe. Trenching can be easily accomplished with a blade in most soils.

Q: Are there any special bedding/trenching requirements for main line?

A: No, but ensure that your trench is free of debris and rocks for best results.

Q: Do I need a special tool to insert or remove splines?

A: 8", 10" and 12" Certa-Set couplings are typically supplied with half splines, which do not require tools to install or remove. You may use a Spline Insertion Tool that can be purchased from your Certa-Set distributor.

Q: How do I separate the coupling from the pipe?

A: Remove the spline(s). Attach a strap to the pipe and pull with a truck or tractor. Mechanized equipment is available from a variety of sources as well. Please consult the Main Line Installation Manual for further information.

Q: Can I pull sections of main line?

A: Yes — typically up to 500' sections depending on terrain and application.

Q: Can I drive over the main line?

A: Certa-Set SDR 32.5 (Yellow Pipe) can be set in the field and tractors can pass over it. However, please take extreme care to avoid driving over any of the couplings, as they should NOT be driven over. If farm implements are intended to be driven over the Certa-Set SDR 32.5 Class 125 main line pipe, the pipe must be installed in V-cut trench, which covers at least $\frac{3}{4}$ of the pipe diameter. Care should be taken to avoid pipe external loading or impacting with any equipment that would lead to a permanent deformation.

Under no circumstances should you drive over Certa-Set Emerald (Green Pipe) Class 100 main line pipe.

Q: Can I field groove a 6" Class 125 (Yellow) main line pipe?

A: The 6" Class 125 main line is produced with thickened ends to accommodate the Certa-Set groove while maintaining the designed pressure rating. Grooving the non-thickened pipe body will result in less-than-designed pressure rating for the new joint and ultimately the entire system. When fabrication is required for 6" Class 125, apply a Certa-Set coupling by solvent weld or a Certa-Set adapter.



FREQUENTLY ASKED QUESTIONS

CERTA-SET® 3" LATERAL

Q: How does 3" Certa-Set arrive at my farm?

A: The pipe will arrive in bundles of 58 pieces, 928 to a truck. The couplings and risers will arrive in boxes. See the Lateral Field Preparation Guide for more information on preparation.

Q: How can I "farm under the pipe"? Are there specifications on the rollers required?

A: The rollers should support the pipe on three sides and have a wide enough opening for the sled coupling to pass through with at least 1/2" of clearance. The roller assembly should be mounted inline with the pipe row and as low as possible above the toolbar.

Q: My risers aren't staying straight when going through the rollers. What can I do?

A: Ensure that the pipe and rollers are perfectly aligned with the center of the furrow. Reduce tractor speed to verify that the pipe is smoothly lifting and setting down.

Q: How can I farm under the pipe with big beds, as the pipe is in a wheel row?

A: Typically, you would use two sets of rollers. You will need to go up, over and around the wheels of the tractor and slightly inside of the furrow to ensure that the pipe drops in the center of the furrow. Contact your distributor and local Certa-Set Territory Manager for an on-farm consultation.

Q: How fast can I move implements while farming under the pipe?

A: The speed varies based on the equipment setup. If you have a straight run and a low toolbar, you will be able to go at a higher speed. If you are working with pipe in a wheel row, you may have to start at a slower pace. Contact your distributor and local Certa-Set Territory Manager for an on-farm consultation.

Q: How do I prepare the lateral pipe for working under it?

A: Remove the swing joint from the Nelson Valve. Turn the tee facing upwards. Remove the end plugs and drain the lines.

Q: How do I reconnect the lateral pipe after working under the pipe?

A: Reconnect the swing joint to the Nelson Valve, reconnect the opposite end to the tee and replace the end plugs.

Q: Help! My pipe has shifted forward after working under it. How do I get it back into place?

A: Minor shifts are normal and are typically able to be compensated with the swing joint. If not, pull the pipe the required distance from the end of the field using a strap with an ATV or tractor.

Q: What is the maximum distance that pipe can be side-shifted?

A: Pipe can be side-shifted up to 20' if the pipe is kept low to the ground.

Certa-Set pipe and sled couplings may be mechanically shifted. The rollers and guides must provide an uninterrupted passage of pipe and couplings. Rollers and guides need to be manufactured from materials such as rubber or urethane, which exhibit absorptive properties. There must be no knocking or abrupt contact with the couplings during shifting.

Q: What is the maximum length of 3" Certa-Set that can be pulled?

A: 3" Certa-Set can be pulled up to 1/2 mile or 88 joints. Note: Always drain the lines before pulling the pipe.



FREQUENTLY ASKED QUESTIONS

CERTA-SET® 3" LATERAL

Q: Do I need to drain the pipe before moving it?

A: Water needs to be drained from the 3" lateral pipe before drag or mechanical retrieval. Failure to do so will result in spline override, with resulting coupling damage. Also, failure to drain water in drag applications will cause severe abrasion to the sled coupling and pipe over time. To remove water, simply remove the Certa-Set end plug (Part No. 745607) and allow the water to drain.

Note that it is not required to drain the water when performing a lateral mechanical shift of up to 20 feet.

Q: Can I drive over 3" Certa-Set lateral pipe?

A: No. Under no circumstances can you drive over 3" Certa-Set lateral pipe. Doing so will damage the pipe.

Q: Is it ever necessary to remove the sprinkler risers?

A: All risers must be removed from the couplings prior to drag movement in heavy foliage installations, as under certain crop conditions foliage can become entangled with the risers, resulting in excessive deflection (stress) on the coupling boss during movement. Any excessive deflection can result in possible breakage at the coupling boss.

Q: How much can the pipe deflect during lateral movement?

A: During mechanized lateral movement of the 3" Certa-Set pipe, pipe offset must not exceed 40 inches per 20 feet of pipe. Exceeding this level will place excessive stress on the sled coupling at the spline groove, resulting in premature coupling breakage.

CAUTION – Under no circumstances should any farm implement (tractor, mower, etc.) be used to impact the coupling or pipe for the intended purpose of lateral or directional movement. Additionally, no farm implements are to be driven over the 3" lateral pipe.

Q: Can I use non Certa-Set piping components to modify the system?

A: Westlake Pipe & Fittings will not assume any responsibility or liability for damage directly or indirectly resulting from the failure to serve the intended purpose of any component, such as saddles, which are used to modify Westlake Pipe & Fittings's standard products.

Q: Can I repair 3" Certa-Set lateral pipe?

A: To repair Certa-Set lateral pipe broken ends, first make a square cut on the broken pipe end to ensure proper alignment in the repair fitting. Solvent-Weld Part Number 715877, Certa-Set Male x Solvent Weld Bell, onto the cut end of the pipe. To repair breaks in the middle of the pipe, make a square cut on both of the broken pieces and solvent weld both cut ends into Part Number 715969, Certa-Set Solvent Weld x Solvent Weld Coupling.