

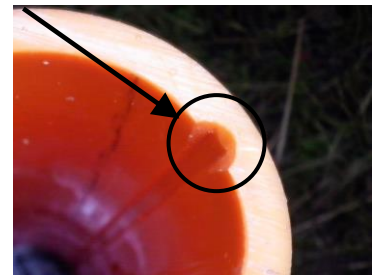
**Step 1**

First you will need to cut the end of the casing at 90° to its axis, this needs to be as accurate as possible. The best way to do this is to wrap some tape round the tube, if done neatly it will form a nice line to cut along.



**Step 2**

Now the end of the casing needs to be de-burred inside and out to leave a clean finish. Then using a round file, file a lead in on each keyway as shown.



**Step 3**

Place the coupling along side the casing and mark it at the half way point of the coupling. Slide the coupling over the casing using the spline for alignment. Using a 3.3mm drill bit, drill through one of the holes in the coupling for the rivet to pass through.



#### **Step 4**

Rivet the coupling in place, now it is secure you can drill and rivet the other 3 holes.



#### **Step 5**

Now the female end of the new casing needs to be prepared, repeat steps 1 and 2 for the female end ensuring you remove at least 65mm to leave solid material.



#### **Step 6**

Now slide the new casing into the coupling, using the spline for alignment. Make sure it is all the way in and drill and rivet the four holes.



#### **Step 7**

Finally wrap the whole joint with Denso tape or similar sealing tape/sealant to seal and waterproof the repair joint.

During any stage of the installation Soil Instruments will be pleased to offer advice.  
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