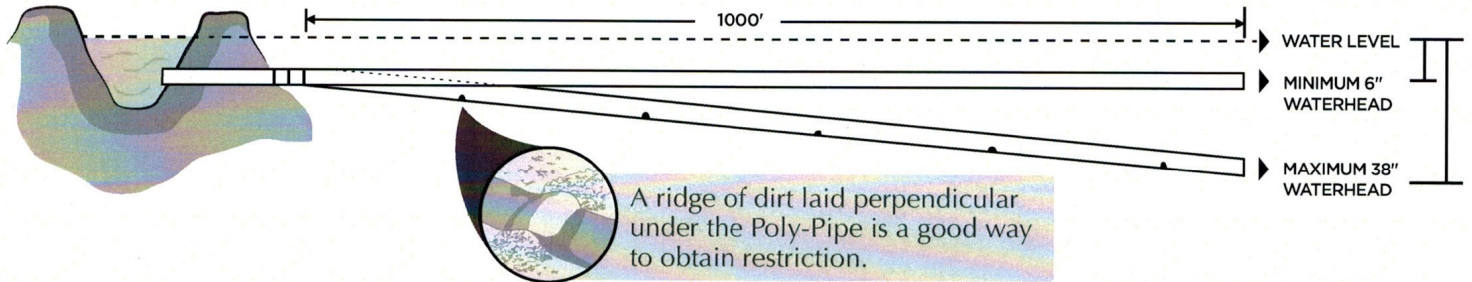


Poly-Pipe is primarily designed for use with level grade farming and it will not transfer water over hills or up grades. Most standard headlands are level or have a slight downgrade and are perfect for Poly-Pipe.

**Prior to installation,  
please read the instructions in their entirety.**

## SLOPED HEADLAND



### RESTRICTIONS FOR SLOPED HEADLAND (more than 2' per 1000' drop)

Headlands with downgrades of more than 2 feet per 1000 feet may need intermittent restriction in the Poly-Pipe line to ensure even water flow to the crop rows.

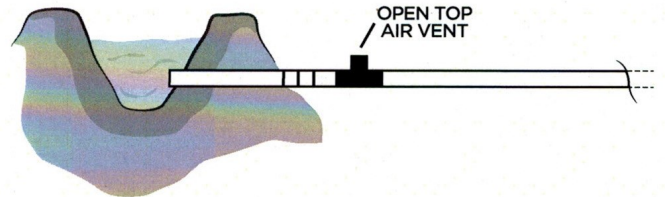
### HAVE SUFFICIENT WATERHEAD (Level or Slight Grades)

Head is the water surface height above ground level. At least 6 inches of head is required for water to enter smoothly into the tubing and transfer across level or slight downgrade headlands.

## PRESSURE RELIEF VENTS

### PRESSURE RELIEF VENTS

The use of an open topped air vent is advised at the connection point of the tubing. The vent allows excess trapped air to escape, thus, avoiding burst damage in the tubing. On long tube runs, pressure relief vents are required to avoid damage to your tube.



While pumping, toothpick size holes should be made in the top of the Poly-Pipe to bleed off excess air where air pockets are visible. This will prevent rupture. Small holes or gates can be installed in the pipe at alternate furrows. The holes can be punched in one or both sides. After each use, puddle water remaining in the pipe holds it in place.

### PUMP WATER SOURCE

Most irrigation tube installations should include placement of an air vent 10 feet from the discharge pipe as well as on high spots.

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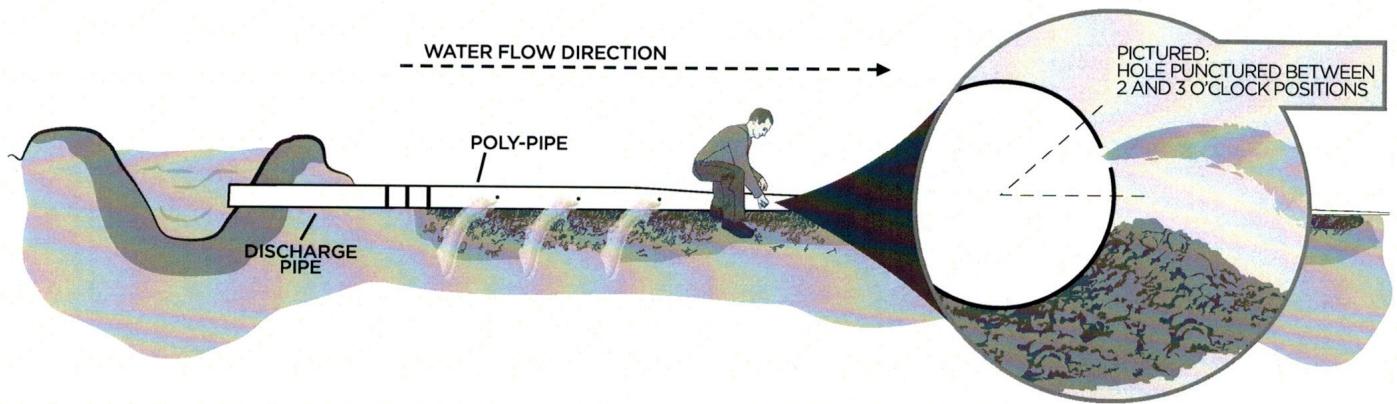
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# OPERATION

## OPERATION

Begin with a small water flow and gradually increase to a full rate. As the Poly-Pipe tubing is filling (starting from the intake end of the tubing) punch gate holes or install adjustable gates as required. Consult your local dealer or county agent for recommended flow rates for your soil type and conditions. The gate holes or adjustable gates should be installed between the 2 and 3 o'clock or the 9 and 10 o'clock position depending on the water flow.

**Note: These instructions are general and act only as a guide for installation. Due to environmental and field condition variance, some steps may not apply to your particular operation. If you have any questions, please call your local dealer.**

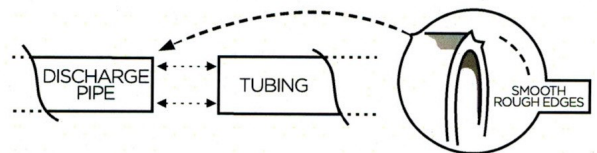


## CONNECTION INSTRUCTIONS

1

### Check size and surface of pipe

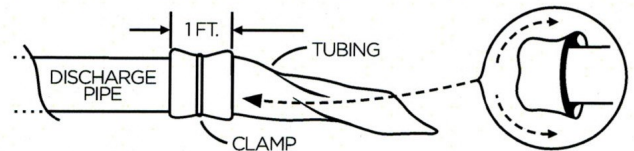
The diameter of the discharge pipe must correspond or be smaller than the Poly-Pipe that is to be attached. Rough or sharp edges should be smoothed or taped before the connection.



2

### Fold back tubing

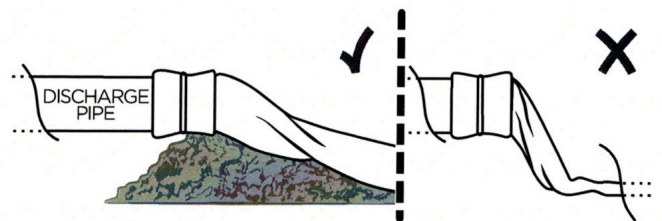
Cuff approximately 1 foot of Poly-Pipe onto itself to form a double thickness over the pipeline. Secure with a hose clamp.



3

### Give support to tubing

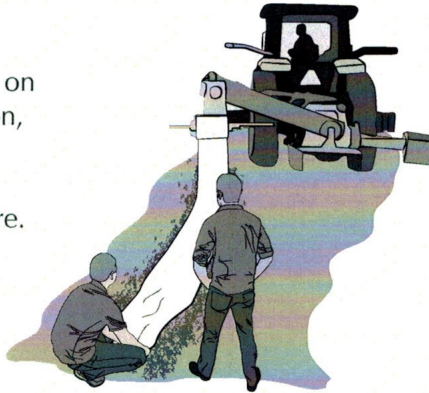
Make sure the connection is at ground level or supported with dirt so the Poly-Pipe does not hang off the connection. Slack should be left at the water source to keep the tubing from pulling off the connection.



## TUBE LAYING INSTRUCTIONS

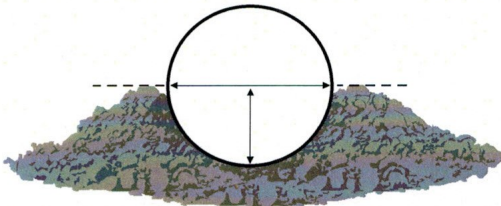
### 1 Ease initial strain on connection

To ease the initial strain on the discharge connection, have someone hold the tubing until the pulling tension is no longer there.



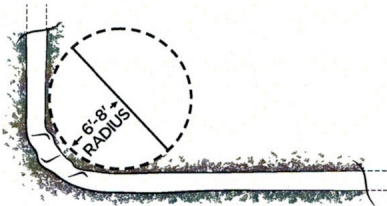
### 2 Trenching

Poly-Pipe must be laid evenly in a continuous trench 3 to 5 feet deep. The trench prevents the Poly-Pipe from rolling when filled with water. Make sure the trench is clear of anything that can puncture the pipe.



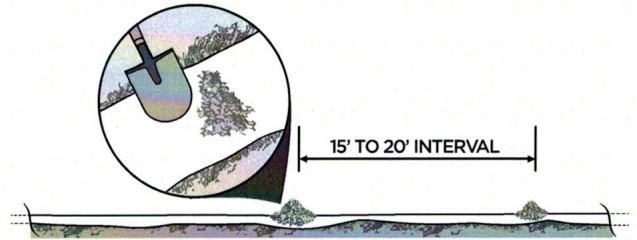
### 3 90° turns

Poly-Pipe is flexible enough to complete a 90 degree turn in a 6 to 8 foot radius.



### 4 Keep tubing in place

A shovel of dirt every 15 to 20 feet will keep the tubing in place during installation as well as maintaining proper tension for smooth unrolling of the tubing.

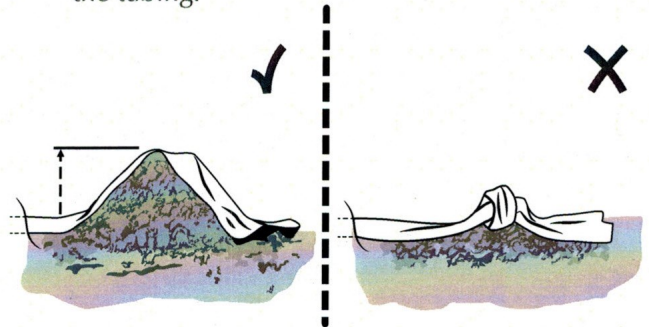


### 5 Tube end

For irrigation, the open discharge end of the Poly-Pipe tubing should be placed over a berm approximately 3 feet in height. This will prevent a build-up of excess pressure in the tubing and avoid damage to the system.

### 6 Do not tie tube end

The eventual pressure build-up will burst the tubing.

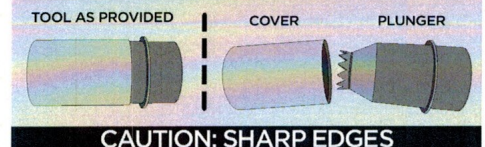


## ADJUSTABLE GATE INSTALLATION INSTRUCTIONS

### 1 Assemble Tool (as shown in steps A and B)

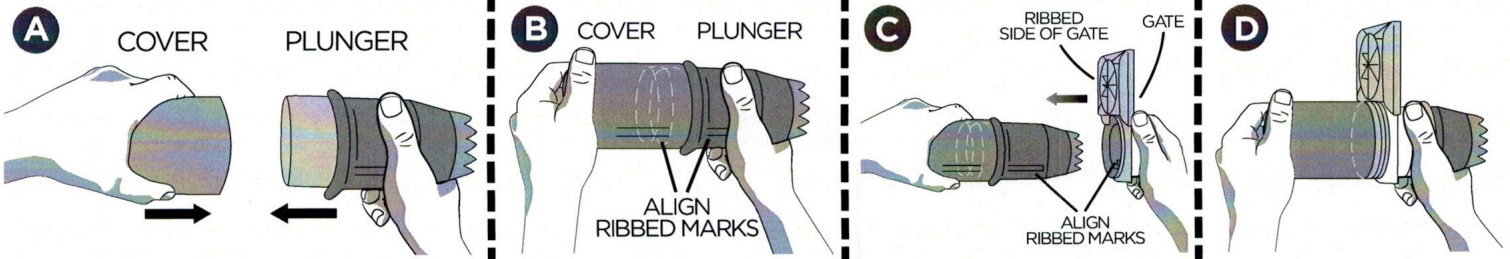
Align groove on plunger with cover and assemble as shown in illustration below.

PULL APART PLUNGER AND COVER TO MAKE TOOL



#### IMPORTANT:

Position gate with **ribbed** side facing the tool. Align gate with groove on plunger and slide into position. (Steps C and D)

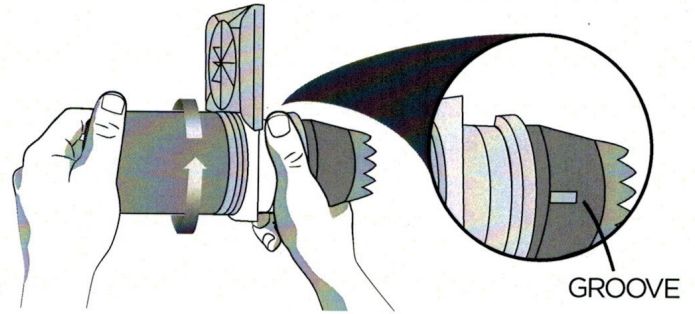


# ADJUSTABLE GATE INSTALLATION INSTRUCTIONS continued

**2**

## Adjust

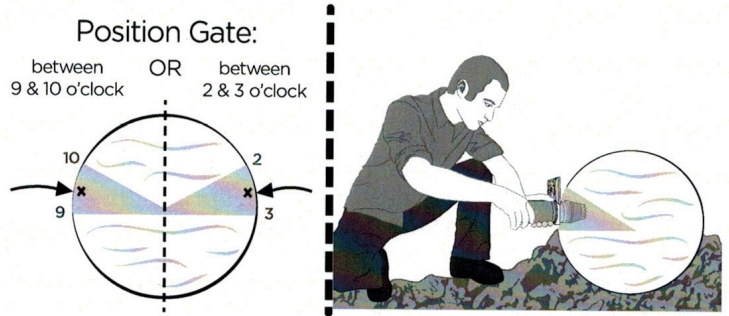
Adjust plunger by turning it counter-clockwise 1¼ to 1½ times (use groove as reference).



**3**

## Install

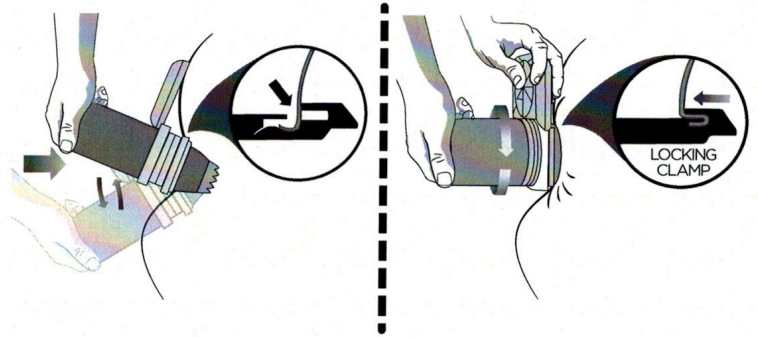
Place gate between 2 and 3 o'clock or the 9 and 10 o'clock position on the Poly-Pipe as shown in illustration. Hit end of plunger with the palm of your hand to pierce tube.



**4**

## Secure

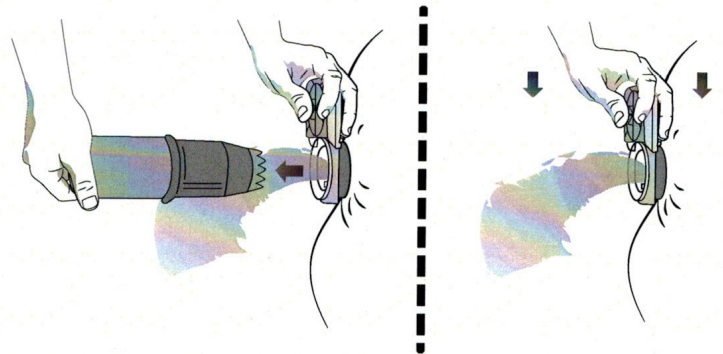
Maintain pressure and rock plunger to assure tubing completely settles into opening of locking clamp. Secure tubing to gate by keeping hold of gate and turn plunger clockwise until it is tight.



**5**

## Release

Maintain hold on gate and pull tool out. Adjust gate to desired opening.



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