

SOLVENT CEMENTING OF PVC JOINTS
(Refer to ASTM D 2855 for more detailed instructions)

The plastic pipe and fittings to be joined should be exposed to the same temperature conditions for a reasonable length of time before assembly. Use a fine tooth saw to cut pipe square and remove burrs with a file.

Wipe outer surface of pipe and inner surface of fittings with a clean cloth to remove all foreign substances and moisture before application of the primer, primer/cleaner and cement.

Using a brush or bobber supplied having a width of approximately 1/2 to 3/4 the depth of the socket, apply primer to the fitting socket and to the pipe. Then apply cement adequately with a light wiping action to spread uniformly over the surface of the pipe and a light coat inside the fitting. Do not rub the surface of the pipe or fitting socket with the brush any more than is necessary.

Immediately after the cement has been applied to the surfaces to be joined, insert the pipe into the fitting/bell and turn a quarter to half turn to distribute cement evenly.

Immediately after joining is completed, wipe off excess cement at the end of the fitting. Excess cement should not be allowed to dry on the pipe. The joined members should be allowed to cure for 15 minutes before they are handled. (In cold or damp weather, this interval should be increased to allow for the slower evaporation of the solvent). Another fitting or pipe section can be added to the opposite end within 2 or 3 minutes if care is exercised in the handling so that undue strain is not placed on the previous assembly.

The assembly should be carefully placed in the ditch, snaking from side to side for expansion. Cover the pipe with a few inches of dirt by hand before machine backfilling. Local Codes may require inspection before burying

Working strength of a solvent-cemented joint is not reached until 24 hours or longer; however, in most cases pressures up to 10% of rated working pressure may be applied within four hours at 75° F.

***The majority of reported failures occurring in small diameter pressure pipe are caused by excess cement.**

TOO MUCH CEMENT WILL DAMAGE THE PIPE
PVC PIPE IS NOT RECOMMENDED FOR AIR PRESSURE