

2.7.4.7 Repeated contact with the skin should be avoided. Proper gloves impervious to and unaffected by the solvents should be worn when frequent contact with the skin is likely. Application of the solvents or solvent cements with rags and bare hand is not recommended. Brushes and other suitable applicators can be used effectively for applying the solvent cement, thus avoiding skin contact. In the event of excessive contact, remove contaminated clothing and wash skin with soap and water.

- Step 1 Cut pipe square with hand saw and miter box, mechanical cut-off saw, or tube cutter designed for plastic.
- Step 2 Ream inside and chamfer outside of pipe (to eliminate all burrs).
- Step 3 Clean all dirt, moisture, and grease from pipe and socket. Use a clean, dry rag.
- Step 4 Check dry fit of pipe in fitting. Pipe should enter fitting socket from 1/3 to 3/4 depth of socket.
- Step 5 Apply a light coat of ABS solvent cement to inside of socket using straight outward strokes (to keep excess solvent out of socket). This is also to prevent solvent cement damage to pipe. For loose fits, apply a second coat of solvent cement. Time is important at this stage. See Section 2.7.3.4.
- Step 6 While both the inside socket surface and the outside surface of the pipe are SOFT and WET with solvent cement, forcefully bottom the pipe in the socket, giving the pipe a one-quarter turn, if possible. The pipe must go to the bottom of the socket.
- Step 7 Hold the joint together until tight (partial set).
- Step 8 Wipe excess cement from the pipe. A properly made joint will normally show a bead around its entire perimeter. Any gaps may indicate insufficient cement or the use of light

bodied cement on larger diameters where heavy bodied cement should have been used.

- Step 9 The system shall not be tested until the joints have cured (set) at least as long as recommended by the manufacturer.

2.7.5 Special Joints

2.7.5.1 Connection to Non-Plastic Pipe

When connecting plastic pipe to other types piping, use only approved types of fittings and adapters, designed for the specific transition intended.

ADOPTED: 1976

REVISED: 1981, 1987, 2003, 2006