

(two people may be needed to make large joints). Use special care when temperature is over 100°F (38°C) or humidity is over 60%.

### 2.5.3 SAFETY REQUIREMENTS AND PRECAUTIONS

**2.5.3.1 General.** Solvents contained in ABS plastic pipe cements are classified as airborne contaminants and flammable and combustible liquids. Precautions listed in this appendix should be followed to avoid injury to personnel and the hazard of fire.

**2.5.3.2 Safety Precautions.** Prolonged breathing of solvent vapors should be avoided. When pipe and fittings are being joined in partially enclosed areas, a ventilating device should be used in such a manner to minimize the entry of vapors into the breathing areas.

**2.5.3.3** Solvent cements should be kept away from all sources of ignition, heat, sparks and open flame.

**2.5.3.4** Containers for solvent cements should be kept tightly closed except when the cement is being used.

**2.5.3.5** All rags and other materials used for mopping up spills should be kept in a safety waste receptacle which should be emptied daily.

**2.5.3.6** Most of the solvents used in ABS pipe cements can be considered eye irritants and contact with the eye should be avoided for it may cause eye injury. Proper eye protection and the use of chemical goggles or face shields is advisable where the possibility of splashing exists in handling solvent cements. In case of eye contact, flush with plenty of water for 15 minutes and call a physician immediately.

**2.5.3.7** 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.

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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 2.5.2.4.

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.

### 2.5.4 Threaded Joints

Threads on iron pipe size (IPS) pipe and fittings shall be standards listed in Table 14-1. Threads on tubing shall be approved types. Threads on plastic pipe shall be factory cut or molded. Threaded plastic pipe shall be Schedule 80 minimum wall thickness. Tubing threads shall conform to fine tubing thread standards. When a pipe joint material is used, it shall be applied only on male threads and such materials shall be approved types, insoluble in water and nontoxic. Cleanout plugs and caps shall be lubricated with water-insoluble, non-hardening material or tape. Only listed thread tape or thread lubricants and sealants specifically intended for use with