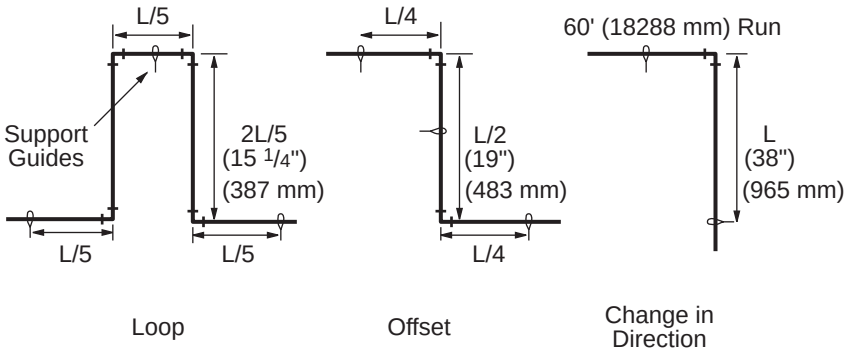
Example: Pipe Size – 1/2 inch (12.7 mm) Length of Run – 60 feet (18288 mm): (38") (965 mm) (from table).



when it thickens appreciably or gels. Solvent cement shall not be thinned.

2.7.4 Primer. A listed primer in compliance with ASTM F 656 shall be used with CPVC solvent cements that require the use of a primer. CPVC solvent cements that do not require the use of a primer are permitted for joints up to 2 inches in size.

2.7.5 Size of Applicator. Applicator should be about one half the pipe diameter. Do not use small applicator on large pipes.

2.7.6 Procedures

Step 1. Cut pipe square with hand saw and mitre box, mechanical cutoff saw or tube cutter designed for plastic.

Step 2. Ream and chamfer pipe (to eliminate sharp edges, beads and all burrs).

Step 3. Clean all dirt, moisture and grease from pipe and fitting socket. Use a clean, dry rag.

Step 4. Check dry fit of pipe in fittings. Pipe should enter fitting socket 1/4 to 3/4 of socket depth. On larger sizes of Sch. 80 fittings, a looser fit may be expected. This is a normal condition, and requires care to apply an adequate amount of cement.

Step 5. Apply CPVC primer, if required (see Section 2.7.4) to inside of fitting socket. Take care to avoid puddling.

Step 6. Apply CPVC primer, if required to outside surface of pipe to depth of fitting socket.

Step 7. When using solvent cements requiring a primer wait until primer surface is tacky. DO NOT attempt to soften (dissolve) the surface as is required for PVC.

Step 8. Apply a liberal coat of CPVC solvent cement to the outside surface of the pipe to the depth of the fitting socket.

Step 9. Apply a light coat of CPVC solvent cement to inside of fitting socket. Apply a second liberal coat of cement to the pipe end. Take particular care in cementing larger sizes of Sch. 80 fittings. Be sure all surfaces are coated.

Step 10. While both the inside socket surface and the outside surface of the pipe are WET with solvent cement, forcefully bottom the pipe in the socket, giving the pipe a quarter turn while inserting, if possible.

Step 11. Hold the joint together for 10 to 15 seconds to assure that the pipe remains bottomed against the pipe stop.

Step 12. Do not disturb the joint for at least 30 minutes.

Note: *The joint is weak until the cement is dry. If the joint is adjusted after it is set, the joint will be ruined. See Table 2 for recommended set time.*

Step 13. Wipe excess cement from the pipe. A properly made joint will show a bead of cement around its entire perimeter. Any gaps may indicate insufficient cement.

[1] Appendix X1. Safety Requirements And Precautions, from ASTM D 2564-88 Solvent Cements for Poly (Vinyl Chloride) (PVC) Plastic Pipe and Fittings is reprinted with permission from the American Society for Testing and Materials, 1916 Race St., Philadelphia, PA 19103, copyright.