


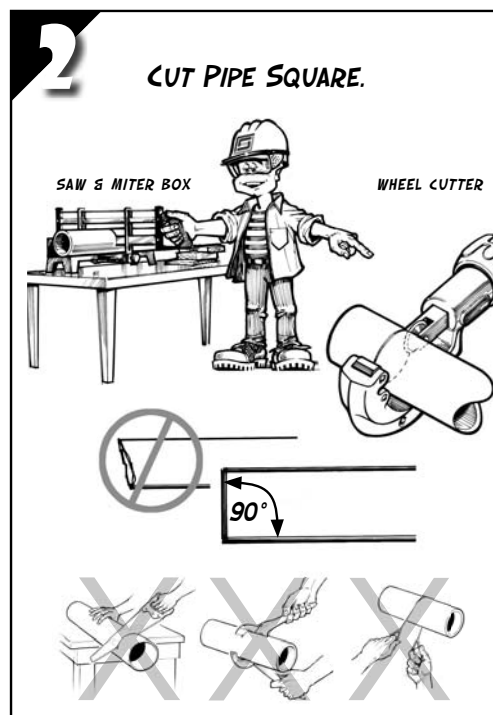
### 1 ASSEMBLE MATERIALS NEEDED.



✓ CHECK PRIMER & CEMENT EXPIRATION DATES.

EXPOSE PARTS TO THE OPEN AIR FOR AN HOUR IN ORDER TO ACCLIMATE THEM TO THE LOCAL WEATHER CONDITIONS. PROVIDE PROTECTION FROM EXCESSIVELY HOT OR EXTREMELY COLD ENVIRONMENTS.

### 2 CUT PIPE SQUARE.



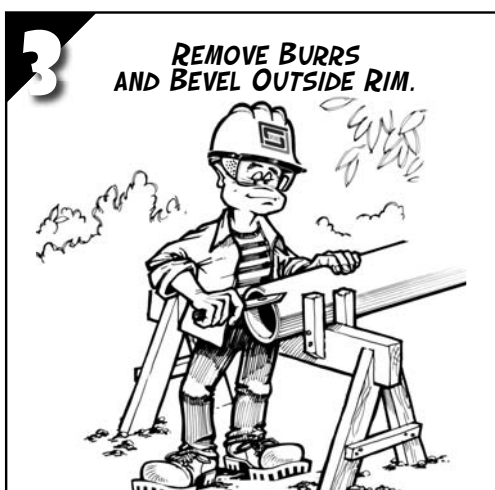
SAW & MITER BOX

WHEEL CUTTER

90°

ALWAYS USE THE PROPER TOOLS FOR CUTTING PVC PIPE, SUCH AS A SAW & MITER BOX, WHEEL CUTTER OR A PIPE CUTTER. THESE TOOLS INSURE A SQUARE (90°) CUT.

### 3 REMOVE BURRS AND BEVEL OUTSIDE RIM.



CAREFULLY BEVEL PIPE WITH FILE.

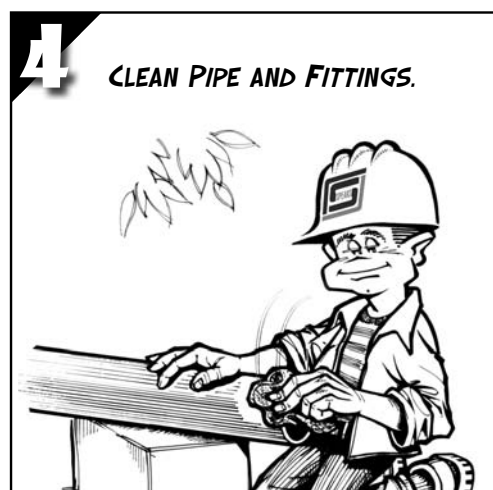
OR:

USE DEBURRING AND BEVELING TOOLS.

10° - 15°

DE-BURR WITH A KNIFE OR DE-BURRING TOOL AND BEVEL EDGES TO 10° - 15° SO THE PIPE WILL FIT SNUGLY INTO SOCKET.

### 4 CLEAN PIPE AND FITTINGS.



WIPE OFF ALL JOINING SURFACES WITH A CLEAN, DRY RAG.

DUST, DIRT, GREASE (EVEN FINGERPRINTS) AND MOISTURE CAN INTERFERE WITH THE PENETRATION AND BONDING PROPERTIES OF PRIMER AND SOLVENT CEMENT.

**5 CHECK DRY FIT.**

Full Interference Fit  
 Net Fit  
 Rough End-Cut  
 Loose Fit

PIPE

Socket Depth

Socket Depth

Socket Depth

Socket Depth

Socket Depth

**6 USE THE CORRECT APPLICATOR SIZE FOR THE JOB.**

USE AN APPLICATOR AT LEAST 1/2 THE SIZE OF PIPE.

**7 APPLY PRIMER\***  
 FITTING → PIPE → FITTING

WORK INTO SURFACE TO SOFTEN.

PRIMER

✓ CHECK PENETRATION.

WITHOUT SOFTENING, MOST SOLVENT CEMENTS WILL NOT BOND PROPERLY. USE 2 TO 3 THICK COATS.

\* SOME CEMENTS ARE "ONE-STEP" AND REQUIRE NO PRIMER. THIS TYPE OF CEMENT IS USED WITH SOME CPVC, ABS AND STYRENE PLASTICS.

**8 APPLY SOLVENT CEMENT**  
 (PIPE → FITTING → PIPE)  
 WHILE THE PRIMER IS STILL WET AND...

SOLVENT CEMENT

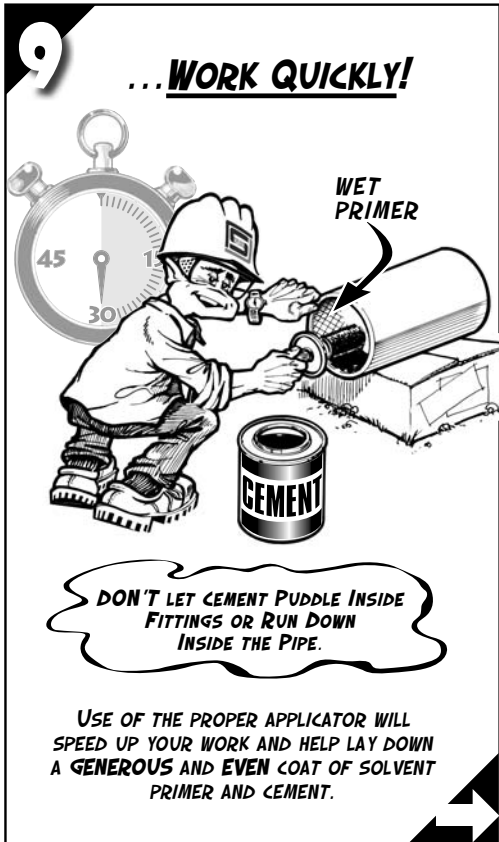
WET PRIMER

CEMENT

...WORK CEMENT ONTO PIPE USING A CIRCULAR MOTION. FOLLOW WITH A THIN COAT IN THE FITTING, REPEAT. KEEP APPLICATOR IN CAN WHEN NOT IN USE.

## Basic Solvent Cementing

**9** ...**WORK QUICKLY!**

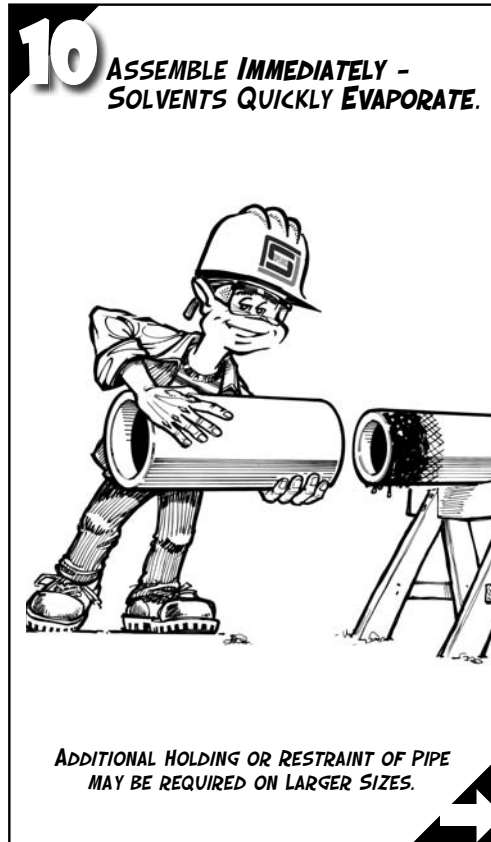


**WET PRIMER**

**DON'T LET CEMENT PUDDLE INSIDE FITTINGS OR RUN DOWN INSIDE THE PIPE.**

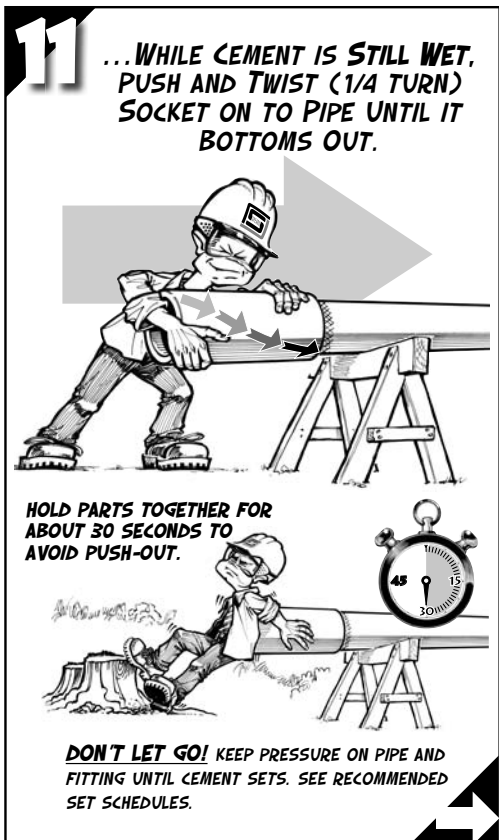
USE OF THE PROPER APPLICATOR WILL SPEED UP YOUR WORK AND HELP LAY DOWN A **GENEROUS AND EVEN** COAT OF SOLVENT PRIMER AND CEMENT.

**10** **ASSEMBLE IMMEDIATELY - SOLVENTS QUICKLY EVAPORATE.**



ADDITIONAL HOLDING OR RESTRAINT OF PIPE MAY BE REQUIRED ON LARGER SIZES.

**11** ...**WHILE CEMENT IS STILL WET, PUSH AND TWIST (1/4 TURN) SOCKET ON TO PIPE UNTIL IT BOTTOMS OUT.**



**HOLD PARTS TOGETHER FOR ABOUT 30 SECONDS TO AVOID PUSH-OUT.**

**DON'T LET GO!** KEEP PRESSURE ON PIPE AND FITTING UNTIL CEMENT SETS. SEE RECOMMENDED SET SCHEDULES.

**12** **REMOVE EXCESS CEMENT. (USE DISPOSABLE MATERIAL)**



IF LEFT ON EXPOSED PIPE, THE SOFTENING EFFECT OF EXCESS SOLVENT COULD PERMANENTLY DISTORT OR WEAKEN PIPE.

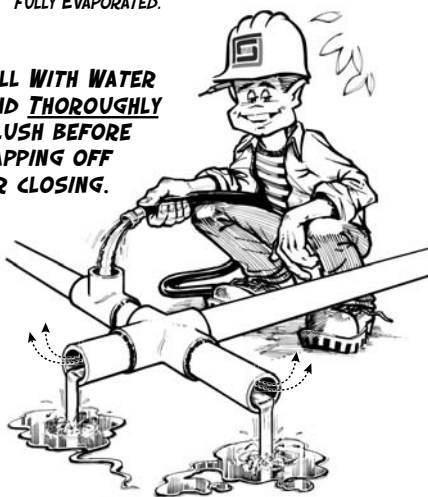


## 13

### FLUSH ENTRAPPED SOLVENT CEMENT VAPORS.

SOLVENTS EVAPORATE THROUGH THE SYSTEM AND WALLS, SOFTENING BOTH PIPE AND FITTINGS. SOME SOFTENING WILL REMAIN UNTIL SOLVENTS HAVE FULLY EVAPORATED.

**FILL WITH WATER AND THOROUGHLY FLUSH BEFORE CAPPING OFF OR CLOSING.**



AVOID PRESSURIZATION OF SYSTEM UNTIL ADEQUATELY CURED. IF THERE IS A STRONG SMELL OF SOLVENTS IN THE PIPING, VAPORS ARE BEING GENERATED.

## 14

### DO NOT DISTURB FOR INITIAL SET BEFORE HANDLING, THEN WAIT FOR FULL CURE...



#### REMEMBER...

JOINT SIZE, EXTREME TEMPERATURE (HOT OR COLD) AND HUMIDITY ALL HAVE AN EFFECT ON SOLVENT CEMENT CURE TIMES.

SEE RECOMMENDED SET & CURE TIMES.

**PROUD TO PARTNER SPEARS**

**MERRIMAN CONTROLS**

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