

Installation Procedures for Non-Gasket Pipe

Prior to completing any of the following steps, you must read the instructions on the PVC cleaner and PVC cement containers for any additional steps not listed below as well as the proper setting time for the PVC cement.

1. Cutting the Pipe:

- Pipe can be easily cut with an ordinary hacksaw, carpenter's saw, a ratchet-type pipe cutter, and miter saw.
- If after cutting there is any indication of cracking or splitting at the end of the pipe, cut off at least 2" beyond the damaged area.
- Make sure the pipe is cut square for a good seal at the base of the fitting hub.

2. Remove Burrs:

- Remove all pipe burrs from the outside and inside of the pipe with a sharp knife, a fine-tooth file, or a de-burring tool.
- Wipe the end of the pipe with a clean dry towel or cloth to make sure all burrs and debris are removed.

3. Dry Fit:

- Insert the dry spigot into the fitting making sure it goes 1/3 to 2/3 of the way in and isn't loose. DON'T over insert to where the pipe cannot be removed for priming or gluing.

4. Primer:

- Primers should be used to clean, soften, and dissolve the joint surfaces prior to applying PVC cement. Make sure to clean the exterior of the pipe and the interior of the fitting.

5. Application of Cement:

- Use the applicator supplied with the can of PVC cement, a brush, or roller with a width of about half the pipe diameter for pipe sizes above 2".
- Apply a moderate even coating of cement to the inside of the fitting and the outside of the spigot end of the pipe, make sure to only apply cement to the areas that will be joined together.
- For 6" pipe and above it will require at least 2 people to complete these steps.



Installation Procedures for Non-Gasket Pipe (continued)

6. Assembly:

- If the cement has dried and hardened prior to you putting the spigot into the fitting, it may be required for you to cut the pipe and start over.
- Insert the spigot into the fitting and give the pipe a 1/4 turn to ensure even distribution of cement within the joint.
- Once the pipe contacts the socket bottom, hold the pipe and fitting together so the pipe doesn't back out.
- Remove excessive solvent from the exterior of the joint with a clean dry cloth.

7. Set Time:

- Do not attempt to disturb the pipe and fitting joint until after the solvent cement has set or damage to the joint and loss of fit may result.
- Follow the instructions on the PVC cement can for the proper amount of time it will take for the cement to set properly.
- Weather conditions and temperatures will also be a factor in the proper setting of the cement. Make sure to take this into account for assembling and set time.

