Installation Procedures for Non-Gasket Pipe

Before beginning installation, carefully read and follow the instructions provided by the manufacturers of the PVC primer and solvent cement for any additional requirements not listed here, as well as the recommended setting and curing times for the PVC cement.

1. Cutting the Pipe
   - Pipe can be cut with a hacksaw, carpenter's saw, ratchet-type pipe cutter, miter saw, or other appropriate cutting tools.
   - Ensure the pipe is cut square to provide full contact at the base of the fitting socket.
   - Inspect the cut end for cracks, splits, or other damage. If damage is present, remove the affected section by cutting at least 2 inches beyond the damaged area.

2. Burr Removal and Surface Preparation
   - Remove all burrs, sharp edges, and loose material from both the interior and exterior of the pipe using a deburring tool, fine-tooth file, or sharp utility knife.
   - Thoroughly clean the pipe end with a clean, dry cloth to remove all dust and debris.

3. Dry Fit Inspection
   - Insert the pipe spigot into the fitting socket without primer or cement to verify proper fit.
   - The pipe should enter approximately 1/3 to 2/3 of the socket depth while maintaining a snug fit.
   - Do not force the pipe fully into the fitting during dry fitting, as it must be easily removable for primer and cement.

4. Primer Application
   - Primers are used to clean, soften, and condition the pipe and fitting surfaces to promote proper fusion.
   - Apply primer in accordance with the primer manufacturer's instructions to prepare the mating surfaces for solvent welding.
   - Avoid puddling of primer in fittings and pipe.



Installation Procedures for Non-Gasket Pipe (continued)

5. Solvent Cement Application
   - Use the supplied PVC cement applicator, brush, or roller. For pipe diameters greater than 2 inches, use an applicator approximately half the pipe diameter in width.
   - Only apply cement to the surfaces that will be joined together.
   - Apply a moderate, uniform coating of cement to the inside surface of the fitting and the outside surface of the spigot end of the pipe.
   - Avoid puddling of cement in fittings and pipe.
   - For pipe diameters of 6 inches and larger, a minimum of two installers is recommended to ensure proper assembly.

6. Assembly
   - Assemble the joint immediately after cement application while the cement remains wet and active.
   - If the cement has dried and hardened prior to assembly, cut and remove the affected section and start over.
   - Fully insert the pipe into the fitting socket while rotating the pipe approximately 1/4 turn to ensure uniform distribution of the solvent cement.
   - Once the pipe contacts the socket bottom, maintain firm pressure on the joint to prevent movement or the pipe from backing out.
   - Remove excess cement from the exterior of the joint with a clean, dry cloth.

7. Set Time
   - Refer to the solvent cement manufacturer's instructions for the required set and cure times.
   - Do not disturb the joint until the cement has achieved the manufacturer's recommended set and cure times. Failure to do so could result in reduced joint integrity and potential failure.
   - Ambient temperatures and weather conditions can affect curing rates and should be considered when determining installation and commissioning schedules.

