



Bonding Specifications

PVC & CPVC

Instruction Bulletin No. 57948

Caution

Solvent cements and primers must be stored in cool areas and never exposed to ignition, heat, sparks or open flames. Avoid prolonged breathing of vapors and repeated contact with the skin. Use proper ventilation in enclosed areas. In case of skin contact, flush with water. In case of eye contact, flush with water for fifteen minutes and seek medical attention.

General

1. Solvent cement has a shelf life and should be used before the date shown on the can.
2. Use brushes, not rags, to apply primer and cement.
3. Do not speed drying time by applying heat to parts.
4. Do not thin or use lumpy cement.
5. Parts being assembled could be made of PVC or CPVC. Be sure to use proper cement.
6. Do not attempt to cement wet parts.

Priming

1. Apply primer with a brush to both parts and allow to dry. Reapply primer to both parts. Parts will be properly primed when surface can be scratched a few thousandths of an inch.

Cementing

1. Apply a full even layer of cement on the pipe or piece O.D., slightly greater than the required depth.
2. Apply a thin layer of cement on the mating piece.
3. Apply another layer of cement on the pipe or piece O.D.

Joining

1. Immediately join both pieces while rotating a 1/4 turn to insure complete and even distribution of the cement. Hold both pieces in place for fifteen seconds to prevent "back-out" during hardening.
2. Wipe off all excess cement from circumference of pieces.
3. Place cemented parts aside and do not move them for at least five minutes. If pipes are 1/2" to 1-1/4", do not move for at least twenty minutes.
4. Place a piece of masking tape on the assembly in a very visible location. Write the date and time of solvent bonding on the tape.

Pressure Test

1. Allow all bonded joints to dry a minimum of 24 hours at room temperature (50°F to 90°F) before pressure testing.
2. Do not heat joint to speed drying.

