

## Instructions for solvent cement jointing of PVC-U

### Installation Instructions

Do not install at temperatures below 5°C.



Cut the pipe end squarely, remove internal burrs and chamfer to 15°.



Mark jointing length on the pipe.



Clean pipe and fitting socket thoroughly with PVC-U cleaner.



Apply solvent cement in the middle of the pipe cementing surface & distribute it first radially than axially all over. If necessary with 2 people.

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Pipe and fitting should be joined slowly and in correct alignment & restrained. 15min waiting time before further cementing below 10°C wait 30 min.



Remove excess glue directly from the fitting and the tube. Excess glue can act on the tube and weaken it.



Finished solvent cement jointing.

Wait at least 24 hours after the last bonding before pressurising the piping system. Attention! Drying times can vary depending on the surface conditions, the applied amount of solvent cement, the relative humidity level and the environmental temperature. General information:

- Close the containers tightly after 1 minute
- Do not use thickened glue

For fittings over 225 mm solvent cement with enhanced gap filling properties and a long opening time should be used.

***All information above is only general information. For exact information, the solvent cementing instructions of the solvent cement manufacturer should be consulted. manufacturer should be consulted.***