



## **How To Make a Leak – Free PVC Joint**

Application temperature: 32 °F to 110 °F (0 °C to 42 °C)

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1. Cut pipe straight (very important). This will allow pipe to bottom into the socket. The strongest part of the joint is the bottom 1/3 of the fitting.
2. Remove burr (shaving), use clean dry cloth. Do not use abrasive material.
3. Clean pipe and fitting using Pipe Cleaner. It is very important that pipe and fitting are free of dirt, grease or any other foreign matter.
4. Check dry fit. Pipe should easily go into the socket 1/3 to 2/3 of the way before any resistance is felt. This is commonly referred to as interference fit. If pipe goes to the bottom of the fitting without any resistance (interference) this ensures that the fitting is the correct size. If it is not the correct size, get another fitting.
5. Apply a liberal coat of primer. Primer is highly recommended for 3” and larger diameter installation. (Quickly proceed to step 6)
6. Apply a thin coat of cement (while primer is still wet) into the socket and a full even coat on the pipe to the depth of socket bottom. Do not puddle socket. Dauber applicator supplied with the can works well for less than 3” diameter installation. For 3” and larger diameter installation use brush/applicator that is 1/2 the size of pipe (i.e. 2” applicator for 4” pipe)
7. Insert pipe into the socket quickly while cement is still fluid (wet), if cement has dried, re- coat pipe and fitting. If possible, twist pipe 1/4 turn, this will allow cement to cover any dry spot. Make sure pipe goes all the way to the bottom of the fitting
8. Hold pipe and fitting together (30 seconds to a minute) to make sure pipe does not push out. Allow cement to set (approx. 15 minutes) before handling the assembly.
9. Wipe off excess cement with clean dry cloth
10. Allow cement to cure before applying water (fluid) pressure. Cure time is dependent upon temperature, humidity etc. Follow the cement manufacturer’s recommendation or refer to the chart in this booklet. (Under normal conditions, allow 24 hours cure time)