

6. Application of solvent Cement

- Apply the solvent cement evenly and quickly around the outside of the tube at a width a little greater than the depth of the fitting socket.
- Apply a light coat of cement evenly around the inside of the fitting socket. Avoid puddling.
- Apply a second coat of cement to the tube end.

CAUTION:

When cementing bell-end tube be careful not to apply an excessive amount of cement to the bell socket or spigot end. This will prevent solvent damage to the tube. For buried tube applications, do not throw empty primer or cement cans into the trench alongside the tube.

NOTE:

Cans of cement and primer should be closed at all times when not in use to prevent evaporation of chemicals and hardening of cement. They are also very flammable and should be kept away from heat or flame.

7. Joint Assembly

Working quickly, insert the tube into the fitting socket bottom and give the tube or fitting a 1/4" turn to evenly distribute the cement. Do not continue to rotate the tube after it has hit the bottom of the fitting socket. A good joint will have sufficient cement to make a bead all the way around the outside of the fitting hub. The fitting will have a tendency to slide back on the tube while the cement is wet so hold the joint tightly together for about 15 seconds. For tube sizes 4" and above, greater axial forces are necessary for the assembly of interference fit joints. Mechanical forcing equipment may be needed to join the tube and hold the joint until the cement "sets". The joint may have to be held together for up to 3 minutes. Consult your Hydroseal representative for specifics.

NOTE:

Always wait at least 24 hours before pressure testing a tubing system to allow cemented joints to cure properly. For colder temperatures, it may be necessary to wait a longer period of time.

8. Cleanup and Joint Movement

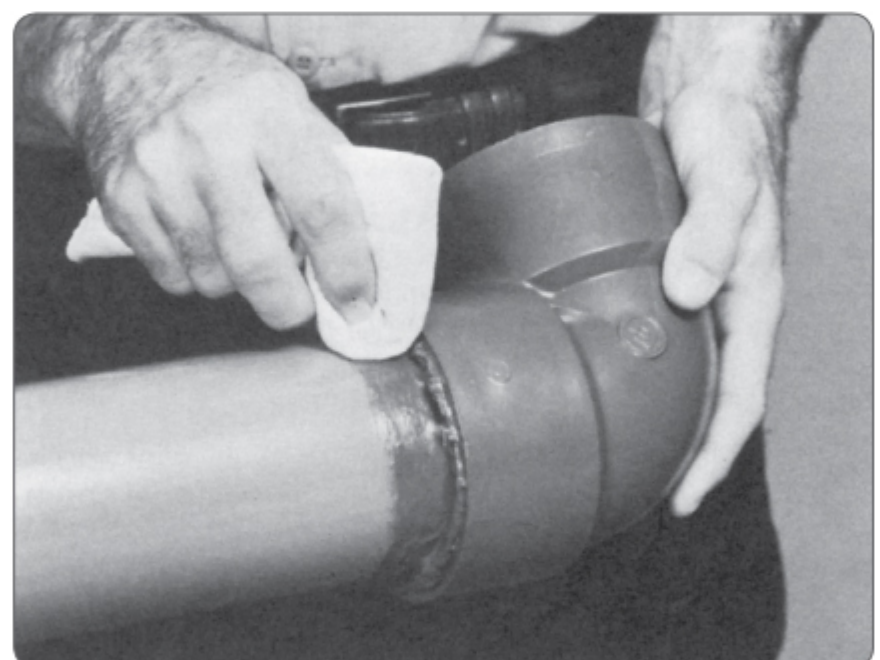
Remove all excess cement from around the tube and fitting with a dry cotton rag. This must be done while the cement is still soft. The joint should not be disturbed immediately after the cementing procedure and sufficient time should be allowed for proper curing of the joint. Exact drying time is difficult to predict because it depends on variables such as temperature, humidity and cement integrity. See the chart on page 7.24 for approximate joint movement times recommended by several tube and solvent cement manufacturers. For more specific information, you should contact your HYDROSEAL representative.



STEP 6



STEP 7



STEP 8