

# SOLVENT CEMENT SUCCESS.

Solvent cement is made up of CPVC resin, stabilizers and fillers in a variety of solvents. Not a glue, the material works by softening the topmost layers of CPVC pipe and fittings. Solvent cement cures as the CPVC molecules harden, form an inextricable bond that is 80% of the strength of the joint, and the solvent flashes off completely. These pro tips will help ensure a successful install.



## 1 CUT THE CPVC

**PRO TIP** Cut the pipe squarely to provide the maximum surface for a strong bond.

## 2 CHAMFER/DEBURR THE PIPE

**PRO TIP** Slightly bevel and ream the outside and the inside of the pipe to remove burrs and CPVC shavings for easing it into the socket without pushing the solvent cement into the joint.

## 3 PREPARE FITTING FOR SOLVENT CEMENT

**PRO TIP** Verify a proper interference fit by inserting the pipe easily 1/3 – 2/3 of the depth into the fitting.

## 4 PRIME THE TWO BONDING AREAS

**PRO TIP** Use pressure or scrub primer on the inside of the fitting and then outside of the pipe; apply a second primer coat inside the fitting socket only.

## 5 APPLY SOLVENT CEMENT TO TACKY SURFACES

**PRO TIP** Evenly apply a heavy coat to the outside of the pipe to the depth of the socket, and a thin-to-medium coat to the inside of the fitting socket. Apply a second coat outside of the pipe only.

**NOTE:** Take care with excess solvent cement inside the fitting because it pushes in, while excess on the outside of the pipe pushes out and can be wiped away.

## 6 ASSEMBLE PARTS QUICKLY

**PRO TIP** Quarter-turn the pipe into the fitting to evenly spread the solvent; when the pipe bottoms, hold it and the fitting together for 30 seconds (or longer depending on weather and temperature conditions) to prevent pipe push-out.

## 7 SET & CURE

**PRO TIP** Consult individual solvent cement manufacturers for their recommendations on set and cure times.

**CORZAN**<sup>®</sup>

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