

SOLVENT WELD JOINTS

TECHNICAL DATA

Solvent weld jointing and installation of PVC pipe systems to be in accordance with AS/NZS 2032 and PIPA Guideline POP102.

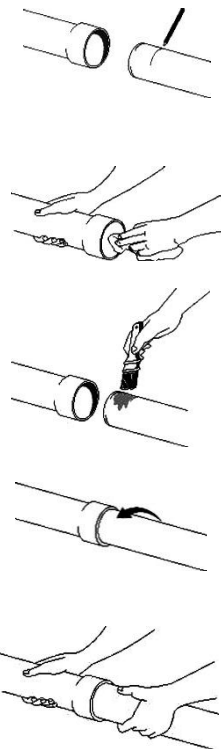
Pipe materials:	PVC-U and PVC-M
Standards:	AS/NZS 3879 Solvent Cements and Priming Fluids
Joint Types:	Tapered/Interference fit (most common for sizes up to DN150) Parallel/Clearance fit (can apply to imported fittings and fittings >DN150).
Solvent Types:	
- Type P (Green)	Pressure applications – Tapered/Interference fit joint
- Type N (Blue)	Non-pressure applications – Tapered/Interference fit joints
- Type G (Clear)	Gap filler applications – Parallel/Clearance fit joints
Priming Fluid (Red):	Suitable for Type P, N and G solvent cements.

For specialty products, such as PVC-C and ABS only use primer and solvents as recommended by the pipe manufacturer.



JOINTING PROCEDURE

PREPARE THE PIPE	Ensure Pipe is cut square and remove burrs and sharp edges from inside and outside edges using deburring tool.
WITNESS MARK THE PIPE	Mark the spigot with a witness mark (eg pencil line) at a distance equal to the internal depth of the socket. Do not use anything that will score the pipe surface.
APPLY PRIMING FLUID	Priming is crucial as it cleans and softens the PVC surface for effective bonding. Using a lint free cloth dampened with priming fluid; rub the spigot and socket surfaces that are to be bonded.
APPLY SOLVENT CEMENT	Use a suitable size brush that can effectively coat the surfaces in 30 seconds. Apply a thin even coat of solvent cement to the internal surface of the socket, then to the spigot up to the witness mark. Take care to avoid excess pools of solvent that will weaken the pipe.
INSERTING THE SPIGOT	Make the joint immediately as solvent cement will dry quickly. Insert the spigot in a single movement for the full depth of the joint and twist the spigot so that it rotates about a 1/4 turn whilst inserting.
SECURE THE JOINT	Hold the joint securely for 30 seconds then wipe off excess solvent cement. Do not disturb joint for a further 5 minutes to secure the bond. Do not fill pipe with water for at least 60 minutes after making the final joint.
CURE THE JOINT	Allow 24 hours before pressure testing where temperature is above 16 deg C. Allow 48 hours if temperature is 0 deg C.



RUBBER RING JOINTS

TECHNICAL DATA

Rubber ring jointing and installation of PVC pipe systems to be in accordance with AS/NZS 2032.

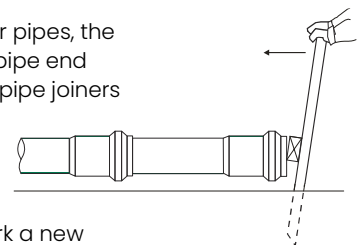
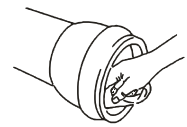
Pipe materials:	PVC-U, PVC-M and PVC-O
Standards:	ATS 5200.015 and AS/NZS 4020 (BK Anti-bacterial lubricant only)
Lubricant Types:	BK Type – Bactericidal lubricant (Anti-Bacterial for use in potable water applications) Std Type – Standard lubricant (for use in non-potable water applications)



JOINTING PROCEDURE

Refer to the Manufacturer's pipe label for joint information and specific jointing instructions.

CUTTING THE PIPE	PVC Pipe can be cut to length if required. Reproduce the chamfer (approx. 12-15 deg) and witness mark to match the manufactured dimensions. The witness mark will vary if inserting the pipe into a ductile iron fittings or mechanical coupling. Refer special notes below.
PREPARE THE PIPE	Do not use lubrication while cleaning. Pipe spigot – clean spigot to witness mark. Socket (Reiber ring) – these rings are installed during the manufacturing process and cannot be removed on site. Check to ensure ring is securely in place and clean socket around the ring. Socket (all other rings) – clean and dry the ring groove and insert the rubber ring into the groove as shown on the label.
APPLY LUBRICATION	Lubricate the pipe spigot to the witness mark including the chamfered edge. Do not lubricate the socket or rubber ring unless recommended by the pipe manufacturer.
ASSEMBLY	Pipes must be aligned during assembly to ensure an effective joint. Restrain the socket of the previously installed pipe to prevent further compression of the pipeline joints while assembling the new joint. Insert the chamfered edge of the spigot into the socket and apply a firm even thrust to push home to the witness mark. This can be achieved by hand on smaller pipes. On larger pipes, the use of a bar thrust against a timber block to protect the pipe end may be required. Alternatively, a commercially available pipe joiners may be required for larger diameter pipes.
SPECIAL NOTE – WITNESS MARKS	
Ductile Iron Fittings	Check the socket depth of the ductile iron fitting and mark a new witness line on the PVC spigot to match.
Couplings	Allowance should be made for a gap between pipe ends for couplings. Refer to the coupling manufacturer's instructions to determine the depth of insertion and mark a new witness line on the PVC spigot to match.



CIVILPIPES PTY LTD

ABN 30 168 566 667
2 Potassium St. Narangba Qld 4504
PO Box 304, North Lakes Qld 4509



Web:
civilpipes.com.au



Telephone:
+61 7 3053 3456



E-mail:
sales@civilpipes.com.au

