

INSTRUCTION GUIDE

SOLVENT WELDING



1 Cut pipe square, chamfer, deburr, and free the ends of any dirt.

2 Dry fit the pipe to test for interference between 1/3 and 2/3 insertion.

3 Clean pipe and fitting hub with Oatey Cleaner.



4 Apply approved Oatey primer inside the fitting hub, re-dip and apply to outside of the pipe, then re-dip and apply to inside of fitting hub again.

5 Apply approved Oatey cement to the outside pipe, do not re-dip and then apply cement to the inside of fitting hub. Then re-dip and apply a second coating of cement to the outside of pipe.

6 While turning a one quarter turn, assemble the parts by inserting the pipe into the fitting hub until the pipe reaches the bottom of the fitting hub.

7 Hold for 30 seconds to prevent push out.

8 Wipe off the excess cement with the dauber. To determine when your system is ready to test review the Oatey solvent weld cure time chart.