

Solvent cement jointing of PVC-U fittings d250 – 400

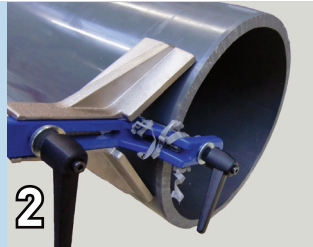
The general cementing instructions for PVC-U must be considered, along with these specific instructions for dimensions d250 – 400. PVC-U solvent cement jointing fittings d250 – 280 from Georg Fischer are approved to a nominal pressure of 10 bar (PN10). Sizes d315 - 400 are approved to a nominal pressure of 6 bar (PN6).

Our experience and tests show that pipes > d250 can be slightly oval, which could produce a cementing gap of more than 0.6 mm. That is why the cementing should be carried out very carefully according to the following instructions.

ATTENTION: Do not exceed the maximum handling time of 4 minutes at 20°C!



1 Cut pipe end squarely



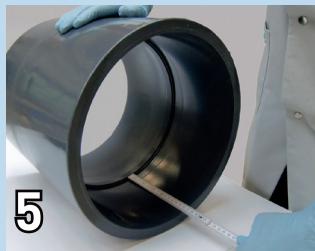
2 Chamfer to 15°, 6-8 mm



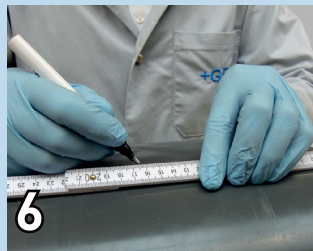
3 Remove internal burrs



4 Clean pipe and fitting socket thoroughly with TANGIT cleaner & make a fingernail check to examine adhesion (poss. roughen pipe surface)



5 Measure jointing length



6 Mark jointing length on the pipe



7 Stir solvent cement thoroughly and check consistency



8 Apply TANGIT solvent cement centered to the fitting socket surface & distribute it first radially than axially (1 person)



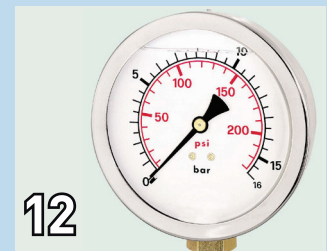
9 Apply solvent cement in the middle of the pipe cementing surface & distribute it first radially than axially all over (2 people)



10 Pipe and fitting should be joined slowly and in correct alignment & restrained for at least 1 min (3 to 4 people)



11 15 min waiting time before further cementing below 10°C wait 30 min



12 Pressure testing after 24 h from the time the last jointing has been made

d (mm)	Nominal working pressure 20°C / water	Max. test pressure 20°C / water*	Waiting time after final cementing joint before pressure test
250 - 280	10 bar	15 bar	24 h
315 - 400	6 bar	9 bar	

*It is not permitted to use any gas as a test medium

www.piping.georgfischer.com/go/Support