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

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

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

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