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.