

# INSTRUCTION GUIDE

## SOLVENT WELDING



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

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

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**3** Clean pipe and fitting hub with Oatey Cleaner.

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**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.

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**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.

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**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.

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**7** Hold for 30 seconds to prevent push out.

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**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.