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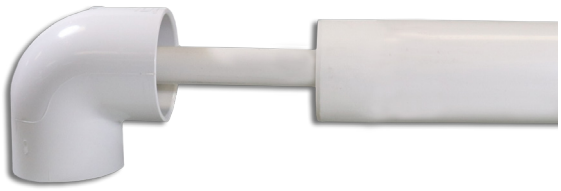
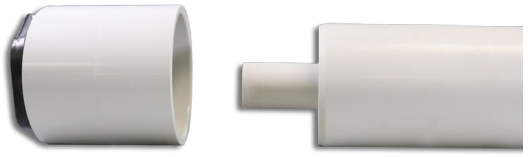
Thermoplastic Piping Systems

Installation Guide
Pro-Lock®
2020





Another Corrosion Problem Solved.™

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Simultaneous Solvent Cementing

Note: It is recommended to follow ASTM D2855 for the PVC and CPVC solvent cementing process.

1. Cut the pipe to the desired lengths. The carrier pipe will be longer by the difference of the socket depths of the fittings to be joined. Bevel the ends of the pipe.

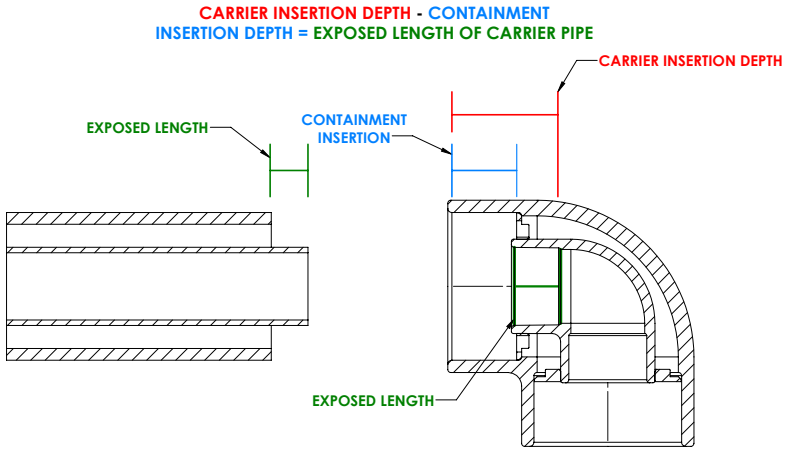

Figure 1: Pipe length visual guide

2. Apply primer and cement to the carrier fitting and pipe. Insert pipe and turn 1/4 turn if possible.

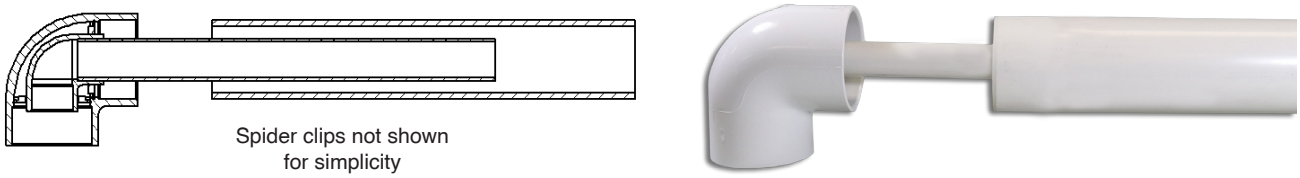

Figure 2: Joint after completion of step 2

3. Apply primer and cement to the containment fitting and pipe. Insert pipe and turn 1/4 turn if possible.

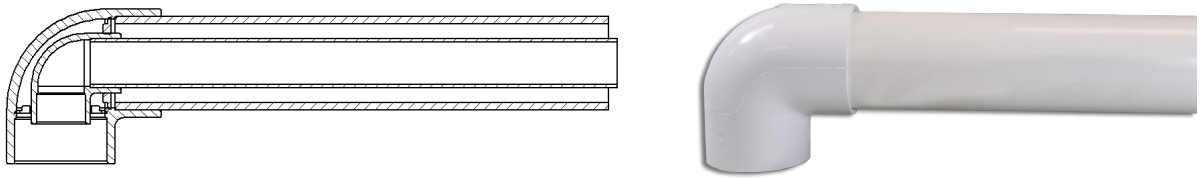

Figure 3: Joint after completion of step 3

4. Spider clips (centralizers) are spaced according to pipe size, but an additional spider clip may be needed at the end of the pipe if there is movement of the carrier pipe.

5. Dry-fit fitting and pipe to ensure proper alignment. Mark the carrier pipe at the fitting so that proper insertion is obtained.

6. Apply Primer and cement to the carrier and containment fitting and pipe. Insert pipe and turn 1/4 turn if possible.

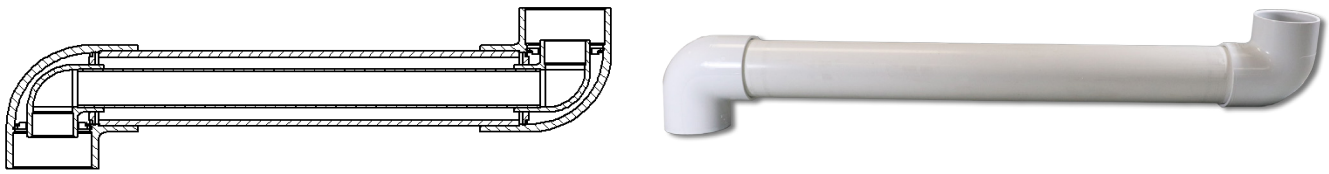

Figure 4: Completed assembly

Termination Fitting

Termination fittings are a one piece fitting with a double O-ring seal on the carrier pipe.

1. Cut back the containment pipe to expose carrier pipe as necessary to pass through the end termination. Bevel the ends of both carrier and containment pipe. Apply standard o-ring lubricant to the o-rings.

Figure 5: End termination and pipe after completion of step 1

2. Apply primer and cement to the termination socket and containment pipe and slide the termination fitting on to containment pipe and rotate 1/8 to 1/4 turn. The carrier pipe will slide through the o-ring seal on the end term.

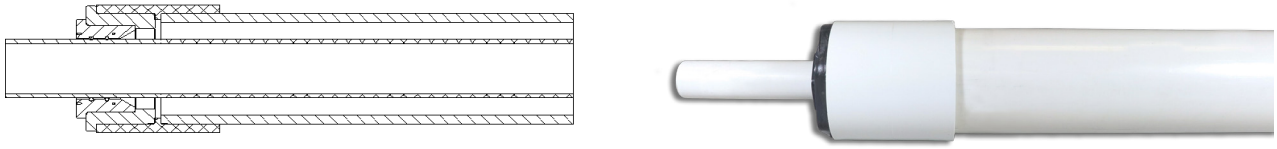

Figure 6: Completed assembly

Solvent Cement Recommendations

Material	Cement
PVC	Weld-On® 724*
CPVC	Weld-On® 724*
Clear PVC	Weld-On® 705*

*Weld-On is a registered trademark of IPS Corporation.

External Support Spacing* (in feet)

Containment Size (nom in.)	PVC Schedule 40	PVC Schedule 80	CPVC Schedule 80
2	6	7	7
3	7	8	8
4	7-1/2	9	9
6	8-1/2	10	10
8	9	11	11
10	10	12	11-1/2

*Support spacing is based on Specific Gravity of 1.0. Correction Factors must be used if the fluid has a higher density as follows: 0.90 for S.G.=1.5, 0.85 for S.G.=2.0, 0.80 for S.G.=2.5.

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