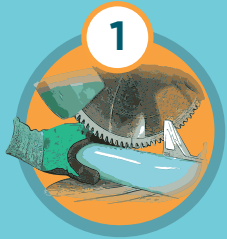


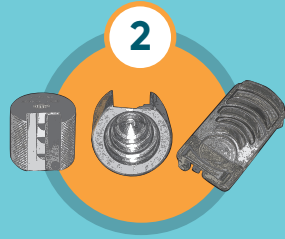
SOLVENT WELDING INSTRUCTIONS



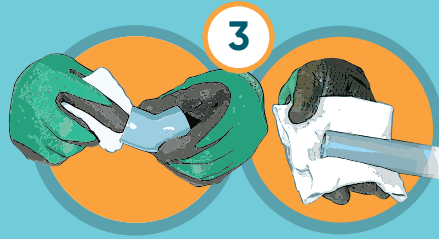
PREPARING YOUR PIPE



CUTTING THE PIPE. It is important to cut the pipe squarely. A square cut provides the surface of the pipe with the maximum bonding area. Pipe can be easily cut with a wheel-type plastic tubing cutter, chop saw or fine toothed saw. Do not use reciprocating saw.



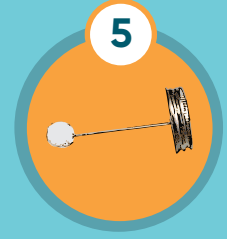
PREPARING PIPE ENDS. Always bevel pipe ends. Use the tools provided by IPEX which have been specifically designed for this purpose. Remove burrs and filings.



CLEANING. Using a clean, dry cloth, wipe any dirt and moisture from the fitting socket and the pipe end.



DRY-FITTING. Before applying primer or solvent cement, test all connections (pipes, fittings and accessories) to confirm a proper interference fit exists.



APPLICATOR SIZE. Use the applicators (daubers and swabs) provided with AquaRise solvent cements.

ONE-STEP

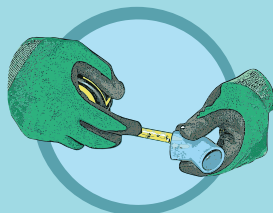
1/2" TO 2" DIAMETERS SOLVENT WELDING PROCEDURE

TWO-STEP

2-1/2" TO 4" DIAMETERS SOLVENT WELDING PROCEDURE



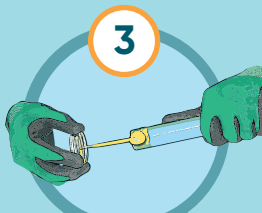
IMPORTANT: For 1/2" to 2" (12mm to 50mm) diameters use only AquaRise One-Step solvent cement. Do not use primer with One-Step solvent cement.



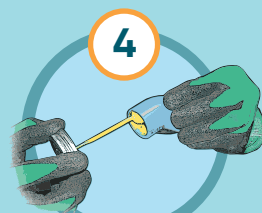
Measure the fitting socket inner depth and mark the outside of the pipe with this dimension.



AquaRise One-Step cement comes with a small dauber inside the can. Use this small dauber for 1/2" (12mm), 3/4" (19mm) and 1" (25mm) diameter joints. A larger dauber is also provided separately inside this carton. Use the larger dauber for 1-1/4" (32mm), 1-1/2" (38mm) and 2" (50mm) diameter joints.



Apply a medium layer of AquaRise One-Step solvent cement to the bevelled pipe end. Apply enough cement to just cover the socket insertion mark on the outside of the pipe. Be aggressive and work One-Step cement onto the pipe surface.



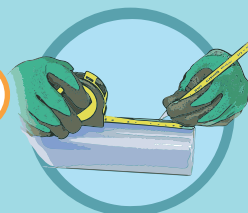
Apply a thin, light layer of AquaRise One-Step solvent cement to the inside of the fitting socket and work this thin layer of One-Step cement into the wall of the fitting socket.



IMPORTANT: For 2-1/2" to 4" (65mm to 100mm) diameters always use AquaRise primer with AquaRise Two-Step solvent cement.



Measure the fitting socket depth and mark the outside of the pipe with this dimension.



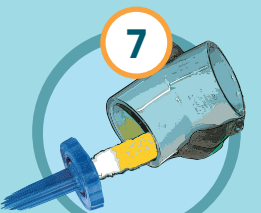
Apply AquaRise primer to the pipe end, equal to the depth of the fitting socket. Be aggressive and work the primer into the pipe.



Apply AquaRise primer to the inside of the fitting socket.



AquaRise Two-Step cement comes with a large dauber inside the can. Use this large dauber for 2-1/2" (65mm) and 3" (75mm) diameter joints. A Super Swab is also provided separately inside this carton. Use the Super Swab for 4" (100mm) diameter joints.



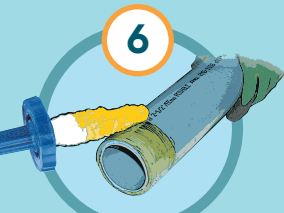
Apply a thin layer of AquaRise Two-Step solvent cement to the inside of the fitting socket.



Apply AquaRise primer to the inside of the fitting socket again.

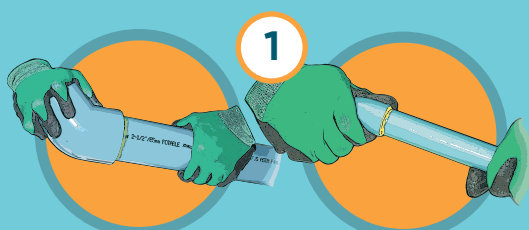


While the primer is still wet and the surfaces are soft, use the swab provided to apply a full, even layer of AquaRise Two-Step solvent cement to the pipe end, equal to the depth of the fitting socket. Be aggressive and work it onto the surface.

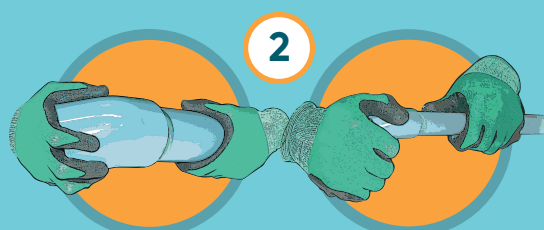


Apply a second full, even layer of AquaRise Two-Step solvent cement to the pipe end.

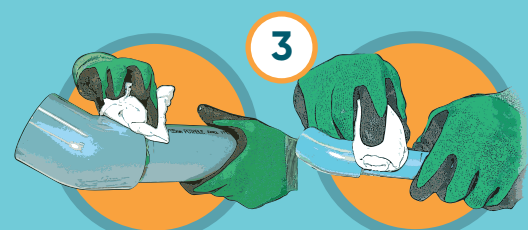
PLEASE NOTE: THESE NEXT THREE STEPS APPLY TO BOTH THE ONE-STEP PROCEDURE AND THE TWO-STEP PROCEDURE.



Without delay, while the solvent cement is still wet, assemble the pipe and fitting, and twist a 1/8 to 1/4 turn as the pipe is being inserted.



Hold the pipe and fitting together for approximately 30 seconds to avoid "push-out".



A bead of solvent cement must be formed around the entire socket fitting entrance. With a clean, dry cloth, remove the excess solvent cement from the pipe and fitting.

YOU ARE DONE!

SAFE HANDLING OF PRIMERS AND SOLVENT CEMENTS:

AquaRise primer and solvent cement is made from flammable liquids and should be kept away from all sources of ignition. Good ventilation should be maintained to reduce fire hazard and to minimize the breathing of solvent vapors. Refer to ASTM F402, Standard Practice for Safe Handling of Solvent Cements, Primers, and Cleaners Used for Joining Thermoplastic Pipe and Fittings. Always adhere to local jobsite and workplace safety regulations. For additional safety information, consult the material safety data sheet for this product which is available at ipexaquaarise.com.



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