

# ABS JOINTING PROCEDURES

ABS

U-PVC IMPERIAL

U-PVC METRIC

POOL HOSE

C-PVC

PP

COMPRESSION

PE

GUIDELINES



## ACCESSORIES



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## ABS pipework systems are designed to have an interference fit and are not designed to be dry fitted.

ABS cement is not gap filling. ABS cement softens the inside of the fitting and the outside of the pipe to form a joint chemically. Strength of joint is reduced if surfaces are not cleaned and properly prepared.

1. Cut the pipe ends square.
2. Remove burrs and clean out swarf. A chamfer must be filed approx 3mm x 45° (This will prevent the layer of cement being scraped away as the pipe is pushed into the fitting).
3. Use a felt marker pen or pencil to mark the pipe at the distance which will penetrate the fitting socket to the root/stop.
4. Thoroughly clean the surfaces of both pipe and fittings with MEK cleaner on a clean lint-free cloth. Please note it is not necessary to abrade pipe or fitting unless pipes are discoloured/sun bleached.
5. Stir the ABS Cement SLOWLY but thoroughly.
6. Use a clean brush approximately half as wide as the pipe to be jointed.

Apply cement to the pipe and fittings using longitudinal strokes.

The pipe should have a slightly thicker coating than the fitting.

The prepared areas should be completely covered with cement.

Note: It is important to apply cement quickly to enable assembly without excessive force being required.

7. Immediately after application of cement push pipe fully home to the stop in the fitting without rotating.

Hold the pipe and fitting for up to a minute, depending on size, to ensure fitting does not slide off the pipe.

Note: When working under cold conditions ensure the joints are free from frost and moisture and allow extra curing time.

8. Wipe off excess cement from both sides of the joint using a clean lint-free cloth.
9. Replace lids on tins.
10. Clean brush in MEK cleaner.

## PRECAUTIONS

- The jointing area must be well ventilated
- Do not allow a naked flame or smoking in the jointing area
- Ensure cement is used prior to its expiry date (shown on bottom of tin)
- Wear rubber or latex gloves when applying MEK cleaner and ABS cement
- Never dilute ABS solvent cement
- Always replace lids on tins when not in use
- Always use clean brushes
- Always use clean lint-free cloth or absorbent paper
- Use a shelter to keep jointing surfaces dry in wet weather

## CEMENT SETTING TIMES

PIPE DIAMETER	UP TO 2"		2 1/2" TO 6"		8" AND ABOVE	
Temp	Up to 10 bar	Up to 15 bar	Up to 10 bar	Up to 15 bar	Up to 10 bar	Up to 15 bar
>15°C	4 h	8 h	6 h	16 h	48 h	72 h
5°C to 15°C	8 h	16 h	12 h	24 h	72 h	96 h
0° to +5°C	12 h	24 h	18 h	32 h	96 h	120 h

These times are applicable to Griffon cement.

- Solvent cement setting times are given for guidance only and can vary depending on a number of factors.

## CEMENT USAGE RECOMMENDATIONS

The following is an estimation of the number of joints likely to be achieved per litre of solvent cement.

NOMINAL BORE	NUMBER OF JOINTS	TYPE AND SIZE OF BRUSH	NUMBER OF PEOPLE
3/8" – 1/2"	400	4mm Round	1
3/4" – 1"	400	8mm Round	1
1 1/4" – 2"	200	1" Flat	1
2 1/2" – 3"	60	2" Flat	1
4"	35	2" Flat	2
5" – 6"	20	3" Flat	2
8"	10	3" Flat	3

## INSTALLING THREADED FITTINGS

1. Ensure all threads are clean.
2. Apply PTFE Tape to the male thread for 1 ½ turns in a clockwise direction.
3. Screw the female threaded fitting by hand onto the male thread.
4. It should be possible to screw the fitting on by hand for 2/3 of the thread length.
5. After tightening by hand add an extra ½ turn with a suitable tool i.e strap wrench.

## PRECAUTIONS

Use PTFE Tape or Kolmat Fibre Tape/Paste. Do not force tightening of the joint under any circumstances. For connecting plastic pipework systems to metal pipework systems composite unions and/or flanges must be used.

