



# Specified Fittings, LLC

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To Whom It May Concern:

Allow this letter to serve as instructions for installing PVC fittings fabricated by Specified Fittings.

When needed, solid walled PVC pipe is easily cut with a sharp bladed saw. It is vital that this cut be made straight and square. The cut end must be beveled. With each cut, insertion marks should be redrawn. In drawing reference marks, first measure—on the inside of the bell—from the edge of the entry lip to the beginning of the taper at the bottom of the bell. Draw the insertion line ½” shorter (including the bevel) than the bell depending on the size.

Clean both the pipe and female socket with a rag. Both primer and PVC cement are required for a good joint; the proper primer and glue will depend on end users’ situation. Using a properly sized applicator swab generously apply primer to both the pipe and to the interior of the female socket. Working quickly, apply copious amounts of glue to the pipe and inside of the fittings’ socket. The application of glue over the top of still-wet primer will inhibit its evaporation. Immediately assemble the fitting and pipe. Be sure that when you bottom out (insert up to drawn line) the pipe in the socket, you twist the pipe a ¼ turn. Hold in place for between 30 seconds and 1 minute to avoid push-out caused by the tapered solvent-weld socket. Wipe away the excess glue, especially the bead, without disturbing the joint.

Before moving the line glued with fittings, allow the cement to set. Set times will depend on the products used. After the joint has set, move into place. You can begin to backfill at this point, but the joints must remain exposed. This is for inspection and to allow complete curing. Cure period will depend on the type of cement, the size of the pipe, the air temperature and humidity, and other factors. Consult cement manufacturer for Recommended cure times. Set and cure times will be longer with large sized pipe, slow drying cements, chemical applications and in damp or humid conditions.

## **Tips for Solvent-Welding:**

- Specified Fittings suggests using IPS brand’s P-70 primer and PVC719 for gluing PVC.
- Pipe and fitting should soften with primer application. Test for appropriate pipe softness by scratching with fingernail.
- Keep applicator in glue between applications and keep can closed when not in use.
- Always follow safety and personal protective equipment suggestions provided by the primer and cement manufacturers.
- Many gluers prefer to keep their glue and primer inside a building or vehicle to keep it

within the manufacturers suggested temperature range.

If you have further questions or require more information, please let us know.

Thank you  
Brad Sukolsky  
Specified Fittings