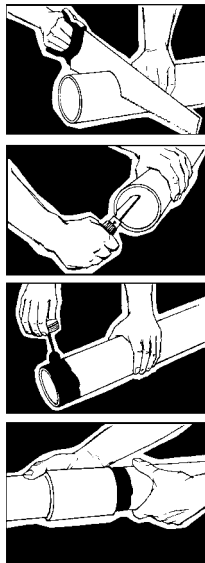


Cement Joints



Carlton nonmetallic products are joined by means of solvent cement joints. Sizes 1/2" through 1 1/2" should be cut square (using a fine tooth handsaw) and deburred. For sizes 2" through 6" a miter box or similar saw guide should be utilized to keep the material steady. After cutting and deburring, wipe ends clean of dust, dirt and shavings.

Joining process as follows: Be sure that conduit end is clean and dry. Apply coat of Carlton Solvent Cement (use dauber) to end of conduit, the length of the socket to be attached. Push conduit firmly into fitting

while rotating conduit slightly about one-quarter turn to spread cement evenly. Allow joint to set approximately 10 minutes.

Carlton recommends the use of Carlton cement for proper solvent cement joints. Since this cement is prepared particularly for our product compounds and tolerances, we cannot guarantee joints assembled with cement materials supplied by other manufacturers. Regular grade grey solvent cement will accommodate most application situations being of a general purpose nature. In situations requiring an extremely fast-setting joint, (low temperature or difficult installation conditions) Carlton All Weather Quick-Set Cement is recommended. Standard grade clear cement is recommended for noncritical utility applications where gap filling and leak testing are not required.

Average number of joints per can

Pipe size	1/2 Pint	Pint	Quart	Gallon
1/2	140	275	550	2,200
3/4	90	180	360	1,440
1	70	140	280	1,120
1 1/4	50	100	200	800
1 1/2	37	75	150	600
2	20	40	80	320
2 1/2	17	35	70	280
3	15	30	60	240
3 1/2	13	27	54	216
4	12	25	50	200
5	9	19	38	150
6	6	12	24	95

Average shelf-life of all Carlton cement is 24 months (unopened cans stored below 80°F.)

All Carlton cements are specially formulated to be used with Carlton PVC products, and do not require primers when parts are clean of dirt and moisture.



Cementing PVC Conduit:

1. Make square saw cut with fine tooth saw.
2. Deburr and round inside edge of the cut end.
3. Clean socket ID and spigot OD of dirt and moisture.
4. Apply a uniform coat of cement to spigot end and push onto socket bottom, rotating 1/4 turn.
5. Allow time to set before disturbing. This will depend upon temperature.

Cementing PVC Conduit for Submerged Areas Requiring Air or Water Tightness:

1. Follow the procedure to the left for cementing conduit.
2. Test workmanship by conducting a low pressure air (3.0 - 5.0 psi) test after system is installed and cemented joints are set.
3. Plug and block ends to prevent movement prior to pressurization.
4. Check for leaks with soap solution.
5. Even low pressure air can cause high thrust loads and caution must be observed.



Cementing ENT for Concrete-Tight Applications:

1. Use Carlton Socket tight fittings or couplings.
2. **Do not** use chemical primer or cleaner.
3. Apply a light uniform coat of cement, labeled for use with ENT.
4. **A brush** shall be used to apply the cement.
5. Brush excess cement out of ENT grooves
6. Promptly insert ENT into fitting while cement is wet, until the fitting stop is reached, and give 1/4 turn.
7. Do not disturb until the joint is set.