



PIPE TOOLS & VISES
SINCE 1896

Correct Solvent Cement Weld Tips for 636 Systems

INSTALLATION OF SYSTEM 636® for the application of flue gas venting requires a certain degree of skill and the use of the correct tools to avoid joint failures which could be life threatening. On-site training is available from IPEX for proper solvent welding procedures as well as other important installation points. Please visit www.ipexinc.com/system636 for details. Information about plastic pipe tools is available at www.reedmfgco.com.

1. Obtain the proper materials for the job, along with the proper cement and applicator for the size of piping system to be assembled.

2. Make a clean, square cut. Pipe must be cut as square as possible since a diagonal cut would reduce the fusing area in the most critical area of the joint. BEST AND CLEANEST TOOL IS A PVC/CPVC TUBING CUTTER. Do not use tools such as chop saws, hack saws, etc which will create statically charged plastic waste that will damage appliances.

3. Create a 15 degree chamfer. After cutting, remove all burrs from the outside of the pipe with a de-burring tool. Failure to remove burrs can scrape channels into pre-softened surfaces, or inadvertently plow cement out of the joint during assembly. BEST AND CLEANEST TOOL IS A DEB4 DEBURRING TOOL

4. Must use IPEX SOLVENT CEMENT and PRIMER.

a) Do not use solvents or cements other than those specified by IPEX's Installation Guide.

b) Only IPEX's System 636 PVC/CPVC Primer (purple or clear in color) shall be used for System 636 PVC or CPVC venting systems.

For detailed primer information, refer to IPEX's guide.

5. Wipe the pipe clean with a rag and then check pipe and fittings for dry fit before cementing.

6. Use the right applicator for the size of pipe or fittings being joined. As a general guide, the applicator size should be equal to 1/2 the pipe diameter.

7. The use of primer in the solvent cementing process is beneficial as it allows for deeper penetration of the weld after assembly. In Ontario, primer is mandatory for usage on System 636 for installation temperatures at or below 0°C, and for installations of 6" and 8" CPVC System 636 in all conditions.

8. Use sufficient force to ensure that the pipe bottoms in the fitting socket. If possible, twist the pipe a 1/4 turn as you insert it.

9. Hold the pipe and fitting together for a minimum of 15 seconds to avoid push out (Check IPEX's Installation Guide for Set & Cure times on Pg. 19).

10. Using a rag or dry cloth, remove all excess wet cement outside of the pipe-fitting joint.

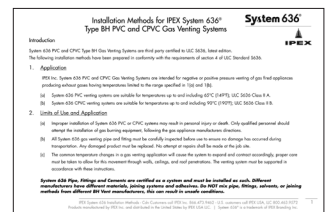
11. Once cure period has elapsed, joint should be pulled and twisted by hand. Should even a slight crack appear in the weld, the joint may need to be replaced.

For additional details, refer to the most current Installation Methods for IPEX System 636®.

Please visit www.ipexinc.com/system636 or Call 1-866-473-9462



DEB4 Deburring Tool



IPEX

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