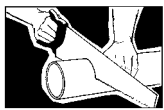


Installation instructions

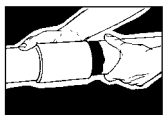
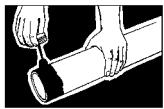
Cement joints



Carlton nonmetallic products are joined by means of solvent cement joints. Sizes ½ in. through 1½ in. should be cut square (using a fine tooth handsaw) and deburred.



For sizes 2 in. through 6 in. 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 non-critical utility applications where gap filling and leak testing are not required.

Average number of joints per can

Trade size (in.)	237 ml	473 ml	946 ml	3.78 L	120 ml	480 ml
½	140	275	550	2,200	70	275
¾	90	180	360	1,440	45	180
1	70	140	280	1,120	35	140
1¼	50	100	200	800	25	100
1½	37	75	150	600	18.5	75
2	20	40	80	320	10	40
2½	17	35	70	280	8.5	35
3	15	30	60	240	7.5	30
3½	13	27	54	216	6.5	27
4	12	25	50	200	6	25
5	9	19	38	150	N/A	N/A
6	6	12	24	95	N/A	N/A

Can: Average shelf-life of all Carlton cement is 24 months (unopened cans stored below 26° C.)

Spray: Average shelf-life of all Carlton spray PVC cement is 3 years.

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 ¼ 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 outlined above 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 ¼ turn.
7. Do not disturb until the joint is set.