

Technical Bulletin 6

Solvent Weld Jointing of Terrain Pipework & Fittings

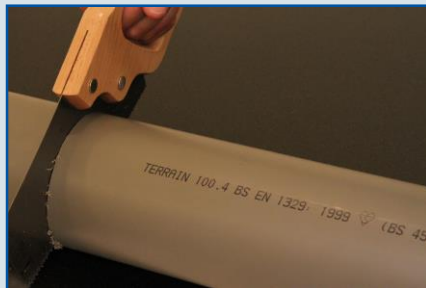
Terrain Soil and Waste fittings have been engineered to incorporate tapered socket connections to enhance the solvent weld joint.

The fittings also have an arrow showing the direction of flow; this is because the downstream connection has a tapered socket to ensure a fully watertight connection if installed correctly.

The following techniques apply to the Terrain 100, 200 and 500 drainage systems.

Step 1

Cut the pipe square and deburr the cut edge with a cloth or file



Step 2

Using a dirt free cloth, **clean** the external surface of the pipe and the internal surface of the fitting socket with an approved cleaning fluid.



The cleaning fluid is important because it:

- Removes dirt and dust which can hold a static charge.
- De-waxes the fitting/pipe, this is what you need to clean off (shine left on the product from the manufacturing process).
- Etches the surface, preparing it for jointing.
- Allows for quicker and stronger adhesion.

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TERRAIN

Step 3

Check the depth of the fitting socket and **mark** the pipe accordingly. This will ensure that when the joint is made, the pipe is fully inserted into the receiving socket.



Step 4

Coat both the mating surfaces with approved solvent **weld** cement using a clean brush. The etched surfaces allow the solvent cement to 'melt' the molecules on the surface of the pipe and fitting.



Step 5

Assemble the **joint** immediately, gently twisting the fitting and pipe together, and ensuring that the pipe is inserted to the previously made mark. Gently twisting the pipe and fittings enables the molecules to interlock, creating a homogenous joint. Remove any excess solvent weld with a clean rag.



If a joint is made correctly it will be strong and watertight, and will last for the lifetime of the installation.

5 Simple Steps

1. Cut Pipe Square
2. Clean
3. Mark
4. Weld
5. Push & Twist

For details on push-fit joints refer to Terrain Soil & Waste technical manual.

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