

# Jointing Procedures Made Easy

## Marley Flexible Rubber Ring Joint



### How to make a Rubber Ring Joint



1.

#### Check Spigot End

Ensure pipe spigot has full 15° chamfer around circumference and insertion depth mark. This should be 10-15mm less than the socket depth.



2.

#### Clean Socket & Rubber Ring

Clean socket and ring groove of dirt and loose gravel.

Clean Rubber Ring.



3.

#### Fit Rubber Ring

Place rubber ring in groove correct way around and check for proper seating.

Fin must point into pipe for Z-ring.



4.

#### Align pipes

Align pipes horizontally and vertically. Do not try to insert pipe at an angle to socket.



5.

#### Lubricate Spigot

Clean off dust and dirt and apply jointing lubricant to chamfer.

Keep end free from dirt.



6.

#### Insert Pipe

Insert spigot into socket to the marked distance. Do not use undue force. If force is required, check ring seating, using a torch to look up pipe.

# Solvent Cement Joint

## How to make a Solvent Cement Joint



**1. Mark & chamfer**  
Mark the socket depth on the pipe end.  
Cut a 15° chamfer on larger pipes.



**5. Apply Solvent**  
Apply an even coat of solvent to the socket and then the spigot to the full marked length.



**2. Clean**  
Clean, dry, degrease the socket and spigot.



**6. Joint**  
Insert the spigot the full marked depth in the socket and HOLD for a minimum of 30 seconds, depending on temperature.



**3. Check the fit**  
Insert the spigot into the socket (without solvent cement). An interference fit should occur between 1/3 and 2/3 of full entry.



**7. Clean Off**  
Remove the surplus solvent cement.



**4. Apply Priming Fluid**  
Apply an even coat of priming fluid to the socket and then the spigot. Note: Solvent Cement should be applied before Priming fluid completely dries off.

## Solvent Cement

Marley Solvent Cement is designed for solvent welding PVC pipe joints. IT IS NOT AN ADHESIVE. It is a blend of three aggressive solvents and sufficient resin to provide a brushing consistency.

When applied to the pipe surface these solvents cause the PVC to soften and swell. When two such surfaces are placed in close contact (as in a spigot and socket joint) the softened surfaces mix and on hardening produce a chemically welded joint. Oil, grease, water, or dust on the PVC surface prevents the softening; dust or similar material prevents the intimate contact between the surfaces, thus preventing the making of a full strength joint.

Solvent, which has thickened in the can through evaporation of the solvents, should not be used, as it will not soften the pipe surface sufficiently.

The solvents attack the natural oils in human skin eventually causing serious dermatitis.

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## Solvent Cement Coverage

The approximate number of joints that may be jointed with one litre is as follows:

SizeDN	Solvent Cement
15	600
20	350
25	260
32	190
40	140
50	85
65	70
80	60
100	50
125	40
150	30
200	25
225	15
300	10
375	10

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