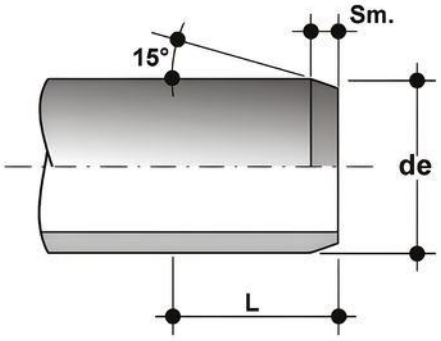
SOLVENT WELDING DATA

SOCKET DEPTH, CEMENT AND CHAMFER LENGTH

EXTERNAL DIAMETER		CEMENTING LENGTH L (mm)		CHAMFER Sm (mm)
Metric series de (mm)	BS series (inches)	Metric series	BS series	
16	3/8”	14	14.5	
20	1/2”	16	16.5	1.5
25	3/4”	18.5	19.5	3
32	1”	22	22.5	3
40	1” 1/4	26	27	3
50	1” 1/2	31	30	3
63	2”	37.5	36	5
75	2” 1/2	43.5	43.5	5
90	3”	51	50.5	5
110	4”	61	63	5
125	-	68.5	-	5
140	5”	76	76	5
160	6”	86	90	5
180	-	96	-	5÷6
200	-	106	-	5÷6
225	8”	118.5	115.5	5÷6
250	-	131	-	5÷6
280	10”	146	142.5	5÷6
315	12”	163.5	168	5÷6



BRUSHES AND APPLICATORS

EXTERNAL DIAMETER de (mm)	EXTERNAL DIAMETER de (inch)	TYPE AND DIMENSIONS OF BRUSH OR APPLICATOR
16 - 25	3/8” - 3/4”	Round (8 ÷ 10 mm)
32 - 63	1” - 2”	Round (20 ÷ 25 mm)
75 - 160	2” 1/2 - 6”	Rectangular / round (45 ÷ 50 mm)
>160	>6”	Rectangular / cylindrical (45 ÷ 50 mm)
>160 - 315	>6” - 12”	Rectangular / cylindrical (60 ÷ 65 mm)

SOLVENT WELDING DATA

THEORETICAL SOLVENT CEMENT CONSUMPTION

Rigid PVC-U pipes and fittings: approximate number of joints per kilogram of solvent cement.

PIPE / FITTING DIAMETER d (mm)	PIPE / FITTING DIAMETER d (inches)	NUMBER OF JOINTS PER kg OF SOLVENT CEMENT
16	3/8”	550
20	1/2”	500
25	3/4”	450
32	1”	400
40	1” 1/4	300
50	1” 1/2	200
63	2”	140
75	2” 1/2	90
90	3”	60
110	4”	40
125	-	30
140	5”	25
160	6”	15
180	-	12
200	-	10
225	8”	6
250	-	4
280	10”	2
315	12”	2

SOLVENT WELDING DATA

MOST COMMON DEFECTS

DEFECT	IMMEDIATE EFFECT	CONSEQUENCE
Solvent cement too fluid (incorrect diluent addition)	Cementing failure	Joint separation or leaks between the pipe and the fitting
Excess solvent cement	Internal and external runs beyond the joint zone	Weakening of the outer surface of the joint area and formation of bubbles with micro-cracks / sources of fracture in the base material
Excessively dense solvent cement due to evaporated solvent	Cementing failure	Joint separation or leaks between the pipe and the fitting; possible surface cracks triggering cracks in the base material
Insufficient and/or incorrect distribution of solvent cement	Cementing failure or local weakness	Joint separation or leaks between the pipe and the fitting
Incorrect pipe insertion (incomplete, excessive, misaligned)	Imperfect joint	Transmission of mechanical stresses from the pipe to the fitting and/or leaks from the joint
Impurities and/or humidity on the surfaces of the parts to join	Imperfect joint	Joint separation or leaks (fluid seepage) between the pipe and the fitting

Specifications are subject to change without notice.