

## Quick Guide – Jointing OsmaDrain

### Preparing Pipe Ends

Pipes cut on site must be clean cut at right angles to their horizontal axis. Deburr the cut end with a scraper.

### Depth of Entry Mark

Some plain ended fittings have a depth of entry mark moulded on the spigot. This depth of entry allows the pipe to expand into the fitting socket by a minimum of 12mm. Insert the spigot into the socket until the depth of entry mark is just visible.

All pipes (whether site cut or otherwise) and other plain ended fittings must be inserted to the full depth of the socket, marked at the socket face, and then withdrawn at least 12mm (See Figure. 10).

### Ring Seal Joints

Pipe couplers and most bends and junctions (in the 110mm and 160mm sizes) are supplied with sockets on all ends. These sockets are fitted with ring seals which act as both a sealing and expansion joint.

The correct sequence for ring seal jointing is as follows:

1. Check that the pipe is correctly prepared (See Pipe preparation, Figure. 11a) and that the ring seal is properly seated in its housing.
2. Make sure that both the pipe or fitting spigot and ring seal socket are dry, clean and free from grit or dust.
3. Lubricate evenly around the spigot (NOT the socket) with OsmaDrain Lubricant (4D392) (See Table 7).
4. Make sure that the components to be joined are correctly aligned.

5. Push the spigot fully into the socket. Mark the spigot at the socket face and then withdraw the spigot by a minimum of 12mm. If the spigot is already marked with the depth of entry, push it into the socket until the depth of entry mark is just visible.
6. Do not cut back the straight leg sections of Long Radius Bends (4D/6D281) as only the spigot end provided is suitable for jointing.

Table 7: Lubricant allowance (for guidance only) weights

Nominal Size (mm)	Approximate No. of joints (per 500g)
82	160
110	100
160	45

Figure 10: Ring Seal jointing

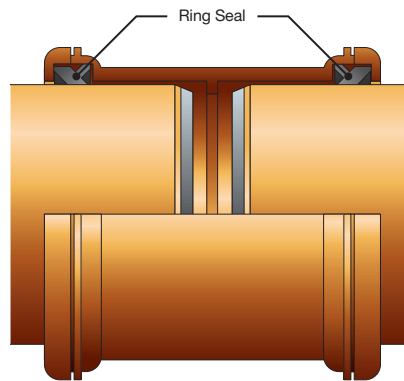


Figure 11a: Pipe preparation

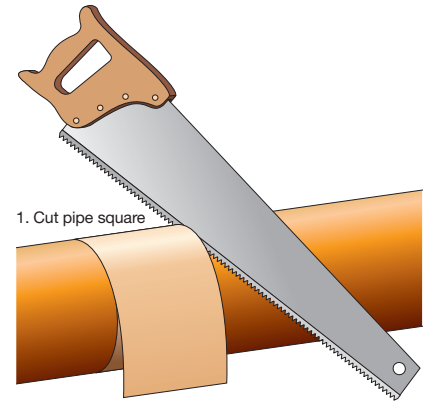
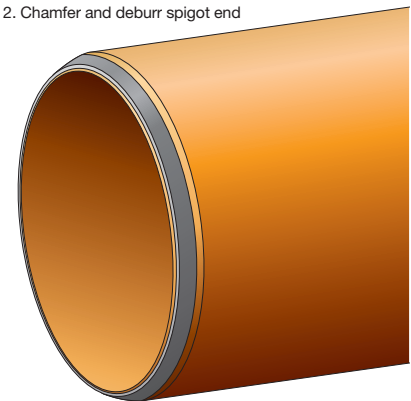


Figure 11b: Pipe end

2. Chamfer and deburr spigot end



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### Solvent Weld Joints

There are relatively few fittings which need to be solvent jointed. The correct sequence for solvent jointing is as follows (also see Figure. 12):

1. Ensure that the pipe has been cut cleanly and at right angles to its axis.
2. Clean swarf and other dirt from the pipe end.
3. Wipe the inside of the socket and the spigot of the pipe or fitting to remove any surface dirt.
4. To remove grease and prepare the surfaces of the socket and spigot, clean both surfaces with Osma Degreasing Cleaner No 1 (4D380) applied liberally on a clean nonsynthetic rag or absorbent paper.

5. Apply one coat of Solvent Cement No 2 (4D383) evenly, using a clean brush, to both the mating surfaces, stroking the cement along and not around the surfaces.
6. Immediately insert the spigot straight into the socket until the full socket depth is reached, hold for 20–30 seconds and remove any surplus cement from the mouth of the socket.
7. Each solvent joint must be completed within 1½ minutes.
8. The joint may be handled after 10 minutes and commissioned after 24 hours.

Do not thin Solvent Cement or Solvent Cement Filler. As these cements are solvent based it is essential to observe the normal precautions for solvents (see 'Safety' page 54).

### Boss Socket Connections

These may be made on the top of sealed inspection junction covers using either a 32mm or 40mm Boss Socket Adaptor (4S398/399).

Make the connection by drilling out the unperforated boss socket on the fitting using a standard 54mm hole cutter. Solvent weld as described in 'Solvent Weld Joints', pushing the adaptor the full depth along the keyway of the boss socket.

Table 8: Solvent cement allowance

Nominal Size (mm)	Approximate No. of joints (per 500g)
82	64
110	44
160	24

Figure 12: Solvent Welding – OsmaDrain Bottle Gully to Pipe spigot

