



HAYWARD INDUSTRIAL PRODUCTS

INSTALLATION DATA FOR

COMPACT VALVES

SOCKET CONNECTION:

Sockets are manufactured to ASTM D2467-87A. Solvent cementing of socket end connections to pipe should be performed per ASTM specifications D2855-87. Cut pipe square. Chamfer and deburr pipe. Surfaces must be cleaned and free of dirt, moisture, oil and other foreign material. Apply primer to inside socket surface of valve. Never allow primer or cement to contact valve ball as leaking may result. Use a scrubbing motion. Repeat applications may be necessary to soften the surface of the socket. Next, liberally apply primer to the male end of the pipe to the length of the socket depth. Again apply to the socket, without delay apply cement to the pipe while the surface is still wet with primer. Next apply cement lightly, but uniformly to the inside of the socket. Apply a second coat of cement to the pipe, and assemble the end connector to the pipe, rotating the pipe 1/4 turn in one direction as it is slipped to full depth on to the pipe. The valve should be held in position for approx. 30 seconds to allow the connection to "set". After assembly wipe off excess cement. Full set time is a minimum of 30 minutes at 60 to 100 F. Full cure time should be based on the chart below. VALVE MUST BE LEFT IN THE PARTIALLY OPEN POSITION DURING THE CURE CYCLE TO ALLOW THE CEMENT FUMES TO VENT.

JOINT CURE SCHEDULE:

The cure schedules are suggested as guides. They are based on laboratory test data, and should not be taken to be the recommendations of all cement manufacturers. Individual manufacturer's recommendations for their particular cement should be followed.

Temperature Range During Cure Period(A) °F(°C)	Test Pressures for Pipe		Test Pressures for Pipe	
	Sizes 1/2 to 1-1/4 In.		Sizes 1-1/2 to 3 In.	
	Up to 180 PSI (1240 kPa)	Above 180 PSI to 370 PSI (1240 to 2550 kPa)	Up to 180 PSI (1240 kPa)	Above 180 315 PSI (1240 to 2170 kPa)
60 to 100 (15 to 40)	1h	6h	2h	12h
40 to 60 (5 to 15)	2h	12h	4h	24h
20 to 40 (-7 to 5)	6h	36h	12h	72h
10 to 20 (-15 to 7)	8h	48h	16h	96h

Colder than 10 (-15)

Extreme care should be exercised on all joints made where pipe, fittings or cement is below 10°F

A: There cure schedules are based on laboratory test data obtained on Net Fit Joints (NET FIT) in a dry fit the pipe bottoms snugly in the fitting socket without meeting interference.

THREADED CONNECTION:

Threaded valve ends are manufactured to ASTM specifications D2464-88, F437-88 and ANSI B2.1. Wrap threads of pipe with Teflon tape of 3 to 3-1/2 mil thickness. The tape should be wrapped in a clockwise direction starting at the first or second full thread. Overlap each wrap by, 1/2 the width of the tape. The wrap should be applied with sufficient tension to allow the threads of a single wrapped area to show through without cutting the tape. The wrap should continue for the full effective length of the thread. Pipe size 2" will not benefit with more than a second wrap, due to the greater thread depth. To provide a leak proof joint, the pipe should be threaded into the end connection "hand tight". Using a strap wrench only. (Never use a stillson type wrench) tighten the joint an additional 1/2 to 1-1/2 turns past hand tight. Tightening beyond this point may induce excessive stress that could cause failure.

