

3/4" Riser Cap Installation Guide

1. Procedure for Solvent Welding PVC Riser to 3/4" Riser Cap.

- a. **Safety** – Solvent cements, primers, and cleaners for plastic pipe are made from flammable liquids. Refer to ASTM D2855 for proper safety precautions.
- b. **Joint Preparation** – Cut the PVC riser pipe square with the axis and chamfer or deburr end of pipe to be assembled into riser cap. Failing to chamfer or deburr the edge of the pipe may scrape and remove the cement from the fitting socket while assembling, leaving a void, and resulting in a leaking joint.
- c. **Cleaning** – Surfaces to be joined must be cleaned and be free of dirt, moisture, oil, and other foreign material. If this cannot be accomplished by wiping with a clean dry cloth, a chemical or mechanical cleaner must be used. If a chemical cleaner is used, apply with an applicator. Skin contact with chemical cleaners should be avoided.
- d. **Application Procedure: (For complete instructions, refer to ASTM D2855 – Standard Practice for Making Solvent-Cemented Joints with Poly(Vinyl chloride)(PVC) Pipe and Fittings)**
 - i. **Solvent Weld Primer and Cement** – the solvent weld primer and cement used are to meet the requirements of ASTM F656 and D2564 respectively.
 - ii. **Applying Primer and Cement** –
 1. Apply primer first to inside of riser cap socket using a brush and scrubbing the surface to ensure penetration.
 2. Apply primer to soften the surface of the male end of the riser pipe to the depth of the riser cap socket, making sure that the entire surface is well softened.
 3. Again brush the inside surface of the cap with primer and without delay apply cement to pipe while the surfaces are still wet with primer.
 4. Apply cement lightly but uniformly to inside socket, taking care to keep excess out of socket. This is to keep excess solvent cement from being pushed into the threaded or sealing surface of the cap during the solvent weld procedure.
 5. Apply second coat of cement to pipe end.
 - iii. **Assembly of Joint** – *Immediately* after applying the last coat of cement to pipe and while both surfaces to be mated are still SOFT and WET, forcefully bottom the male end of the riser pipe into the cap socket turning the pipe 1/4 turn during the assembly. The riser pipe is to be inserted until the end of the riser pipe and the bottom surface of the riser cap are flush. **In no case is the riser pipe to be inserted past the bottom of the riser cap socket.** (See Figure 1). A fixture that will not allow further penetration may be used to facilitate this stop. Assembly time is not to exceed 20 seconds after the last application of cement. Immediately wipe off any excess solvent weld material from the inside of the cap.
 - iv. **Setting of Joint** – Handle newly cemented joints carefully for at least 30 minutes to allow the proper fusing of the material. This time is temperature dependent. Refer to ASTM D2855 for setting times for lower temperatures.



Figure 1.

Riser pipe flush with bottom of riser cap socket.

2. Assembly of 3/4" Riser Cap and Riser to Certa-Set Sled Coupling

- a. **Assembly of O-Ring to Cap** – Assemble the o-ring that comes with the cap into the O-Ring groove located on the inside sealing surface of the cap (See Figure 2). Stretching the gasket slightly may help facilitate this assembly.
- b. **Lubrication of O-Ring** – using a small brush or rag, put an even coat of PVC Pipe Lubricant on the surface of the o-ring. This is very important to help facilitate even gasket compression during assembly of the cap to the sled.
- c. **Assembly of Riser Cap** – Making sure that the o-ring is seated properly in the o-ring groove; assemble the riser cap and riser assembly onto the Certa-Set Sled coupling by lining up the threads and twisting in a clockwise direction until snug. Compress the o-ring by tightening until the alignment arrow located on the outside of the riser cap (between the riser cap grips), is aligned with the middle of the gusset rib located on the opposite side of the coupling from the raised marking (See Figure 3). Please note older sled couplers may have a different thread configuration where the arrow will align slightly past the gusset rib. It is important to always tighten the cap until it is snug.



Figure 2.
Assembled O-ring.

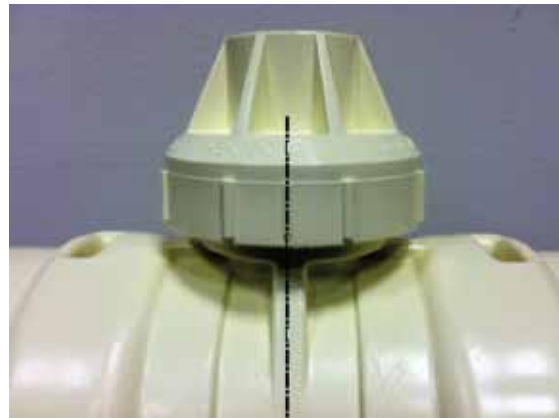


Figure 3.
Riser Cap Arrow Aligned with back gusset rib
of Certa-Set Sled.

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