

CONLEY LARGE DIAMETER (24" & 30") PIPE FIELD JOINT FABRICATION PROCEDURE

Large Diameter Pipe and Fittings utilize the same Straight Socket joining system as all Conley Piping Products. The Pipe and Fitting joint preparation and Dry-Fit procedures are exactly the same for all sizes. However, caution must be used when mixing and applying the adhesive. Because of the volume of adhesive required, four mixing boards and four mixers should be available to mix and apply the material.

The two most important factors when joining large diameter parts are: 1) Shade the pipe and fitting from direct sunlight to keep as cool as possible; and 2) Have both the pipe and fitting in position with the necessary equipment to push the pipe into the fitting or the fitting onto the pipe.

Begin mixing the adhesive per instructions with three of the mixers working with two 2-cup kits, and one of the mixers working with three 2-cup kits. After complete mixing, two of the men should start at the top or 12 o'clock position on the fitting socket, scrubbing-in the adhesive until they meet at the bottom or 6 o'clock position. The remaining two men should start at the top or 12 o'clock position of the pipe, scrubbing-in the adhesive until they meet at the bottom or 6 o'clock position.

Once scrubbed-in, apply the adhesive liberally to the outside of the pipe and only about ¼" thickness to the inside of the socket. Use all the adhesive that is mixed. Apply any excess to the outside of the pipe.

Push pipe straight into fitting (or fitting straight onto pipe), without twisting. Lock into place with pulling equipment and immediately make a fillet or bevel on the outside with the squeezed out adhesive, removing any excess to one of the mixing boards. Reach inside the fitting (if possible) and remove any excess adhesive there as well. Leave pulling equipment in place until adhesive is hard to the touch to avoid hydraulic "push-out" between the pipe and fitting.

The key to large joint fabrication is to move fast and smooth, and keep any mixed adhesive as thin as possible while fabricating.