

# FINOLEX PIPES



# FINOLEX CPVC

IS 15778



— PIPES AND FITTINGS —

IDEAL FOR HOT AND COLD WATER APPLICATIONS

## PRODUCT CATALOGUE



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# FINOLEX CPVC PIPES & FITTINGS

Finolex CPVC Pipes are our premium range of pipes for hot and cold water applications. Manufactured with the latest technology and using high grade raw material, the CPVC pipes can withstand higher temperatures as compared to many other plastic piping systems.

We recommend the use of our CPVC pipes for water supply and distribution in both domestic and industrial applications, and for solar and electric water heaters.

Finolex CPVC pipes are lightweight, non-corrosive and long lasting, which makes them a good substitute for GI and conventional pipes. These pipes are manufactured using lead free compounds. Hence they are safe, and health and environment friendly. Our stringent quality assurance approach across all stages of manufacturing gives this product a high degree of reliability, making it a preferred choice of leading MEP Consultants, architects, builders, plumbing contractors, plumbers, and quality conscious people.

CPVC plumbing pipes are available in sizes ranging from 15mm (1/2") to 50mm (2"), which conforms to IS 15778 in SDR 11 and 13.5 classes in 'Copper Tube Size' (CTS). These pipes are also available in 'Iron Pipe Size' (IPS) ranging from 65mm (2 1/2") to 150mm (6") in Schedule 40 and Schedule 80 series, which meet the requirements of ASTM F 441. Finolex CPVC pipes are plain ended and are available in standard lengths of 3 and 5 meters with various pressure ratings.

Although these pipes have similar physical properties, the classes differ in wall thickness and therefore at any given temperature their pressure ratings will differ. Finolex CPVC pipes are recommended for water temperature up to 82 °C. CPVC fittings are available in sizes from 15 mm (1/2") to 50 mm (2") and meet the requirement of ASTM D 2846 in Copper Tube Sizing (CTS). CPVC fittings from 65 mm (2.1/2") to 150 mm (6") in Schedule 40 and Schedule 80 are manufactured as per ASTM F 438 & ASTM F 439 respectively.

## PRESSURE DE-RATING FACTORS AT WORKING TEMPERATURES

Working Temperature		Pipe Derating factor
In °F	In °C	Finolex CPVC Pipes
73 - 80	23 - 27	1.00
90	32	0.91
100	38	0.82
120	49	0.65
140	60	0.50
160	71	0.40
180	82	0.25

## DIMENSIONS & PRESSURE RATING OF CTS SERIES CPVC PIPES

Conforming to IS 15778

Nominal Pipe Size in mm (inch)	SDR 11				SDR 13.5				Standard Pipe Length in Meters
	Outside Diameter in mm	Tolerance of OD in mm	Pressure Rating (kg/cm <sup>2</sup> )		Outside Diameter in mm	Tolerance of OD in mm	Pressure Rating (kg/cm <sup>2</sup> )		
			27°C	82°C			27°C	82°C	
			27.6	6.80			21.8	5.50	
			Wall Thickness (t) in mm				Wall Thickness (t) in mm		
Min	Max	Min	Max						
15 (1/2")	15.9	+/- 0.1	1.7	2.2	15.9	+/- 0.1	1.4	1.9	3, 5
20 (3/4")	22.2	+/- 0.1	2.0	2.5	22.2	+/- 0.1	1.7	2.2	3, 5
25 (1")	28.6	+/- 0.1	2.6	3.1	28.6	+/- 0.1	2.1	2.6	3, 5
32 (1 1/4")	34.9	+/- 0.1	3.2	3.7	34.9	+/- 0.1	2.6	3.1	3, 5
40 (1 1/2")	41.3	+/- 0.1	3.8	4.3	41.3	+/- 0.1	3.1	3.6	3, 5
50 (2")	54.0	+/- 0.1	4.9	5.5	54.0	+/- 0.1	4.0	4.6	3, 5

### Batch number logic:

Year	Month	Day	Mc.No.	Shift
xxxx	xx	xx	xxx	x

For example, the batch number of pipes produced on Mc. no. 20 on 1st June 2021 in the 1st shift will be 202106010201

## DIMENSIONS & PRESSURE RATING OF IPS SERIES CPVC PIPES

As per ASTM F 441

Nominal Pipe Size in mm (inch)	Schedule 40						Schedule 80						Standard Pipe Length in Meters
	Outside Diameter in mm	Tolerance of OD in mm	Wall Thickness (t) in mm		Pressure Rating at 23°C (kg/cm <sup>2</sup> )	Pressure Rating at 82°C (kg/cm <sup>2</sup> )	Outside Diameter in mm	Tolerance of OD in mm	Wall Thickness (t) in mm		Pressure Rating at 23°C (kg/cm <sup>2</sup> )	Pressure Rating at 82°C (kg/cm <sup>2</sup> )	
			Min	Max					Min	Max			
65 (2½")	73.00	+/- 0.18	5.16	5.77	21.10	5.30	73.00	+/- 0.18	7.01	7.85	29.57	7.34	3, 5
80 (3")	88.90	+/- 0.20	5.49	6.15	18.25	4.58	88.90	+/- 0.20	7.62	8.53	26.00	6.32	3, 5
100 (4")	114.30	+/- 0.20	6.02	6.73	15.50	3.87	114.30	+/- 0.20	8.56	9.58	22.53	5.60	3, 5
150 (6")	168.30	+/- 0.28	7.11	7.97	12.64	3.16	168.30	+/- 0.28	10.97	12.29	19.98	4.89	3, 5

## CPVC FITTINGS AT A GLANCE

### SDR 11 (As per ASTM-D 2846)

Type of Fittings	Size in inch
COUPLER	½" to 2"
ELBOW 90°	½" to 2"
ELBOW 90°-BRASS INSERT	½" to 1¼"
ELBOW 45°	½" to 2"
3 WAY ELBOW	¾" to 1"
TEE	½" to 2"
CROSS TEE	½" to 2"
TEE-BRASS INSERT	½" to 1¼"
END CAP	½" to 2"
MALE THREADED ADAPTER (M.T.A.)	½" to 2"
MALE THREADED ADAPTER (M.T.A.) - BRASS INSERT	½" to 2"
FEMALE THREADED ADAPTER (F.T.A.)	½" to 2"
FEMALE THREADED ADAPTER (F.T.A.) - BRASS INSERT	½" to 2"
UNION	½" to 2"
STEP OVER BEND	½" to 2"
TANK NIPPLE	½" to 2"
TANK NIPPLE SOCKET	½" to 2"
TRANSITION BUSH	½" to 2"
SWEEP BEND	¾" to 1¼"
PIPE CLIP	½" to 2"

### SDR 11 (As per ASTM D-2846)

Type of Fittings	Size in inch
POWDER COATED METAL CLAMP FOR CPVC PIPE	½" to 2"
CPVC BALL VALVE	½" to 2"
BALL VALVE ACCESSORIES - RED HANDLE	½" to 2"
REDUCER	¾" to 2"
REDUCING BUSH	¾" to 2"
REDUCING ELBOW 90°	¾" to 2"
REDUCING ELBOW 90° - BRASS INSERT	¾" to 1"
REDUCING TEE	¾" to 2"
REDUCING MALE THREADED ADAPTER (M.T.A.)	¾" to 1"
REDUCING MALE THREADED ADAPTER (M.T.A.) BRASS INSERT	¾" to 1"
REDUCING FEMALE THREADED ADAPTER (F.T.A.)	¾"
REDUCING FEMALE THREADED ADAPTER (F.T.A.) - BRASS INSERT	¾" to 1¼"
TEE HOLDER	½" to ¾"
HEX NIPPLE	½" to 1½"
NON RETURN VALVE	¾" to 1"
FLANGE WITH GASKET OPEN	1" to 2"
FLANGE WITH GASKET CLOSE	1" to 2"
MIXER 6" & 7"	¾" x ½"
CONCEALED VALVE (LONG & SHORT)	¾" to 1"

### SCH-80 (As per ASTM F-439)

Type of Fittings	Size in inch
COUPLER	2½" to 4"
ELBOW 90°	2½" to 4"
ELBOW 45°	2½" to 4"
TEE	2½" to 4"
END CAP	2½" to 4"
MALE THREADED ADAPTER (M.T.A.)	2½" to 4"
FEMALE THREADED ADAPTER (F.T.A.)	2½" to 4"
REDUCER	2½" to 4"
REDUCING BUSH	4"
REDUCING TEE	2½" to 3"
FLANGE WITH GASKET OPEN	2½" to 6"
FLANGE WITH GASKET CLOSE	2½" to 6"

### SCH-40 (As per ASTM F-438)

Type of Fittings	Size in inch
COUPLER	6"
ELBOW 90°	6"
ELBOW 45°	6"
TEE	6"
END CAP	6"
REDUCING BUSH	6"



# CPVC FITTINGS IN SDR 11

As per ASTM D 2846

Finolex offers an extensive range of superior quality CPVC fittings. These products provide unmatched installation options with excellent finish, high dimensional accuracy, and are suitable for all types of domestic and commercial installations.



## COUPLER

To join two lengths of pipes

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## ELBOW 90°

To give a 90° turn to a pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## ELBOW 90° - BRASS INSERT

To connect male threaded CP/Metal fittings like taps, showers, etc to a pipeline

mm	15	20	25	32
inch	½"	¾"	1"	1¼"



## ELBOW 45°

To give a 45° turn to a pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## 3 WAY ELBOW

To interconnect three pipes in different directions at 90°

mm	20	25
inch	¾"	1"



## TEE

To take a bypass or a service line from a main line

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## CROSS TEE

To take a double bypass or service line from a main line

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## TEE - BRASS INSERT

To connect male threaded CP/metal fittings like taps, showers, etc to the pipeline

mm	15	20	25	32	20 x 15	25 x 15
inch	½"	¾"	1"	1¼"	¾" x ½"	1" x ½"
mm	25 x 20		32 x 15			
inch	1" x ¾"		1¼" x ½"			



## END CAP

To plug the end of a pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## MALE THREADED ADAPTER (M.T.A.)

To connect female threaded fittings to the pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## MALE THREADED ADAPTER (M.T.A.) - BRASS INSERT

To connect female threaded CP/metal fittings like taps, showers, etc to the pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## FEMALE THREADED ADAPTER (F.T.A.)

To connect male threaded fittings to the pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



## FEMALE THREADED ADAPTER (F.T.A.) - BRASS INSERT

To connect male threaded CP/metal fittings like taps, showers, etc to the pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### UNION

To allow quick and convenient disconnection of pipes for maintenance or fixture replacement

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### STEP OVER BEND

To cross over an existing pipeline

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### TANK NIPPLE

To connect the pipeline to a tank

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### TANK NIPPLE SOCKET

To connect the pipeline to a tank. A socket is provided at one end of the tank nipple to connect with the pipe directly

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### TRANSITION BUSH

To connect ASTM PVC-U pipeline (IPS) to CPVC pipeline (CTS)

mm	15X15	20x20	25x25	32x32
inch	½" x ½"	¾" x ¾"	1" x 1"	1¼" x 1¼"
mm	40x40	50x50		
inch	1½" x 1½"	2" x 2"		



### SWEEP BEND

To give a 90° turn to a pipeline for smooth water flow

mm	20	25	32
inch	¾"	1"	1¼"



### PIPE CLIP

To fix and secure the pipeline to a wall or a flat surface

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### POWDER COATED METAL CLAMP FOR CPVC PIPE

To fix and secure the pipeline to a wall or a flat surface

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### CPVC BALL VALVE

To allow a quick and convenient disconnection of water supply for flow control in water supply lines

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### BALL VALVE ACCESSORIES - RED HANDLE

To use for on/off movement of Ball Valve

mm	15	20	25	32	40	50
inch	½"	¾"	1"	1¼"	1½"	2"



### REDUCER

To reduce the main line

mm	20 x 15	25 x 15	25 x 20	32 x 15
inch	¾" x ½"	1" x ½"	1" x ¾"	1¼" x ½"
mm	32 x 20	32 x 25	40 x 15	40 x 20
inch	1¼" x ¾"	1¼" x 1"	1½" x ½"	1½" x ¾"
mm	40 x 25	40 x 32	50 x 15	50 x 20
inch	1½" x 1"	1½" x 1¼"	2" x ½"	2" x ¾"
mm	50 x 25	50 x 32	50 x 40	
inch	2" x 1"	2" x 1¼"	2" x 1½"	



### REDUCING BUSH

To reduce the internal diameter of fittings

mm	20 x 15	25 x 15	25 x 20	32 x 15
inch	¾" x ½"	1" x ½"	1" x ¾"	1¼" x ½"
mm	32 x 20	32 x 25	40 x 15	40 x 20
inch	1¼" x ¾"	1¼" x 1"	1½" x ½"	1½" x ¾"
mm	40 x 25	40 x 32	50 x 15	50 x 20
inch	1½" x 1"	1½" x 1¼"	2" x ½"	2" x ¾"
mm	50 x 25	50 x 32	50 x 40	
inch	2" x 1"	2" x 1¼"	2" x 1½"	



### REDUCING ELBOW 90°

To give a 90° turn to the pipeline and connect with a reduced pipeline

mm	20 x 15	25 x 15	25 x 20	32 x 15
inch	¾" x ½"	1" x ½"	1" x ¾"	1¼" x ½"
mm	32 x 20	32 x 25	40 x 20	40 x 25
inch	1¼" x ¾"	1¼" x 1"	1½" x ¾"	1½" x 1"
mm	50 x 25			
inch	2" x 1"			



### REDUCING ELBOW 90° - BRASS INSERT

To give a 90° turn to the pipeline and connect male threaded fittings

mm	20 x 15	25 x 15	25 x 20
inch	¾" x ½"	1" x ½"	1" x ¾"



### REDUCING TEE

To take a reducing bypass or service line from the main line

mm	20 x 15	25 x 15	25 x 20	32 x 15
inch	¾" x ½"	1" x ½"	1" x ¾"	1¼" x ½"
mm	32 x 20	32 x 25	40 x 15	40 x 20
inch	1¼" x ¾"	1¼" x 1"	1½" x ½"	1½" x ¾"
mm	40 x 25	40 x 32	50 x 20	50 x 25
inch	1½" x 1"	1½" x 1¼"	2" x ¾"	2" x 1"
mm	50 x 32	50 x 40		
inch	2" x 1¼"	2" x 1½"		



### REDUCING MALE THREADED ADAPTER (M.T.A.)

To connect female threaded fittings to a bigger pipeline

mm	20 x 15	25 x 20
inch	¾" x ½"	1" x ¾"



### REDUCING MALE THREADED ADAPTER (M.T.A.) - BRASS INSERT

To connect female threaded CP/metal fittings like taps, showers, etc to a bigger pipeline

mm	20 x 15	25 x 15	25 x 20
inch	¾" x ½"	1" x ½"	1" x ¾"



### REDUCING FEMALE THREADED ADAPTER (F.T.A.)

To connect male threaded fittings to a bigger pipeline

mm	20 x 15
inch	¾" x ½"



### REDUCING FEMALE THREADED ADAPTER (F.T.A.) - BRASS INSERT

To connect male threaded CP/metal fittings like taps, showers, etc to a bigger pipeline

mm	20 x 15	25 x 15	25 x 20	32 x 15
inch	¾" x ½"	1" x ½"	1" x ¾"	1¼" x ½"



### TEE HOLDER

To hold or support the tee component in a pipeline

mm	15 X 15	20 X 15
inch	½" x ½"	¾" x ½"



### HEX NIPPLE

To connect two female threaded fittings on either side

mm	15	20	25	32	40
inch	½"	¾"	1"	1¼"	1½"



### NON RETURN VALVE

To allow /control flow of water in only one direction

mm	20	25
inch	¾"	1"

## FLANGE

A flange is a method of connecting pipes, valves, pumps, and other equipment to form a piping system. It provides easy access for cleaning, inspection, or modification. Available in following options:



### FLANGE WITH GASKET - OPEN

mm	25	32	40	50
inch	1"	1¼"	1½"	2"



### FLANGE WITH GASKET - CLOSE

mm	25	32	40	50
inch	1"	1¼"	1½"	2"

## MIXER ADAPTERS

A wall mixer unit allows to draw water from both hot and cold sources and combine into a single flow. These mixers are available in 6" & 7" sizes in the following options:



### ALL TOP 6" & 7" MIXER

mm	20 x 15
inch	¾" x ½"



### TOP BOTTOM 6" & 7" MIXER

mm	20 x 15
inch	¾" x ½"



### TOP SIDE 6" & 7" MIXER

mm	20 x 15
inch	¾" x ½"



### HOT UP COLD DOWN 6" & 7" MIXER

mm	20 x 15
inch	¾" x ½"



### HOT SIDE COLD DOWN 6" & 7" MIXER

mm	20 x 15
inch	¾" x ½"

# CONCEALED VALVES

A concealed valve allows quick and convenient disconnection of concealed water supply lines. These concealed valves are available in Full and Quarter Turn.

## LONG CONCEALED VALVE

### SQUARE KNOB TYPE



LONG QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

LONG FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

### TRIANGLE KNOB TYPE



LONG QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

LONG FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

### ROUND KNOB TYPE



LONG QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

LONG FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

## SHORT CONCEALED VALVE

### SQUARE KNOB TYPE



SHORT QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

SHORT FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

### TRIANGLE KNOB TYPE



SHORT QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

SHORT FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

### ROUND KNOB TYPE



SHORT QUARTER TURN	mm	15	20	25
	inch	½"	¾"	1"

SHORT FULL TURN	mm	15	20	25
	inch	½"	¾"	1"

# CPVC FITTINGS IN SCHEDULE 40

As per ASTM F 438



### SCH 40 - COUPLER

To join two lengths of pipes

mm	150
inch	6"



### SCH 40 - ELBOW 90°

To give a 90° turn to a pipeline

mm	150
inch	6"



### SCH 40 - ELBOW 45°

To give a 45° turn to a pipeline

mm	150
inch	6"



### SCH 40 - TEE

To take a bypass or a service line from the main line

mm	150
inch	6"



### SCH 40 - END CAP

To plug the end of a pipeline

mm	150
inch	6"



### SCH 40 - REDUCER BUSH

To reduce the internal diameter of fittings

mm	150X50	150X65	150X80	150X100
inch	6"x2"	6"x2½"	6"x3"	6"x4"

# CPVC FITTINGS IN SCHEDULE 80

As per ASTM F 439



## SCH 80 - COUPLER

To join two lengths of pipes

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - ELBOW 90°

To give a 90° turn to a pipeline

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - ELBOW 45°

To give a 45° turn to a pipeline

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - TEE

To take a bypass or a service line from the main line

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - END CAP

To plug the end of a pipeline

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - MALE THREADED ADAPTER (M.T.A.)

To connect female threaded fittings to the pipeline

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - FEMALE THREADED ADAPTER (F.T.A.)

To connect male threaded fittings to the pipeline

mm	65	80	100
inch	2½"	3"	4"



## SCH 80 - REDUCER

To reduce the main line.

mm	65 x 15	65 x 20	65 x 25	65 x 32
inch	2½" x ½"	2½" x ¾"	2½" x 1"	2½" x 1¼"
mm	65 x 40	65 x 50	80 x 15	80 x 20
inch	2½" x 1½"	2½" x 2"	3" x ½"	3" x ¾"
mm	80 x 25	80 x 32	80 x 40	80 x 50
inch	3" x 1"	3" x 1¼"	3" x 1½"	3" x 2"
mm	80 x 65	100 x 15	100 x 20	100 x 25
inch	3" x 2½"	4" x ½"	4" x ¾"	4" x 1"
mm	100 x 32	100 x 40	100 x 50	100 x 65
inch	4" x 1¼"	4" x 1½"	4" x 2"	4" x 2½"
mm	100 x 80			
inch	4" x 3"			



## SCH 80 - REDUCER BUSH

To reduce the internal diameter of fittings

mm	100 x 40	100 x 50	100 x 65	100 x 80
inch	4" x 1½"	4" x 2"	4" x 2½"	4" x 3"



## SCH 80 - REDUCING TEE

To take a reducing bypass or service line from the main line

mm	65 x 15	65 x 20	65 x 25	65 x 32
inch	2½" x ½"	2½" x ¾"	2½" x 1"	2½" x 1¼"
mm	65 x 40	65 x 50	80 x 15	80 x 20
inch	2½" x 1½"	2½" x 2"	3" x ½"	3" x ¾"
mm	80 x 25	80 x 32	80 x 40	80 x 50
inch	3" x 1"	3" x 1¼"	3" x 1½"	3" x 2"
mm	80 x 65			
inch	3" x 2½"			



## SCH 80 - FLANGE WITH GASKET - OPEN

mm	65	80	100	150
inch	2½"	3"	4"	6"



## SCH 80 - FLANGE WITH GASKET - CLOSE

mm	65	80	100	150
inch	2½"	3"	4"	6"

# FINOLEX SOLVENT CEMENT & PRIMER

## CPVC SOLVENT CEMENT



CPVC Solvent Cement  
for Hot and Cold Water  
plumbing applications  
Yellow Medium Bodied  
(Up to 2")  
(Meets ASTM F 493 standard)

ml	59	118	237	473	946
Container	Tin	Tin	Tin	Tin	Tin



CPVC Solvent Cement  
for Hot and Cold Water  
plumbing applications  
Orange Heavy Bodied  
(Above 2")  
(Meets ASTM F 493 standard)

ml	118	237	473	946
Container	Tin	Tin	Tin	Tin

## PRIMER



Primer for PVC-U and  
CPVC plumbing applications  
(Meets ASTM F 656 standard)

ml	237
Container	Tin

## PRECAUTIONS

- Brush must be clean and dry before commencing the solvent welding process.
- System should be pressure tested before concealment.
- Do not attempt cementing in rain or in moist conditions.
- Cement should be used within the expiry period mentioned on the container.
- Use of primer prior to the solvent cement joint is essential for pipe sizes 65mm (2 1/2") and above. This will increase the joint strength.
- Keep cement away from all sources of ignition, heat, spark, and open flame.
- Keep cement containers tightly closed after use.
- Store solvent cements and pipe component in a cool area.



# JOINTING:

1. Measuring



2. Cutting



3. Deburring and chamfering



4. Cleaning



5. Check dry-fit



6. Solvent cement application



7. Assembly



## SOLVENT SET AND CURE SCHEDULE GUIDELINES

### AVERAGE INITIAL SET SCHEDULE FOR CPVC SOLVENT CEMENT

Set schedule is the necessary time to be allowed before the joint can be carefully handled.

(In damp or humid weather allow 50% more set time than recommended.)

Temperature Range	Pipe Size	Pipe Size	Pipe Size
	½" to 1¼"	1½" to 2"	2½" to 6"
16°C to 38°C	2 minutes	5 minutes	30 minutes
5°C to 16°C	5 minutes	10 minutes	2 hours
-18°C to 5°C	10 minutes	15 minutes	12 hours

### AVERAGE JOINT CURE SCHEDULE FOR CPVC SOLVENT CEMENT

Joint cure schedule is the necessary time to be allowed before pressurizing the system.

(Allow 50% more set time in damp or humid weather)

Temperature Range	Pipe Size		Pipe Size		Pipe Size	
	½" to 1¼"		1½" to 2"		2½" to 6"	
Temperature range during assembly and cure period	Up to 11 Kg/cm <sup>2</sup>	11 to 22 Kg/cm <sup>2</sup>	Up to 11 Kg/cm <sup>2</sup>	11 to 22 Kg/cm <sup>2</sup>	Up to 11 Kg/cm <sup>2</sup>	11 to 22 Kg/cm <sup>2</sup>
16°C to 38°C	15 minutes	6 hours	30 minutes	12 hours	1-1½ hours	24 hours
5°C to 16°C	20 minutes	12 hours	45 minutes	24 hours	4 hours	48 hours
-18°C to 5°C	30 minutes	48 hours	1 hours	96 hours	72 hours	8 days

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## INSTALLATION OF CPVC PIPES WITH SOLAR WATER HEATERS

- CPVC SDR 11 pipes are recommended for use with solar water heaters in the main line.
- Based on the height of the building, it is necessary to provide expansion and contraction loops in case of exposed pipes used in solar water heater installations.
- It is strongly recommended that solar water heaters must be installed with thermo-regulating valves. However, if thermo-regulating valves are unavailable, air-venting on the hot water outlet side must be provided.
- Only brass transition fittings must be used for all connections with solar water heaters.
- Ensure that proper pipe clamp support is provided.
- When used with gas water heaters, CPVC pipes and fittings should not be directly connected to the heater. At least 150mm (6") clearance from the flame is recommended. For the initial portion a long metal nipple or GI pipes must be used.
- Finolex CPVC pipes can be directly connected to the electrical water heater with special metal-to-CPVC transition fittings.
- Don't thread, groove, or drill CPVC pipes.

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## CERTIFICATIONS & APPROVALS

- Pipes are manufactured conforming to IS 15778 (Bureau of Indian Standards)
- Pipes, fittings and solvent cement comply with ASTM D 2846, ASTM F 441, ASTM F 438, ASTM F 439 & ASTM F 493
- Tested and approved by Central Institute of Plastics Engineering & Technology (CIPET)
- Tested and approved by Department of Metallurgical Engineering and Material Science, Indian Institute of Technology Mumbai (IIT Mumbai)
- Certified by Shriram Institute for Industrial Research (SIIR)
- Certified by Central Food Technological Research Institute, Mysore (CFTRI)

# FEATURES & BENEFITS

-  Manufactured using lead-free and environmentally friendly compounds
-  UV stabilised
-  Ideal for hot and cold water applications
-  Low thermal expansion
-  Safe for potable water systems
-  Unaffected by chlorine in water
-  Outstanding fire safety profile
-  Insulating properties result in high energy saving
-  High impact strength
-  Leak-proof joints
-  No corrosion resulting in uncompromised water quality
-  No scaling, pitting, or leach formation
-  Cost-effective
-  Easy installation
-  Stringent quality control
-  Manufactured from high grade raw material

# APPLICATIONS

Finolex CPVC pipes are ideal for hot and cold water distribution systems for indoor and outdoor applications. This system is widely used with solar and electric water heaters in:

-  Individual homes and residential apartments
-  Hotels and resorts
-  Hospitals
-  High-rise buildings as well as independent houses
-  Corporate houses and commercial establishments
-  Swimming pools
-  Academic institutions
-  Manufacturing plants

Note: Not suitable for compressed air and gases.

## Finolex Industries Limited

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### Disclaimer:

• Specifications are subject to change without prior notice. • The product images shown are for illustration purposes only and may not be an exact representation of the product. • The product images or other information cannot be construed as guarantee or suitability for a particular application. • Warranty applicable only for manufacturing defects when products are installed as per our standard guidelines and usage. • Warranty is not applicable if any other brand's products are used in combination with Finolex products. • In any case, the manufacturer/ seller's liability towards any claim is limited to replacement of, or credit for the defective product excluding any allied or incidental expenses. The manufacturing defect should be brought to notice within 24 months from manufacturing date.

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