



Standard Practice for the Two-Step (Primer and Solvent Cement) Method of Joining Poly (Vinyl Chloride) (PVC) or Chlorinated Poly (Vinyl Chloride) (CPVC) Pipe and Piping Components with Tapered Sockets¹

This standard is issued under the fixed designation D2855; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This practice describes a two-step (primer and solvent cement) method of joining poly(vinyl chloride) (PVC) or chlorinated poly(vinyl chloride) (CPVC) pipe and piping components with tapered sockets.

NOTE 1—Simplified procedures may be allowed in non-pressure applications where local codes permit.

NOTE 2—Where conflicts occur between the code and the manufacturer's installation instructions, the more restrictive provisions apply.

1.2 The products covered by this practice are intended for use with the distribution of pressured liquids only, which are chemically compatible with the piping materials. Due to inherent hazards associated with testing components and systems with compressed air or other compressed gases, some manufacturers do not allow pneumatic testing of their products. Consult with specific product/component manufacturers for their specific testing procedures prior to pneumatic testing.

NOTE 3—Pressurized (compressed) air or other compressed gases contain large amounts of stored energy which present serious safety hazards should a system fail for any reason.

1.3 This standard practice does not address the one-step method of joining pipe and piping components with tapered sockets with solvent cement without the use of primer.

1.4 The techniques covered are applicable to joining PVC to PVC or CPVC to CPVC pipe and piping components with tapered sockets. In the remainder of this standard practice, the term "piping components with tapered sockets", whether it be bell end pipe, spigot connections, or any other type of tapered connections, will be referred to as "fittings."

1.5 A partial list of standards for PVC and CPVC pipe, piping components, and solvent cements suitable for use in joining pipe and fittings is given in [Appendix X1](#).

1.6 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.7 The text of this practice references notes and footnotes that provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the practice.

1.8 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- [D1600 Terminology for Abbreviated Terms Relating to Plastics](#)
- [D1784 Specification for Rigid Poly\(Vinyl Chloride\) \(PVC\) Compounds and Chlorinated Poly\(Vinyl Chloride\) \(CPVC\) Compounds](#)
- [D1785 Specification for Poly\(Vinyl Chloride\) \(PVC\) Plastic Pipe, Schedules 40, 80, and 120](#)
- [D2241 Specification for Poly\(Vinyl Chloride\) \(PVC\) Pressure-Rated Pipe \(SDR Series\)](#)
- [D2466 Specification for Poly\(Vinyl Chloride\) \(PVC\) Plastic Pipe Fittings, Schedule 40](#)
- [D2467 Specification for Poly\(Vinyl Chloride\) \(PVC\) Plastic Pipe Fittings, Schedule 80](#)
- [D2564 Specification for Solvent Cements for Poly\(Vinyl Chloride\) \(PVC\) Plastic Piping Systems](#)
- [D2665 Specification for Poly\(Vinyl Chloride\) \(PVC\) Plastic Drain, Waste, and Vent Pipe and Fittings](#)

¹ This practice is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.20 on Joining.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.