

4715.0810 PLASTIC JOINTS.

Subpart 1. **Joint methods.** Every joint in plastic piping must be made with approved fittings using solvent welded connections, fusion welded connections, insert fittings with metal clamps and screws of corrosion-resistant material or approved crimp rings, threaded joints according to accepted standards, or special IAPMO listed fittings of other types. Large diameter water service pipe may have approved elastomeric-gasket push-on type joints which comply with ASTM D 3139. All solvent materials must meet approved recognized standards. Expansion and contraction joint materials and dimensions must conform to ASTM D 2661 or ASTM D 2665 and shall be of an approved type. Gasketed sewer fittings must comply with ASTM F1336.

Subp. 2. **Primer.** Solvent weld joints in PVC and CPVC pipe must include use of a primer of contrasting color to the pipe and cement. Primers must comply with the National Sanitation Foundation (NSF) Standard Number 14. A mechanical method of preparing PVC or CPVC pipe for solvent cement is not acceptable in lieu of using a primer.

Exception: A one-step solvent cement complying with ASTM F493 and ASTM D2846 may be used for CPVC pipe.

Subp. 3. **Fusion welding.** Fusion-weld connections in polypropylene pipe shall include socket-fusion, butt-fusion, electro-fusion, and fusion outlet branch fittings. Fusion welding shall be in accordance with ASTM F2389.

Statutory Authority: *MS s 16B.59 to 16B.75; 326.37 to 326.45; 326B.101 to 326B.194; 326B.43 to 326B.49*

History: *11 SR 1405; 15 SR 76; 19 SR 590; 23 SR 686; L 2007 c 140 art 4 s 61; art 6 s 15; art 13 s 4; L 2008 c 337 s 64; 33 SR 2042*

Published Electronically: *May 14, 2012*