

THE HARMONY OF PIPES, FITTINGS AND VALVES

DESIGNED
ENGINEERED &
MADE IN AUSTRIA



1. perfect tolerances acc. ISO 727/DIN8063
2. producer, material, dimension, pressure rate
3. indication of socket length on the PVC pipe
4. production date
5. brand IBG
6. 90°/45° marking for installation

IBG

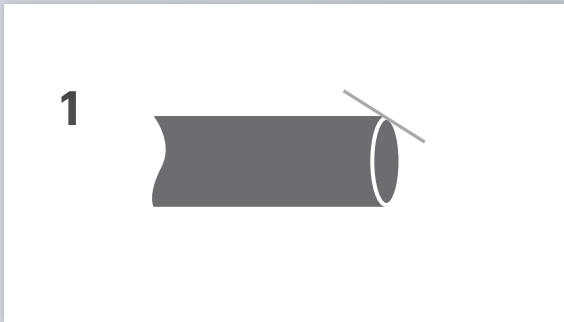
PIPES & FITTINGS – WELLNESS FOR THE POOL WATER

The globally known and world-valued IBG® pipes and fittings are produced with smallest possible tolerances and match in a perfect way. The exactly processed plastic material PVC-U (polyvinyl chloride without plasticizer), is particularly suitable for demanding and custom-fit piping systems. Praher works exclusively with raw material from certified manufacturers/suppliers. This raw material is tested ongoing, also by external authorities.

The advantages of IBG® PVC-U pipes are obvious :

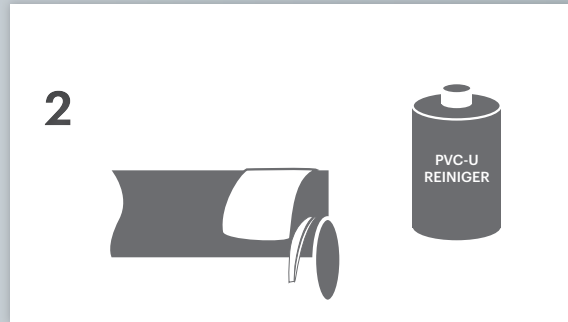
- » excellent chemical resistance, easy installation (also due to the low weight of the material)
- » easy installation with special pipe clamps (type A, B and C)
- » best suitability for the swimming pool industry for different joining techniques (gluing, thread, flange,...) in many shapes and dimensions
- » Guaranteed lasting and secure connections (average lifetime up to 50 years)
- » Optimal price-performance ratio
- » Praher PVC pipe systems and fittings match perfectly in order to reduce the handling time

INSTRUCTION FOR CORRECT INSTALLATION OF IBG® PVC-U PIPING SYSTEMS



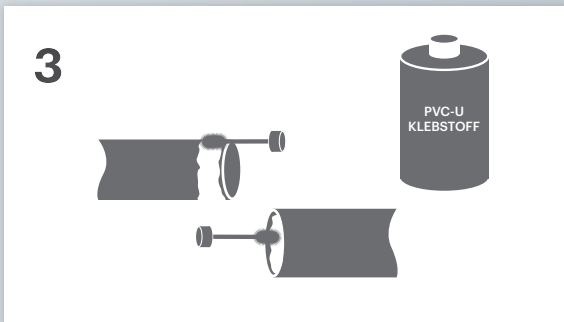
1 PREPARING

Chamfering and deburring of the pipe end with the cutter. Gluing only to be done at temperatures more than 8°C. At the temperature of approx. 8°C the pipe end has to be tempered to handwarm condition.



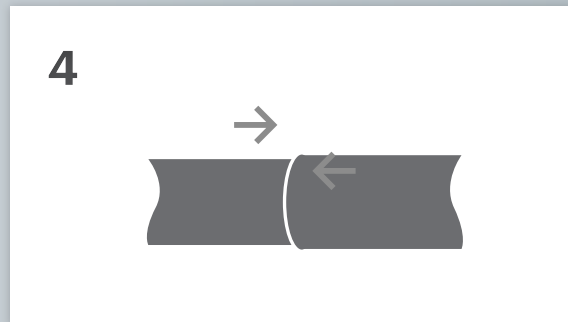
2 CLEANING

For optimal adhesion, the surfaces have to be dry and free from dirt. Additional cleaning of the pipe end on the outside and inside with waterleaf paper and cleaner.



3 APPLYING SOLVENT

Stir the solvent and apply the brush with the solvent substantially. Apply a thin film of the solvent on the inner side of the socket axial (from inner part to the outer part). Please also apply enough solvent on the end of the pipe (also axial, press the brush). Drying time depends from the temperature and quantity of solvent (4 min./20°C up to <1 in./ 40°C).



4 CONNECTING

Instantly push the pipe in the socket without torsion or twist. Fix the connection till the glue is adhering. From DN 150 pipe dimension please use a suitable tool for pushing pipe. Remove the excess glue with waterleaf paper.



CAUTION!
CONSIDER DRYING TIME

Move the pipes earliest 5 min. after the gluing process, at a temperature under +10°C the time minimum 15min after the gluing process. Lowering of the pipes after 10 – 12 hours. Filling of the piping system and pressure test up to a test pressure of 1,5 x PN earliest after 24 hours after the last glueing process. In case the piping has to be loaded with operation pressure (reparation) please stick to the rule: per 1 bar operation pressure 1 hour time to wait. Pipes which are not in immediate operation have to be rinsed or left filled with water.