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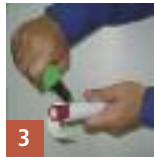
**IPS THREADED** SYSTEM



The cutting angle must be 90° (straight and perpendicular). The pipe cutter can be used to cut pipes of up to 1", above that it is recommended to use a hacksaw.



Clean the area to be threaded of dust and grease. Remove any burrs. To do so a cutter can be used.



When using 4x4 Plus pipes remove the thermoplastic foam with a cutter to fit the thread and the guide of the threading tool.



In order to thread a pipe, place the threading tool guide with the threading tool dies at one end of the pipe. Apply some pressure to get a bite on the pipe. Turn the tool with one hand first. Then continue turning with both hands.



Spread IPS Plussealant on the threads of the male thread. For fittings above 1" we recommend applying hemp fiber on the sealant (without exceeding the crests of the thread) and then applying another coat of sealant.



Place the fitting on the pipe and thread as far as it will go. In the case of wide diameters use channel lock pliers or a Stillson wrench.