



IPS®

WELD·ON

Guide to Solvent Cementing PVC and CPVC Plastic Pipe and Fittings



This guide describes the basic principles for solvent cementing plastic pipe and fittings and gives recommended techniques for making high strength joints in a wide variety of conditions.

IPS Corporation was the first company to produce reliable solvent cements for use with PVC, CPVC and ABS pipe and fittings.

Each Weld-On formulation has been developed for a specific application and is subject to the strictest quality control program in the industry. This program guarantees the most consistent and highest quality solvent cements commercially available.

IPS solvent cements, primers and accessories are shipped worldwide to customers in such diverse fields as construction, agriculture, swimming pools and spas, automotive, aerospace and general manufacturing.

Our products are intended for use by skilled individuals at their own risk. When you use Weld-On products, rest assured you are using the highest quality products commercially available, so insist on Weld-On!

The solvent cemented connection in thermoplastic pipe and fittings is the last vital link in a plastic pipe installation. It can mean the success or failure of the system as a whole. Accordingly, it requires the same professional care and attention that is given to other components of the system.

We feel that if the basic principles involved are explained, known and understood, a better understanding would be gained as to what techniques are necessary to suit particular applications, temperature conditions and variations in sizes of pipe and fittings.

This guide was developed to aid the installer in the proper techniques needed for the joining of plastic pipe and fittings.

The suggestions and data in this guide are based on information we believe to be reliable. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Also, it is recommended that installers receive personal instruction from trained instructors or competent, experienced installers. Contact us or your supplier for additional information or instruction.

If you have any questions on the material in this guide or need further assistance, please give us a call. Our toll free number is **800-421-2677**.

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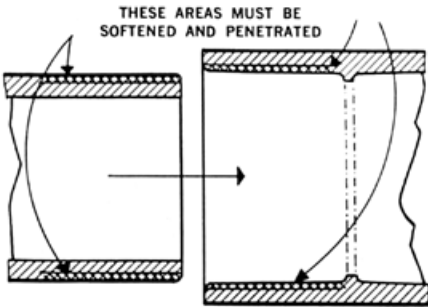


BASIC PRINCIPLES OF SOLVENT CEMENTING

To make consistently good joints, the following points should be clearly understood.

1. The joining surfaces must be softened and made semifluid.
2. Sufficient cement must be applied to fill gap between pipe and fitting.
3. Assembly of pipe and fittings must be made while the surfaces are still wet and cement is still fluid.
4. Joint strength develops as the cement dries. In the tight part of the joint the surfaces will tend to fuse together; in the loose part, the cement will bond to both surfaces.

These areas must be softened and penetrated.



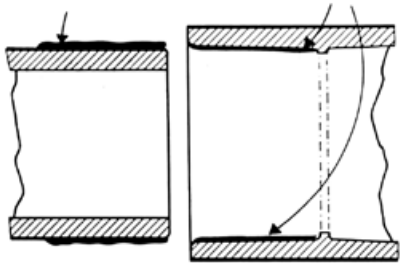
Penetration and softening can be achieved by the cement itself, by using a suitable primer or by the use of both primer and cement. For certain materials and in certain situations, it is necessary to use a primer. A suitable primer will usually penetrate and soften the surfaces more quickly than cement alone. Additionally, the use of a primer can provide a safety factor for the installer, for he can know under various temperature conditions when sufficient softening has been achieved. For example, in cold weather more time and additional applications may be required.

Sufficient cement to fill the loose part of the joint must be applied. Besides filling the gap, adequate cement layers will penetrate the surfaces and also remain wet until the joint is assembled. Prove this for yourself. Apply on the top surface of a piece of pipe two separate layers of cement.

First apply a heavy layer of cement; then along side it, apply a thin brushed out layer. Test the layers every 15 seconds or so by a gentle tap with your finger. You

will note that the thin layer becomes tacky and then dries quickly (probably within 15 seconds); the heavy layer will remain wet much longer. A few minutes after applying these layers check for penetration. Scrape the surface of both with a knife. The thin layer will have achieved little or no penetration; the heavy one will have achieved much more penetration.

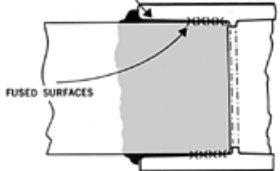
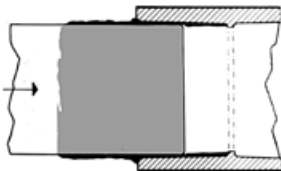
CEMENT COATINGS OF SUFFICIENT THICKNESS



If the cement coatings on the pipe and fittings are wet and fluid when assembly takes place, they will tend to flow together and become one cement layer. Also, if the cement is wet, the surfaces beneath them will still be soft and these softened surfaces in the tight part of the joint will tend to fuse together. As the solvent dissipates, the cement layer and the softened surfaces will harden with a corresponding increase in joint strength. A good joint will take the required working pressure long before the joint is fully dry and final joint strength is obtained. In the tight (fused) part of the joint, strength will develop more quickly than in the looser (bonded) part of the joint. Information about the development of bond strength of solvent cemented joints is available in this manual (page 22).

SURFACES MUST BE ASSEMBLED WHILE THEY ARE WET AND SOFT

BONDED SURFACES



SOLVENT CEMENTING WITH PRIMER

1. Assemble proper materials for the job (proper primer, cement, if necessary - cleaner, and applicator for the size of pipe and fittings to be assembled).

2. Pipe must be cut as square as possible. Use a miter box saw or power saw. Check the end of the pipe with a square to make sure it has been cut squarely. A diagonal cut reduces bonding area in the most effective and critical part of the joint.



3. Plastic tubing cutters may also be used for cutting plastic pipe; however, some produce a raised bead at the end of the pipe. This bead must be removed with a file or deburring tool, as it will scrape the cement away when pipe is inserted into the fitting.



4. Remove inside diameter burrs or raised beads with an internal deburring tool or knife. Remove the burrs or raised beads on the outside diameter of the pipe by using a file or external deburring tool that will produce a $\frac{3}{32}$ " , 10-15° chamfer (bevel). Burrs can scrape channels into pre-softened surfaces or create hang-ups across the inside fitting diameter.



5. With a clean-dry rag, remove any dirt, grease, shavings or moisture from the inside and outside of the pipe and fitting. A thorough wipe is usually sufficient. (Moisture will retard cure and dirt, grease, or any foreign material can prevent proper fusion).



6. Check pipe and fittings for dry fit before cementing. For proper interference fit, fitting should go over end of pipe easily but become tight about $\frac{1}{3}$ to $\frac{2}{3}$ of the way on. Too tight a fit is not desirable; you must be able to fully bottom the pipe in the socket during assembly. If the pipe and fittings are not out of round, a satisfactory joint can be made if there is a "net" fit, that is, the pipe bottoms in the fitting socket with no interference, but without slop. A quick, dry fit "slop" test: Hold a short length of pipe vertically with a fitting "bottomed" on the pipe. If the fitting falls off the end of the pipe, do not start assembly. Contact your pipe or fitting supplier. Measure the fitting socket length and mark this distance on the pipe OD to insure the fitting has been fully inserted, add a couple inches to this distance and make a second check mark on the pipe, as the primer and cement will remove the first mark. All pipe and fittings must conform to ASTM or other recognized product standards.



7. Use the right applicator for the size of pipe or fittings being joined. The applicator size should be approximately $\frac{1}{2}$ the pipe diameter. It is important that a satisfactory size applicator be used to help ensure that sufficient layers of cement are applied.



8. Priming; the purpose of a primer is to penetrate and soften the surfaces so they can fuse together. The proper use of a primer and checking its softening capability provides assurance that the surfaces are prepared for fusion in a wide variety of conditions. Check the penetration or softening on a piece of scrap pipe before you start the installation or if the weather changes during the day.



Using a knife or other sharp object, drag the edge over the coated surface. Proper penetration has been made if you can scratch or scrape a few thousandths of the primed surface away. Because weather conditions do affect priming and cementing action, repeated applications to both surfaces may be necessary. In cold weather more time is required for proper penetration.

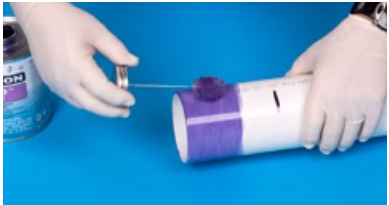
Note: Without hesitation, complete steps 9 through 16.

For pipe diameters of 6" and larger, the size of the joining crew should be increased (see page 13).

9. Using the correct applicator (as outlined in step #7), aggressively apply the primer into fitting socket, keeping the surface and applicator wet until the surface has been softened. More applications may be needed for hard surfaces and cold weather conditions. Re-dip the applicator in primer as required. When the surface is primed, remove any puddles of primer from the socket.



10. Next, aggressively apply the primer to the end of the pipe to a point 1/2" beyond the depth of the fitting socket.



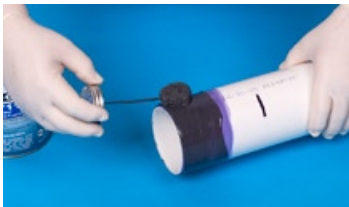
11. Apply a second application of primer to the fitting socket. Do not allow primer to run down the inside of the fitting or pipe.



12. With the proper size and type of applicator, while surfaces are still wet, immediately apply the appropriate Weld-On cement.

Please Note: The adding of primers, cleaners or other thinners to thin the viscosity of solvent cement is not recommended.

13. Cementing: (Stir or shake the cement before using.) Aggressively apply a full, even layer of cement to the pipe-end equal to the depth of the fitting socket – do not brush it out to a thin paint type layer, as this will dry too quickly.



14. Aggressively apply a medium layer of cement into the fitting socket; avoid puddling cement in the socket. On bell-end pipe do not coat beyond the socket depth or allow cement to run down into the pipe beyond the bell.



15. Apply a second, full even layer of cement on the pipe. Most joint failures are caused by insufficient application of cement.



16. Immediately, while cement is still wet, assemble the pipe and fittings. If not completely wet, recoat parts before assembly. If cement coatings have hardened, cut pipe, dispose of fitting and start over. Do not assemble partially cured surfaces. While inserting, twist $1/8$ to $1/4$ turn until reaching pipe stop. Do not continue to rotate after the pipe has reached the socket bottom.



17. Hold the pipe and fitting together for a minimum of 30 seconds to eliminate movement or pushout.



18. After assembly, a joint should have a ring or bead of cement completely around the juncture of the pipe and fitting. If voids (gaps) in this ring are present, sufficient cement was not applied and the joint may be defective.



19. Using a rag, remove the excess cement from the pipe and fitting, including the ring or bead around the socket entrance, as it will needlessly soften the pipe and fitting, and does not add to joint strength. Excess cement around the socket entrance will also extend the cure time. Avoid disturbing or moving the joint.



20. Handle newly assembled joints carefully until initial set has taken place. Follow IPS Weld-On set and cure times before handling or hydro-testing piping system (for set and cure times refer to page 22).

SOLVENT CEMENTING WITHOUT PRIMER

If local codes permit, successful joints can be made without a primer using cement alone, but extra care must be given to the installation. It is important that a good interference fit exists between the pipe and fittings. It is for this reason we recommend that joints being made without a primer be limited to systems 2" and smaller for pressure applications (water systems only) or 6" and smaller for DWV or non-pressure applications. (Check local code requirements.)

Extra care must also be given in applying the cements to make sure proper penetration and softening of the pipe and fitting surfaces is achieved.

BEFORE CEMENTING

1. Review all directions on the cement container label or the standard practice for making solvent cemented joints (ASTM D-2855).
2. Assemble proper materials for the job (proper cement, if necessary - cleaner, and applicator for the size of pipe and fittings to be assembled).
3. Pipe must be cut as square as possible . Use a miter box saw or power saw. Check the end of the pipe with a square to make sure it has been cut squarely. A diagonal cut reduces bonding area in the most effective and critical part of the joint.
4. Plastic tubing cutters may also be used for cutting plastic pipe; however, some produce a raised bead at the end of the pipe. This bead must be removed with a file or deburring tool, as it will scrape the cement away when pipe is inserted into the fitting.
5. Remove inside diameter burrs or raised beads with an internal deburring tool or knife. Remove the burrs or raised beads on the outside diameter of the pipe by using a file or external deburring tool that will produce a $3/32"$, 10-15° chamfer (bevel). Burrs can scrape channels into pre-softened surfaces or create hang-ups across the inside fitting diameter.
6. With a clean-dry rag, remove any dirt, grease, shavings or moisture from the inside and outside the pipe and fitting. A thorough wipe is usually sufficient. (Moisture will retard cure and dirt, grease, or any foreign material can prevent proper fusion).
7. Check pipe and fittings for dry fit before cementing. For proper interference fit, fitting should go over end of pipe easily but become tight about $1/3$ to $2/3$ of the way on. Too tight a fit is not desirable;

you must be able to fully bottom the pipe in the socket during assembly. If the pipe and fittings are not out of round, a satisfactory joint can be made if there is a "net" fit, that is, the pipe bottoms in the fitting socket with no interference, but without slop. A quick, dry fit "slop" test: Hold a short length of pipe vertically with a fitting "bottomed" on the pipe. If the fitting falls off the end of the pipe, do not start assembly. Contact your pipe or fitting supplier. (A good interference fit is desired for a one-step application.) Measure the fitting socket length and mark this distance on the pipe O.D. to insure the fitting had been fully inserted, add a couple inches to this distance and make a second check mark on the pipe, as the primer and cement will remove the first mark. All pipe and fittings must conform to ASTM or other recognized product standards.

8. Check for penetration and softening of the pipe's surface. Take a scrap piece of the pipe you will be using and make a normal application of the cement. Then immediately, using a knife or other sharp object, try to scratch or scrape a few thousandths of the surface away. If you are able to do so, proceed with installation. If not, try making a more aggressive application of the cement on the scrap piece of pipe and check for penetrations noted above. If you still are unable to achieve penetration or softening of the pipe's surface, you may want to consider the use of a primer.

9. Use the right applicator for the size of pipe or fittings being joined. The applicator size should be approximately $\frac{1}{2}$ the pipe diameter. It is important that a satisfactory size applicator be used to help ensure that sufficient layers of cement are applied.

Please Note: The adding of primers, cleaners or other thinners to thin the viscosity of solvent cement is not recommended.

Without hesitation, complete steps 10 through 16.

For pipe diameters of 6" and larger, the size of the joining crew should be increased (see page 13).

10. Cementing: (Stir or shake the cement before using.) Aggressively apply a full, even layer of cement to the pipe-end equal to the depth of the fitting socket - do not brush it out to a thin paint type layer, as this will dry too quickly.

11. Aggressively apply a medium layer of cement into the fitting socket; avoid puddling cement in the socket. On bell-end pipe do not coat beyond the socket depth or allow cement to run down into the pipe beyond the bell.

12. Apply a second full, even layer of cement on the pipe. Most joint failures are caused by insufficient application of cement.

13. Immediately, while cement is still wet, assemble the pipe and fittings. If not completely wet, recoat parts before assembly. If cement coatings have hardened, cut pipe, dispose of fitting and start over. Do not assemble partially cured surfaces. While inserting, twist $1/8$ to $1/4$ turn until reaching pipe stop. Do not continue to rotate after the pipe has reached the socket bottom.

14. Hold the pipe and fitting together for a minimum of 30 seconds to eliminate movement or pushout.

15. After assembly, a joint should have a ring or bead of cement completely around the juncture of the pipe and fitting. If voids (gaps) in this ring are present, sufficient cement was not applied and the joint may be defective.

16. Using a rag, remove the excess cement from the pipe and fitting, including the ring or bead around the socket entrance, as it will needlessly soften the pipe and fitting, and does not add to joint strength. Excess cement around the socket entrance will also extend the cure time. Avoid disturbing or moving the joint.

17. Handle newly assembled joints carefully until initial set has taken place. Follow IPS Weld-On set and cure times before handling or hydro-testing piping system (for set and cure times, refer to page 22).

JOINING LARGE DIAMETER PIPE AND FITTINGS (6" Diameter and Larger)

As pipe diameter increases, so does the difficulty in installing it. The professional installer should be able to successfully assemble large diameter pipe and fittings by following the IPS Weld-On Solvent Cementing with Primer instructions listed in the beginning of this guide along with the following additional recommendations.

1. Use of proper size applicators is even more necessary to insure enough cement is applied to fill the larger gap that exists between the pipe and fittings.

2. Of equal importance is the use of the applicable cement for the size of pipe and fittings being installed. We recommend the following:

up to 12" PVC Sch 40 or Sch 80 - Weld-On #717, #711,
#2711, #2717

up to 30" PVC Sch 40 or Sch 80 - Weld-On #719, #2719

up to 12" CPVC - Weld-On #714, #2714, #724

up to 24" CPVC Duct - Weld-On #729

3. End of pipe must be cut square and chamfered (beveled). (See photo at right.)

4. Increase size of joining crew:
6" - 8": 2-3 people per joint
10" - 30": 3-4 people per joint

It is important in large diameter joining that the primer and cement be applied simultaneously to the pipe and fittings.

5. Make sure to apply a second, full layer of cement to the pipe.

6. Because of the short sockets in many large diameter fittings, **IT IS VERY IMPORTANT TO HAVE PIPE BOTTOMED INTO THE FITTING.** Large diameter pipe is heavy and can develop significant resistance during insertion, before reaching socket bottom. It is for this reason that we recommend above 4" diameter the use of a pipe-puller such as the one pictured. (Available at IPS Weld-On).

7. Large diameter pipe and fittings require longer set and cure times.
*(In cold weather, a heat blanket may be used to speed up the set and cure times.)

8. Prefabricate as many joints as possible.

9. If pipe is to be buried, make as many joints as possible above ground, then after joints have cured, carefully lower into trench.

10. Never bury empty cans, brushes, or anything else containing wet cement, primer, or cleaner next to the pipe.

* Contact the IPS Technical Service Department for further information: **800-421-2677**.



CHEMICAL APPLICATIONS

Installations of plastic pipe and fittings for chemical applications requires a higher degree of skill than other installations; joint failures in these systems could be life threatening. It is for this reason we recommend the following tips for these applications.

Tips for Installation:

1. Installers should attend an IPS Weld-On Installation Seminar.
2. Allow at least two to three times the normal set and cure times on page 22.
3. Flush system before putting into operation.
4. Installers should use extra care during assembly to insure proper installation of system.
5. Make sure the proper cement for the specific application is used.
6. If there is any doubt about compatibility of materials (pipe, fittings or cement) with chemicals in system, manufacturers of materials should be contacted.

REPAIRS

For over forty years, we have been manufacturing solvent cements and have had the opportunity to evaluate numerous joint failures, visit many job sites and witness numerous attempts at repairing leaking joints (most do not work).

Taking into consideration the cost of materials, time involved and labor costs, in most cases the installer is better off cutting out the defective joint, replacing it with new materials and taking greater care in the joining process.

If the joint cannot be cut out, the following repair has been found to be somewhat successful.

This repair is for leaks only, not cases where pipe has separated from fitting:

1. Clean area around leak - area must be free from soil, grease or chemical residue.
2. Shut-off source of leak - area must be dry.
3. Use Weld-On #810 or #811 and fiberglass cloth. Mix #810 or #811.
4. Apply #810 or #811 to area of leak; cover area with fiberglass cloth. Then cover complete area with second application of #810 or #811. This is not a guaranteed fix, but one that has proven to be very successful in most applications.

JOINING PLASTIC PIPE IN HOT WEATHER

There are many occasions when solvent cementing plastic pipe at 95°F (38°C) temperatures and above cannot be avoided. If special precautions are taken, problems can be avoided.

Solvent cements for plastic pipe contain high strength solvents which evaporate faster at elevated temperatures. This is especially true when there is a hot wind blowing. If the pipe is stored in direct sunlight, the pipe surface temperatures may be from 20°F to 30°F (10°C to 15°C) higher than the ambient temperature. Solvents attack these hot surfaces faster and deeper, especially inside a joint. Therefore, it is very important to avoid puddling the cement inside the fitting socket and to wipe off any excess cement outside the joint.

By following our standard instructions and using a little extra care, as outlined below, successful solvent cemented joints can be made in even the most extreme hot weather conditions.

Tips to Follow when Solvent Cementing in High Temperatures:

1. Store solvent cements and primers in a cool or shaded area prior to use.
2. If possible, store fittings and pipe or at least the ends to be solvent welded, in a shady area before cementing.
3. Cool the surfaces to be joined by wiping with a damp rag. Make sure that surface is dry prior to applying solvent cement.
4. Try to do the solvent cementing during the cooler morning hours.
5. Make sure that both surfaces to be joined are still wet with cement when putting them together. With large diameter pipe, more people on the crew may be necessary.
6. Using a primer and a heavier, high viscosity cement will provide a little more working time. Vigorously shake or stir the cement before using.

As you know, during hot weather there can be a greater expansion-contraction factor. We suggest you follow the advice of the pipe manufacturer regarding this condition. Anchored, and final connections should be made during the cooler hours of the day.

By using Weld-On products as recommended and by following these hot weather tips, making strong, leakproof joints even during very hot weather conditions can be achieved.

JOINING PLASTIC PIPE AND FITTINGS IN COLD WEATHER

Working in freezing temperatures is never easy. But sometimes the job is necessary. If that unavoidable job includes solvent cementing plastic pipe, you can do it successfully with IPS Weld-On Solvent Cements.

By following our standard instructions and using a little extra care as outlined below, successful solvent cemented joints can be made at temperatures even as low as -15°F (-26°C). In cold weather, solvents penetrate and soften the plastic pipe and fitting surfaces more slowly than in warm weather. Also the plastic is more resistant to solvent attack. Therefore it becomes even more important to pre-soften surfaces with an aggressive primer. And, because of slower evaporation, a longer cure time is necessary. Our cure schedules allow a margin for safety, but for colder weather more time should be allowed.

Tips to Follow in Solvent Cementing during Cold Weather:

1. Prefabricate as much of the system as is possible in a heated work area.
2. Store cements and primers in a warmer area when not in use and make sure they remain fluid. If possible, store the fittings & valves the same way.
3. Take special care to remove moisture including ice and snow from the surfaces to be joined, especially from around the ends of the pipe.
4. Use the most aggressive Weld-On Primer available to soften the joining surfaces before applying cement. More than one application may be necessary.
5. Vigorously shake or stir cement before using. Allow a longer cure period before the system is tested and used.
*A heat blanket may be used to speed up the set and cure times.
6. Read and follow all of our directions carefully before installation.

All Weld-On cements are formulated to have well balanced drying characteristics and to have good stability in subfreezing temperatures.

For all practical purposes, good solvent cemented joints can be made in very cold conditions with proper care and a little common sense.

*Contact the IPS Technical Service Department for additional information: **800-421-2677**.

HELPFUL HINTS

We are all aware that a properly cemented joint is a most critical part of the installation of plastic pipe and fittings. And no matter how many times we join pipe and fittings, it's very easy to overlook something. So, we just want to remind you of a few things you may already know.

1. Have you reviewed all of the instructions on the cement container label or in ASTM D-2855?
2. Are you using the proper cement for the job... for the type and size of pipe and correct fittings being joined?
3. Do you need to take special precautions because of unusual weather conditions?
4. Do you have sufficient manpower? Do you need more help to maintain proper alignment and to bottom pipe in fitting?
5. Do you have the proper tools, applicators and sufficient quantities of Weld-On cements and primer and is cement in good condition?

Please Note: The adding of primers, cleaners or other thinners to thin the viscosity of solvent cement is not recommended.

6. Remember, primer is NOT to be used on ABS pipe or fittings.
7. Be sure to use a large enough applicator to quickly spread cement generously on pipe and fittings. Then assemble immediately.
8. Avoid puddling excess primer and cement inside the fitting socket, especially on thin wall, bell-end PVC pipe and ABS in any schedule.
9. Do NOT allow primer or cement to run through a valve-socket into the valve body. The solvents can cause damage to interior valve components and cause valve malfunction.
10. Be aware at all times of good safety practices. Solvent cements for pipe and fittings are flammable, so there should be no smoking or other sources of heat, spark or flame in working or storage areas. Be sure to work only in a well ventilated space and avoid unnecessary skin contact with all solvents. More detailed safety information is available from us.
11. Take advantage of our free literature on joining techniques. We offer DVDs/CDs on joining PVC & CPVC pipe and fittings, a cartoon booklet illustrating joining and installation methods and individual bulletins. We also offer joining seminars and job site training. Call the IPS Technical Service Department for more details.
12. Finally, we remind you to INSIST ON WELD-ON!



CAUTION

For over 40 years, millions of solvent cemented joints have been made with only rare cases of mishap. However, since flammable and toxic solvents are part of these products, appropriate safety precautions should be used.

All solvent cements and primers for plastic pipe are flammable and should not be used or stored near heat, spark, open flame and other sources of ignition. Vapors may ignite explosively. Solvent cement vapors are heavier than air and may travel to source(s) of ignition at or near ground or lower level(s) and flash back. Keep container closed when not in use and covered as much as possible when in use. Avoid breathing of vapors. Use only in well-ventilated area. If confined or partially enclosed, use forced ventilation. When necessary, use local exhaust ventilation to remove harmful airborne contaminants from employee breathing zone and to keep contaminants below 25 ppm TWA. Atmospheric levels must be maintained below established exposure limits contained in Section II of the Material Safety Data Sheet (MSDS). If airborne concentrations exceed those limits, use of a NIOSH approved organic vapor cartridge respirator with full face-piece is recommended. The effectiveness of an air-purifying respirator is limited. Use it only for a single short-term exposure. For emergency and other conditions where short-term exposure guidelines may be exceeded, use an approved positive pressure self-contained breathing apparatus.

Do not smoke, eat or drink while working with this product. Avoid contact with skin, eyes and clothing. Wash clothing if contaminated and before reuse. May cause eye injury. Protective equipment such as gloves, goggles and impervious apron should be used. Keep out of reach of children. Do not take internally. Carefully read Material Safety Data Sheet and follow all precautions. Do not use this product for other than intended use.

FIRST AID

Inhalation: If ill effects occur from inhalation, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call a physician.

Eye Contact: Flush abundantly with flowing water for 15 minutes and call a physician.

Skin Contact: Wash skin with plenty of soap and water for at least 15 minutes. If irritation develops, get medical attention.

Ingestion: If swallowed, give 1 to 2 glasses of water or milk, **DO NOT INDUCE VOMITING.** Contact physician immediately.

SPECIAL PRECAUTIONS

IPS WELD-ON SOLVENT CEMENTS MUST NEVER BE USED IN A PVC OR CPVC SYSTEM USING OR BEING TESTED BY COMPRESSED AIR OR GASES! NOTE: 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.

Do not use any type of dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of granules or pellets of calcium hypochlorite with PVC and CPVC solvent cements and primers (including their vapors) may result in a violent chemical reaction if a water solution is not used. It is advisable to purify lines by pumping chlorinated water into the piping system-this solution will be nonvolatile. Furthermore, dry granular calcium should not be stored or used near solvent cements and primers. All systems should be flushed before start-up to remove excess fumes from piping system.

New or repaired potable water systems shall be purged of deleterious matter and disinfected prior to utilization. The method to be followed shall be that prescribed by the health authority having jurisdiction or, in the absence of a prescribed method, the procedure described in either AWWA C651 or AWWA C652.

USE CAUTION WITH WELDING TORCHES

At construction sites where plastic pipe is being installed or has recently been solvent welded, extreme caution should be taken when using welding torches or other equipment where sparks may be involved. Flammable vapors from cemented joints sometimes linger within or around a piping system for some time.

Special care must be taken when using a welding torch in these installations:

- A. Well casing, elevator shafts and other confined areas.
- B. Installing pumps in irrigation water lines.
- C. Plastic pipe systems in industrial plant areas with little or no air circulation.

In all cases, solvent vapors must be removed by air circulation, purging, or other means prior to the use of welding torches, or other spark or flame generating equipment or procedures.

STORAGE AND HANDLING

Store in the shade between 40°F and 110°F (5°C and 44°C) or as specified on label. Keep away from heat, spark, open flame and other sources of ignition. Keep container closed when not in use. If the unopened container is subjected to freezing, it may become extremely thick or jelled. This cement can be placed in a warm area, where after a period of time, it will return to its original, usable condition. But such is not the case when jelling has taken place because of actual solvent loss – for example, when the container was left open too long during use or not properly sealed after use. Cement in this condition should not be used and should be properly discarded.

IPS Weld-On solvent cements are formulated to be used “as received” in original containers. Adding thinners or primers to change viscosity is not recommended. If the cement is found to be jelly-like and not free flowing, it should not be used. Containers of cement should be shaken or stirred before using. Do not shake primers.

LISTING ORGANIZATIONS

IPS Weld-On products are manufactured and inspected to the national standards listed below.

IAPMO, CSA, NSF, ASTM Standards

F-656	Primers
D-2235	ABS Solvent Cements
D-2846	CPVC Solvent Cements
F-493	CPVC Solvent Cements
D-2564	PVC Solvent Cements
D-3138	Transition Cements

Other IPS Weld-On Installation Information Includes:

DVDs/CDs - Available in English or Spanish

Cartoon Books - Available in English or Spanish

Basic Principles Bulletin

General Safety Bulletin

Helpful Hints Bulletin

Cold Weather Installation Bulletin

Hot Weather Installation Bulletin

Job Site Training

WARNING - IPS Weld-On products must never be used in a PVC or CPVC system using or being tested by compressed air or gases.

Nominal Pipe Size	in. mm.	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
		15	20	25	32	40	50	65	80	100	150	200	250	300	350	600	750
Primers	P75																
	P70																
	P68																
Multi-Purpose	796**																
	794**																
	2794**																
	793**																
	790*																
	2790*																
ABS	773																
	2773																
	771																
	2771																
CPVC	All Weather Flow+ Guard Gold																
	Flow+ Guard Gold																
	729																
	724 ^o																
	714																
	2714																
	713																
Specialty Cements	795																
	2795																
	747†																
	2747†																
	737†																
	2737†																
	735†																
2735†																	
PVC	727†																
	725†																
	2725†																
	719																
Extra Heavy Body	2719																
	717 [§]																
Heavy Body	2717 [§]																
	711																
Medium Body	2711																
	721†																
	2721†																
	705†																
	2705†																
	704†																
	2704†																
	710																
Regular Body	702																
	700																
	2700																

* PVC, CPVC, ABS and Styrene
 **ABS to PVC
 ***Copper Tube Size

◊ For CPVC and PVC Chemical Piping Systems

^a FlowGuard Gold[®] is a registered trademark of Noveon, Inc.

† Can be used without a primer with fittings having an interference fit (unless required by local code).

§ non-pressure only up to 18"

Schedule 40

Schedule 80

Nominal Pipe Size	in. mm.	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	24	30
		15	20	25	32	40	50	65	80	100	150	200	250	300	350	600	750

Average Initial Set Schedule For WELD-ON PVC / CPVC Solvent Cements**

Temperature Range	Pipe Sizes 1/2" to 1 1/4"	Pipe Sizes 1 1/2" to 2"	Pipe Sizes 2 1/2" to 8"	Pipe Sizes 10" to 15"	Pipe Sizes 15"+
60°-100°F	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F	10 minutes	15 minutes	12 hours	24 hours	48 hours

Note - Initial set schedule is the necessary time to allow before the joint can be carefully handled. In damp or humid weather allow 50% more set time.

Average Joint Cure Schedule For WELD-ON PVC / CPVC Solvent Cements**

Relative Humidity 60% or Less	Cure Time Pipe Sizes 1/2" to 1 1/4"		Cure Time Pipe Sizes 1 1/2" to 2"		Cure Time Pipe Sizes 2 1/2" to 8"		Cure Time Pipe Sizes 10" to 15"	Cure Time Pipe Sizes 15"+
Temperature range during assembly and cure periods	up to 160 psi	above 160 psi to 370 psi	up to 160 psi	above 160 psi to 315 psi	up to 160 psi	above 160 psi to 315 psi	up to 100 psi	up to 100 psi
60°-100°F	15 min	6 hrs	30 min	12 hrs	1 1/2 hrs	24 hrs	48 hrs	72 hrs
40°-60°F	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

Note - Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.

**These figures are estimates based on our laboratory tests; extended set and cure times are required for chemical applications. Due to the many variables in the field, these figures should be used as a general guide only.

Average Number of Joints/Qt. of WELD-ON Cement*

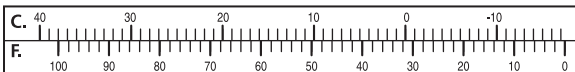
Pipe Diameter	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

*For Primer: Double the number of joints shown for cement.

These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only.

Note: 1 Joint = 1 Socket

Fahrenheit to Celsius Conversion Chart



IPS®

WELD·ON

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