



Solvent Cements

**LOOK
INSIDE**

for the industry's
most detailed
cure charts



The choice of plumbing professionals.



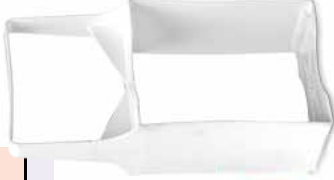
Product Selection Guide

Body	Product Name	Color	Max Nominal Pipe Size		One Step Cement	Recommended Applications						Oatey Product Number					
			Schedule 40	Schedule 80		Potable Water	Drain, Waste & Vent	Sewer	Hot Water (180°F)	Industrial	Max Service Temp	Recommended Application Temperature	4oz	8oz	16oz	32oz	1 gal.
PVC	Regular Advanced	Clear	4"	2"		✓	✓	✓	✓				31925	31926	31927	31928	31929
	Regular Clear	Clear	4"	2"		✓	✓	✓	✓				31012	31013	31014	31015	31016
	Regular Clear Industrial	Clear	4"	2"		✓	✓	✓	✓		✓		-	-	31024	31025	-
	Medium Clear	Clear	6"	6"		✓	✓	✓	✓		✓		31017	31018	31019	31020	31021
	Medium Gray	Gray	6"	6"		✓	✓	✓	✓		✓		30883	30884	30885	30886	30887
	Hot Weather Plus™	Clear	6"	6"		✓	✓	✓	✓		✓		-	31936	31937	31938	-
	All-Weather	Clear	6"	6"		✓	✓	✓	✓		✓		-	-	31132	31133	31135
	Flexible	Green	6"	6"									30875	-	-	30879	-
	Heavy Duty Clear	Clear	12" 18" (non-pressure)	12"		✓	✓	✓	✓		✓		30850	30863	30876	31008	31011
	Heavy Duty Gray	Gray	12" 18" (non-pressure)	12"		✓	✓	✓	✓		✓		31093	31094	31095	31105	31118
Extra HD	Extra HD Gray	Gray	30"	30"		✓	✓	✓	✓		✓	-	-	-	30343	30344	30344
Hot Cements	Rain-R-Shine®	Blue	6"	6"	✓	✓	✓	✓	✓			30890	30891	30893	30894	30895	30895
	Blue Lava	Blue	6"	6"	✓	✓	✓	✓	✓			32160	32161	32162	32163	32164	32164
	Heavy Duty Fast Set	Gray	18"	18"	✓	✓	✓	✓	✓		✓	-	-	31121	31122	31123	31123
	FlowGuard Gold®	Gold	2" CTS	-	✓	✓	✓	✓	✓	✓		31910	31911	31912	31913	31913	31914
Medium	FlowGuard Gold UVI	Gold	2" CTS	-	✓	✓	✓	✓	✓			-	31917	31918	31919	31919	-
	Medium Orange	Orange	6"	6"		✓	✓	✓	✓			31128	31129	31130	31131	31131	31127
Heavy Duty	Heavy Duty Gray	Gray	12"	12"		✓	✓	✓	✓		✓	-	-	31036	31037	-	-
	Heavy Duty Orange	Orange	12"	12"		✓	✓	✓	✓		✓	-	-	31082	31083	31084	31084
	Heavy Duty Industrial	Gray	12"	12"		✓	✓	✓	✓		✓	-	-	30328	30329	30330	30330
	Heavy Duty Industrial	Orange	12"	12"		✓	✓	✓	✓		✓	-	-	30331	30332	-	-
Hot Cement	Orange Lava	Orange	4"	4"	✓	✓	✓	✓	✓		✓	-	32166	32167	32168	-	-
ABS	Medium	Black	8"	-			✓	✓	✓			30999	30889	30892	30902	30915	30915
	Extra Special	Black	8"	-			✓	✓	✓			30916	30917	30918	30919	30920	30920
	Milky Clear	Milky Clear	8"	-			✓	✓	✓			-	-	30922	30923	30924	30924
Medium	All-Purpose	Milky Clear	6"	6"			✓	✓	✓	✓		30818	30821	30834	30847	30848	30848
Medium	Transition (ABS to PVC)	Green	6"	-			✓	✓	✓			30900	-	30925	30926	-	-
Speciality	NSF Primer	Purple	all	all		✓	✓	✓	✓			30755	30756	30757	30758	30759	30759
		Clear	all	all		✓	✓	✓	✓			30750	30751	30752	30753	30754	30754
	Industrial Primer	Purple	all	all		✓	✓	✓	✓			-	-	30770	30771	30772	30772
		Clear	all	all		✓	✓	✓	✓			-	-	30773	30774	30775	30775
Cleaner	Cleaner	Clear	all	all		✓	✓	✓	✓			30779	30782	30795	30805	30786	30786
Primer Cleaner	Primer Cleaner	Purple	all	all		✓	✓	✓	✓			30780	30783	30796	30806	30768	30768

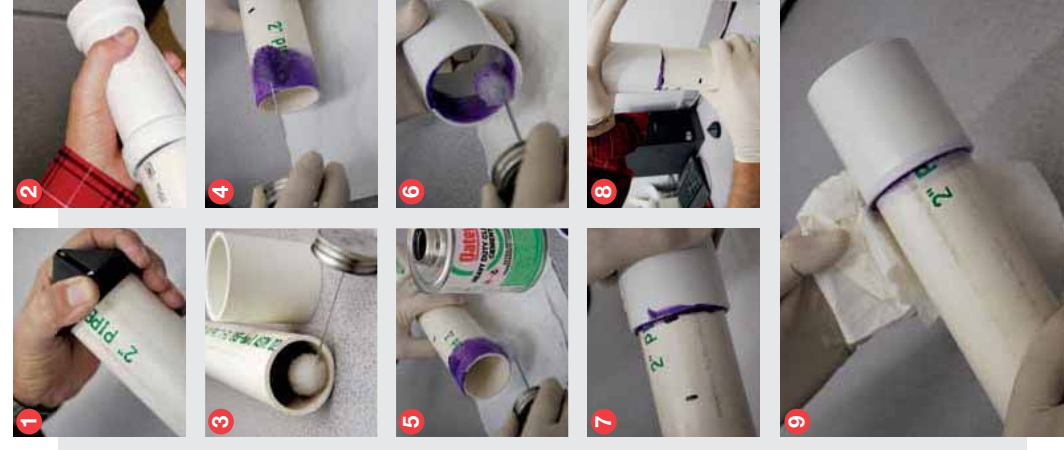
FlowGuard Gold® is a registered trademark of the Lubrizol Corporation.

Solvent Cement Accessories

Category	Description / Size	Product Number	Carton Qty
Applicators	4oz Can	31299	48
	8oz Can	31309	48
	16oz Can	31310	48
	32oz Can	31312	48
	16/32oz Can	30359	50
	16/32oz can-CPVC	31313	48
	32oz Can	30357	48
	32oz Can	30358	50
	Adjustable	31300	100
	Adjustable	31301	100
	32oz Can	30354	24
	Wide Mouth Gallon	30356	24
	Gallon - wide & std mouth	31276	12
	32oz Wide Mouth Can	30351	24
	32oz Can	30352	24
	Wide Mouth Gallon	30353	20
Rollers	Gallon - wide & std mouth	31275	12
	Natural bristle brush	50200	36
Brushes	16/32oz Can	31257	48
	1-1/2" brush	31304	24
Empty Cans	4oz Empty Can	31305	24
	8oz Empty Can	31306	24
	16oz Empty Can	31307	12
	32oz Empty Can	30901	6
	Gallon - 2-7/8" mouth	30367	12
	32oz including cap	30376	6
	Gallon including cap	30363	6
	Hand Deburring Tool	30365	1
Bevellers	Large diameter pipe puller	31250	12
Pipe Puller	Dual 32oz Can Carrier		
Can Carrier			



How To Solvent Weld



- Prior To Use:**
Read all product labels carefully.
 Stir or shake cement before using. If jelly-like, do not use. Keep container closed when not in use. Avoid eye and skin contact. Wear safety glasses with side shields and wear rubber gloves.
1. Cut pipe ends square, chamfer and clean pipe ends.
 2. Check dry fit of pipe and fitting. Pipe should easily go 1/3 of the way into the fitting. If pipe bottoms, it should be snug.
 3. Use a suitable applicator at least 1/2 the size of the pipe diameter. For larger size pipe systems use a natural bristle brush or roller.
 4. Clean pipe and fitting with a listed primer. (Do not use primer on ABS pipe and fittings. Use Clear Cleaner only)
 5. Apply liberal coat of cement to pipe to the depth of the socket, leave no uncoated surface.
 6. Apply a thin coat of cement to inside of fitting, avoid puddling of cement. Puddling can cause weakening and premature failure of pipe or fitting. Apply a second coat of cement to the pipe.
 7. Assemble parts QUICKLY. Cement must be fluid. If cement surface has dried, recoat both parts.
 8. Push pipe FULLY into fitting using a 1/4 turning motion until pipe bottoms.
 9. Hold pipe and fitting together for 30 seconds to prevent pipe push-out - longer at low temperatures. Wipe off excess.
 10. Allow 15 minutes for good handling strength and 2 hours cure time at temperatures above 60°F before pressure testing up to 180 psi. Longer cure times may be required at temperatures below 60°F or with pipe above 3". DO NOT TEST WITH AIR.
- For specialty cements and chemical applications please see specific product label instructions.

Average Handling/Set Up Times for PVC/CPVC Solvent Cements

Handling/Set Up Time is the time required prior to handling the joint. In damp or humid weather, allow 50% additional time.

Temperature during assembly	Pipe Diameter 1/2" to 1-1/4"	Pipe Diameter 1-1/2" to 3"	Pipe Diameter 4" to 5"	Pipe Diameter 6" to 8"	Pipe Diameter 10" to 16"	Pipe Diameter 18" +
60° - 100°F	2 minutes	5 minutes	15 minutes	30 minutes	2 hours	4 hours
40° - 60°F	5 minutes	10 minutes	30 minutes	90 minutes	8 hours	16 hours
20° - 40°F	8 minutes	12 minutes	60 minutes	3 hours	12 hours	24 hours
0° - 20°F	10 minutes	15 minutes	2 hours	6 hours	24 hours	48 hours

These figures should only be used as a general guide. Conditions in the field may vary.



Average Joint Cure Times for Oatey Solvent Cements

PVC & ABS

Pipe Diameter		Temperature during assembly and cure period			
		60°-100°F 16°-38°C	40°-60°F 4°-16°C	20°-40°F -7°-4°C	0°-20°F -18°-7°C
1/2" to 1-1/4" 13 to 32mm	Up to 180 psi	15 min	20 min	30 min	60 min
	180 psi +	4 hrs	8 hrs	36 hrs	48 hrs
1-1/2" to 3" 40 to 80mm	Up to 180 psi	30 min	45 min	60 min	120 min
	180 psi +	8 hrs	16 hrs	72 hrs	96 hrs
4" to 5" 100 to 125mm	Up to 180 psi	2 hrs	4 hrs	36 hrs	48 hrs
	180 psi +	12 hrs	24 hrs	4 days	8 days
6" to 8" 150 to 200mm	Up to 180 psi	8 hrs	16 hrs	3 days	4 days
	180 psi +	24 hrs	48 hrs	9 days	12 days
10" to 16" 250 to 400mm	Up to 100 psi	24 hrs	48 hrs	8 days	10 days
	180 psi +	24 hrs	48 hrs	8 days	10 days
18" or more 460mm or more	Up to 100 psi	36 hrs	72 hrs	12 days	14 days
	180 psi +	36 hrs	72 hrs	12 days	14 days

CPVC

Pipe Diameter		Temperature during assembly and cure period			
		60°-100°F 16°-38°C	40°-60°F 4°-16°C	20°-40°F -7°-4°C	0°-20°F -18°-7°C
1/2" to 1-1/4" 13 to 32mm	Up to 180 psi	1 hr	2 hrs		
	180 psi +	6 hrs	12 hrs		
1-1/2" to 3" 40 to 80mm	Up to 180 psi	2 hrs	4 hrs		
	180 psi +	12 hrs	24 hrs		
4" to 5" 100 to 125mm	Up to 180 psi	6 hrs	12 hrs		
	180 psi +	18 hrs	36 hrs		
6" to 8" 150 to 200mm	Up to 180 psi	8 hrs	16 hrs		
	180 psi +	24 hrs	48 hrs		
10" to 16" 250 to 400mm	Up to 100 psi	24 hrs	48 hrs		
	180 psi +	24 hrs	48 hrs		
18" or more 460mm or more	Up to 100 psi	36 hrs	72 hrs		
	180 psi +	36 hrs	72 hrs		

Please contact
Oatey Technical
Services for cure time
information

This data is applicable only for new piping installations and not recommended for repair or cut-ins on hot and cold water distribution systems. Please contact Oatey Technical Service for recommendations on Cure Times for such applications.

DO NOT test PVC and CPVC piping systems with compressed air or gas.

Notes: Cure schedule is the time required before pressure testing the system

- This chart can be used as a guideline to determine joint cure
- Cure times stated are for conditions with relative humidity of 60% or less
- + In damp or humid weather allow 50% additional cure time

Average Number of Joints Per Quart of Solvent Cement

Pipe Diameter	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	325	250	150	125	90	70	50	30	10	8	3	2	3/4	1/2

These figures are estimates based on laboratory testing. Conditions in the field may vary.



4700 W. 160th St. | Cleveland, OH 44135
800.321.9532 | Fax: 800.321.9535
www.oatey.com

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4675 W. 160th St. | Cleveland, OH 44135
800.321.9532 | Fax: 800.321.9535