

Average Handling/Set times for Arrow PVC / CPVC Solvent Cements**

Handling/Set Schedule*

Temperature	Pipe Size 1/2" to 1 1/4"	Pipe Size 1 1/2" to 3"	Pipe Size 4" to 8"	Pipe Size 10" to 16"	Pipe Size 16"+
60°- 100° F	4 minutes	10 minutes	40 minutes	2 hours	4 hours
40°- 60° F	10 minutes	15 minutes	3 hours	8 hours	16 hours
0°- 40° F	15 minutes	25 minutes	12 hours	24 hours	48 hours

* The handling/set schedule is the time required before handling joint. In case of damp/humid weather or loose fitting joints, allow 50% additional cure time.

Average Number of Joints per Quart of Arrow PVC/CPVC Solvent Cement **

Pipe Diameter	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"	8"	10"	12"
Total Joints	325	240	180	120	80	50	30	15	7	4	2

Average Joint Cure times for Arrow PVC / CPVC Solvent Cements**

Joint/Cure Schedule*

Relative Humidity 60% or less	Cure Time Pipe Size 1/4" to 1 1/4"		Cure Time Pipe Size 1 1/2" to 3"		Cure Time Pipe Size 4" to 8"		Cure Time Pipe Size 10" to 16"		Cure Time Pipe Size 16"+	
	Up to 180 PSI	180 PSI +	Up to 180 PSI	180 PSI +	Up to 180 PSI	180 PSI +	Up to 100 PSI	100 PSI +	Up to 100 PSI	100 PSI +
Temperature during assembly and cure periods	Up to 180 PSI	180 PSI +	Up to 180 PSI	180 PSI +	Up to 180 PSI	180 PSI +	Up to 100 PSI	100 PSI +	Up to 100 PSI	100 PSI +
60°- 100° F	1 hr	6 hrs	2 hrs	12 hrs	8 hrs	24 hrs	48 hrs	72 hrs	72 hrs	72 hrs
40°- 60° F	2 hrs	12 hrs	4 hrs	24 hrs	16 hrs	48 hrs	96 hrs	8 days	8 days	8 days
0°- 40° F	8 hrs	48 hrs	16 hrs	96 hrs	4 days	12 days	10 days	14 days	14 days	14 days

* The joint cure schedule shows the required time to allow before pressurizing a system. In case of damp/humid weather or loose fitting joints, allow 50% additional cure time.

** All Data is based on laboratory testing. Charts should be used as a general guide, as conditions in the field may vary.

PRODUCT APPLICATION INSTRUCTIONS

1. Cut pipe square and remove all burrs.
2. Wipe pipe end and fitting socket with a clean cloth to remove dirt and moisture.
3. Check the dry fit of the pipe and fitting; should be tight.
4. Use an applicator or brush that is a width of 1/2 the pipe diameter.
5. For best results, remove gloss from pipe and fitting with Arrow Cleaner, S-901, for non-pressure applications; Primer S-911, for pressure.
6. Apply a heavy coat of cement to outside end of the pipe, a light coat to the inside of the fitting and then another coat to the outside of the pipe.
7. Immediately insert pipe into fitting with slight twisting motion until it bottoms in the socket.
8. Hold joint together for at least 30 seconds.
9. Wipe all excess cement from joint.
10. Use care when handling freshly made joints. Joints may be pressure tested 24 hours after joining. Allow longer cure time for cold weather or high humidity.



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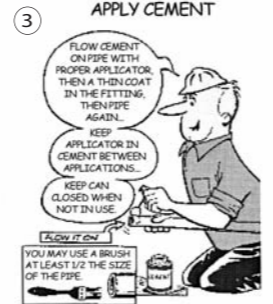
CUT PIPE AND REMOVE BURRS



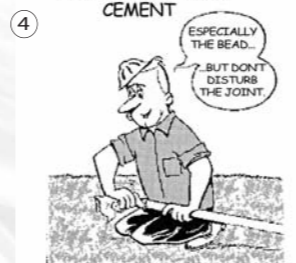
CLEAN PIPE WITH RAG



APPLY CEMENT



WIPE OFF EXCESS CEMENT



ALLOW THE JOINT TO CURE



PRESSURE TEST



Quality Solvent Cements
Since 1964

- PVC, CPVC, ABS Cements
- Primers & Cleaners
- Sealants & Lubricants



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Selecting the right Solvent Cement

Contractors have learned that solvent cement is a relatively minor part of total piping job cost but is absolutely critical to job performance. Cutting corners on the quality of solvent cements can be a costly error. All Arrow cements are formulated for maximum performance and cost effectiveness. Each meets a particular industry need and is produced under the highest standards of quality control throughout the entire manufacturing process. Use the chart below to determine which Arrow products are right for your application.

Thanks for choosing Arrow, you can count on Arrow products to perform!



PVC



CPVC



PRIMERS/ CLEANERS



SEALANT/ LUBRICANT



INDUSTRIAL POOL & TURF

FLOW-TITE PRIMER PRIMER-CLNR CLEANER

PRODUCTS	1104RB	1104MB	1104HB	1130	1132	1106	1106HB	1148	911	921	901	A-10	A-15
FOR USE ON	PVC	PVC	PVC	PVC	PVC	CPVC	CPVC	FLOWGUARD GOLD® CPVC	PVC CPVC	PVC CPVC	PVC CPVC, ABS	THREADED JOINTS	GASKETED JOINTS
COLOR	CLEAR	CLEAR, GRAY, WHITE	CLEAR, GRAY, WHITE	GRAY, WHITE	BLUE	ORANGE	ORANGE, GRAY	YELLOW	CLEAR, PURPLE	CLEAR, PURPLE	CLEAR	WHITE	AMBER
BODY	REGULAR	MEDIUM	HEAVY	EXTRA HEAVY	MEDIUM	REGULAR	HEAVY	MEDIUM	WATER THIN	WATER THIN	WATER THIN	HEAVY	HEAVY
SET TIME	FAST	FAST	MEDIUM	SLOW	VERY FAST	FAST	MEDIUM	FAST					
MAXIMUM PIPE DIAMETER	4"	6"	12"	30"	6"	4"	12"	2"	ALL	ALL	ALL		
ASTM SPEC.	D-2564	D-2564	D-2564	D-2564	D-2564	D-2846 F-493	D-2846 F-493	D-2846 F-493	F-656	F-656			
INDUSTRY LISTINGS	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code	NSF, U.P. Code			NSF	NSF
COMMENTS	Regular bodied, fast setting, high strength PVC cement.	Medium bodied, fast setting, high strength PVC cement.	Heavy bodied, medium setting, very high strength industrial grade PVC cement.	Extra heavy bodied, slow setting, very high strength industrial grade PVC cement. Excellent gap filling properties and good fabrication cement.	Medium bodied, very fast setting, high strength, PVC cement for welding rigid or flexible PVC in wet conditions where quick pressurization is desired.	Regular bodied, fast setting, CPVC cement for copper tube size pipe and fittings thru 4".	Heavy bodied, medium setting, very high strength industrial grade CPVC cement.	Medium bodied, fast setting, high strength CPVC cement for CTS pipe and fittings thru 2". For use with Flowguard Gold® systems. One Step cement (where permitted)	Aggressively softens and prepares the pipe and fittings for solvent cement.	Removes foreign material, cleans and prepares surface to be welded.	Removes dirt, oil, grease and other foreign substances from pipe and fitting surface.	A soft-set, non-hardening, smooth, pipe joint compound, for use on metal and plastic threaded connections. Pressure range for gases up to 3,000 PSI, liquids up to 10,000 PSI.	A water soluble lubricant for joining gasketed pipe with rubber, synthetic rubber or plastic seals.

* Flowguard Gold® registered trademark of the Lubrizol Corporation.