ARROW 50th ANNIVERSARY

Creating Strong Bonds for Over 50 Years!

PVC Solvent Cements

PVC Regular Body Solvent Cement

(1104RB - Golden Label)

- ✓ For all types of PVC schedule 40 through 4" and schedule 80 through 2" diameter.
- ✓ Fast setting.
- ✓ Clear color.
- ✓ Meets ASTM D-2564.
- ✓ Listed in NSF and UPC.

PVC Medium Body Cement

(1104MB - Gray Label)

- ✓ For all types of PVC schedule 40 through 6" and schedule 80 through 4" diameter.
- ✓ Fast setting.
- ✓ Clear color.
- ✓ Meets ASTM D-2564.
- ✓ Listed in NSF and UPC.

"Pool & Turf" - PVC Medium Body Cement

(1132 - Blue Label)

- ✓ For all types of PVC schedule 40 through 6" and schedule 80 through 4" diameter.
- ✓ Recommended for use in **wet conditions** and/or where quick pressurization is desired. Extremely fast setting.
- ✓ Blue color.
- ✓ Meets ASTM D-2564.
- ✓ Listed in NSF and UPC.

PVC Heavy Body Cement

(1104HB - Green Label)

- ✓ For all types of PVC through 12" diameter, including schedule 80.
- ✓ Medium setting.
- ✓ Clear or Gray color.
- ✓ Meets ASTM D-2564.
- ✓ Listed in NSF and UPC.

CPVC Solvent Cement

100% compatible with all brands of PVC and CPVC pipes

CPVC Heavy Body Cement

(1106HB - Orange Label)

- ✓ For all types of CPVC through 12" diameter.
- ✓ Medium setting.
- ✓ Orange color.
- ✓ Meets ASTM F-493 and D-2846.
- ✓ Listed in NSF and UPC.

LOW VOC

LOW VOLATILE ORGANIC COMPOUNDS

** Dauber included*

Committed to Your Health and the Environment

☎ 770.448.9058 www.arrowadhesives.com info@arrowadhesives.com

Cleaner

Cleaner for PVC, CPVC and ABS

(901 - Yellow Label)

- ✓ For use on all classes and schedules of PVC, CPVC and ABS plastic pipe and fittings.
- ✓ Cleans and removes oil and dirt from the joining surfaces.
- ✓ Clear color.

ARROW 50th ANNIVERSARY ® Quality and Service Since 1964

Handling and Cure Times

The handling and cure time depends on many factors like the pipe size, solvent cement used, ambient temperature and relative humidity during assembly and cure periods. All Data is based on laboratory testing. These charts should be used as a general guide, as conditions in the field may vary.

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

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	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

** 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.*

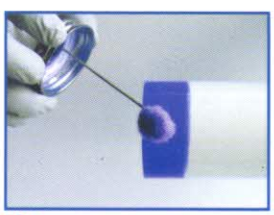
Average Joint Cure times for PVC/CPVC Solvent Cements*

Relative Humidity 60% or less	Cure Time Pipe Size 1/2" to 1 1/4"		Cure Time Pipe Size1 1/2" to 3"		Cure Time Pipe Size 4" to 8"		Cure Time Pipe Size 10" to 16"	Cure Time Pipe Size +16"
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	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 hr	96 hrs	3 days	8 days	8 days	14 days

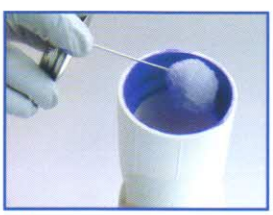
** The joint cure schedule shows the required time to allow before pressurizing a system. In case of damp/humid weather or loose fitting joints, allow 50% additional cure time.*

Solvent Weld Guide

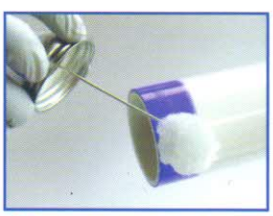
1 Cut pipe square and remove burs from edges.



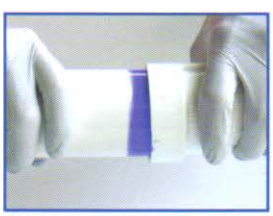
2 Apply Primer or Cleaner to pipe and fitting.



3 Apply cement to the inside of the fitting.



4 Apply cement to the outside of the pipe.



5 Assemble pipe and fittings with a twisting motion (1/4 turn) until pipe bottoms into socket.

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