

# Solvent Cements & Primers for PVC Connections

For priming and bonding PVC pipe and fittings.



TECHNICAL GUIDE: **TA4.2**

## Applications

For use on PVC pipe and fittings

Recommended application temperatures 5°C to 43°C

Recommended for PVC pipe and fittings used in wastewater, stormwater and potable applications

## Product Attributes

Metal container for secure storage

Fast setting cement option for wet conditions and/or quick pressurisation

Medium setting cement option for larger diameter pipes and parallel fit sockets

## Quality

Low V.O.C compliant

ISO 9001:2008 Quality Management System

Solvent cements meet ASTM D-2564

Primers/Cleaners meet ASTM F-656

## All purpose PVC solvent cement and primer/cleaner.

### Product Range

#### Lo-V.O.C. Purple Primer:

- Purple-tinted aggressive primer for use on all sizes of PVC pipe and fittings.
- Removes surface dirt, grease and grime as well as softens the pipe surface to allow a fast, secure solvent weld.
- Colour provides verification that a primer has been used.
- Meets ASTM F-656.



FIG. 1 CF05000P

#### Lo-V.O.C. PVC Medium Clear Cement:

- Medium-bodied clear cement for use on PVC pipe and fittings up to NB 150 mm.
- Recommended application temperature 5°C to 43°C.
- Meets ASTM D-2564.



FIG. 2 SC45000



FIG. 3 SC05000M

#### Lo-V.O.C. PLUMB-TITE™ PVC Medium Blue “HOT” Cement:

- Medium-bodied blue coloured cement for PVC pipe and fittings up to NB 150 mm.
- Very fast setting cement formulated for wet conditions and/or quick pressurization and fast installation.
- Fades to clear in sunlight.
- Recommended application temperature 5°C to 43°C.
- Meets ASTM D-2564.



FIG. 4 SC05000H

#### Lo-V.O.C. PVC Heavy-Duty Gray Cement:

- Heavy-duty gray coloured cement for PVC pipe and fittings up to NB 300 mm (pressure) with interference fit, and NB 450 mm for non-pressure.
- Thick formula fills gaps in large diameter fittings and loose joints.
- Recommended application temperature 5°C to 43°C.
- Meets ASTM D-2564.



FIG. 5 SC38000HD



FIG. 6 SC05000HD & SC09500HD

**Note:** Refer to Table 2 for a solvent cement selection chart.

**TABLE 1** Codes

Product Code	Description	Size (mL)
CF05000P	Pipe Primer Lo-V.O.C. Purple	473
SC05000M	Solvent Cement Lo-V.O.C. Medium Clear	473
SC05000HD	Solvent Cement Lo-V.O.C. Heavy Duty Grey	473
SC05000H	Solvent Cement Lo-V.O.C. PLUMB-TITE Medium "Hot" Blue	473
SC09500HD	Solvent Cement Lo-V.O.C. Heavy Duty Grey	950
SC45000	Solvent Cement Lo-V.O.C. Medium Clear	3780
SC38000HD	Solvent Cement Lo-V.O.C. Heavy Duty Grey	3780
SCD1632	Replacement Dauber and Cap for 473mL and 950mL cans	-
SCD3780	Replacement Dauber and Cap for 3780mL cans	-



**FIG. 7** SCD1632



**FIG. 8** SCD3780

**TABLE 2** Cement selection chart

Nominal Bore Pipe Size																		
	in	½	¾	1	1¼	1½	2	2½	3	4	6	8	10	12	14	16	18	
	mm	15	20	25	32	40	50	65	80	100	150	200	250	300	350	400	450	
Primer	Primer	Purple																
	Heavy Duty	Grey																
PVC Cements	Medium	Clear																
	Medium "Hot"	Blue																

**TABLE 3** Average Joints per U.S. Quart (950mL)

Pipe Dia	15	25	40	50	80	100	150	225	300	375	450
No of Joints	350	200	150	80	60	40	20	8	3	1	0.5

**TABLE 4** Average Joint Cure Time

Pipe Dia	15–32 mm Ø		40–80 mm Ø		100–125 mm Ø		150–200 mm Ø		250–400 mm Ø	450+ mm Ø
	LESS THAN 180PSI	MORE THAN 180PSI	LESS THAN 180PSI	MORE THAN 180PSI	LESS THAN 180PSI	MORE THAN 180PSI	LESS THAN 180PSI	MORE THAN 180PSI	LESS THAN 100PSI	MORE THAN 100PSI
15-40°C	1 hrs	6 hrs	2 hrs	12 hrs	6 hrs	18 hrs	8 hrs	1 day	1 day	36 hrs
5-15°C	2 hrs	12 hrs	4 hrs	1 day	12 hrs	36 hrs	16 hrs	2 days	2 days	3 days
0-5°C	6 hrs	36 hrs	12 hrs	3 days	36 hrs	4 days	3 days	9 days	8 days	12 days

**\*Note:** Relative temp is at 60% humidity  
 In more humid or damp weather conditions allow up to 50% additional cure time.  
 This is a guideline only and may vary depending on field conditions.



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