

## CEMENT SELECTION CHART

	XIRTEC 06 Industrial PVC Cement		XIRTEC 11 Industrial PVC Cement		XIRTEC 17 Industrial PVC Cement		XIRTEC 19 Industrial PVC Cement		XIRTEC 24 Industrial PVC Cement		XIRTEC 7 Primer		IPEX 04 PVC General Purpose Cement		IPEX T1 ABS Cement		IPEX 99 PVC Flex Transition Cement	
Medium Body - Fast Set	Y								Y	Y	Y							
Heavy Body - Medium Set		Y	Y			Y												
Extra Heavy Body - Slow Set				Y														
Max Dia For Pressure (Sch 40)	6"	12"	12"	30"	12"	None	6"	8"	6"									
Max Dia For Pressure (Sch 80)	4"	12"	12"	30"	12"	None	4"	8"	3"									
Max Dia For Drainage Systems	6"	12"	12"	30"	12"	None	6"	8"	6"									
CSA Certified	Y	Y	Y	Y	Y		Y	Y										
NSF Listed	Y	Y	Y	Y	Y	Y	Y	Y										
ULC Listed																		
Primer Required	Y	Y	Y	Y	Y		Y	N	**									
Product Shelf Life (Years)	3	3	3	3	2	3	3	3	3									

\*\*NOT WITH ABS

## AVERAGE NUMBER OF JOINTS/QT. OF CEMENT

Pipe Diameter (inches)	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

Due to the many variables in the field, these figures should be used as a general guide only.

## AVERAGE JOINT CURE SCHEDULE FOR 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"+
	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		
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 hr	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 laboratory tests, extended 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.

## INITIAL SET TIME

### AVERAGE INITIAL SET SCHEDULE FOR PVC & CPVC SOLVENTS CEMENTS

Temperature Range	Pipe Size 1/2" - 1 1/4"	Pipe Size 1 1/2" - 2"	Pipe Size 2 1/2" - 8"	Pipe Size 10" - 15"	Pipe Size 15" +
60° - 100°F	2 min	5 min	30 min	2 hrs	4 hrs
40° - 60°F	5 min	10 min	2 hrs	8 hrs	16 hrs
0° - 40°F	10 min	15 min	12 hrs	24 hrs	48 hrs

NOTE: Initial set schedule is the necessary time to allow before the joint can be carefully handled.

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

After initial set, the joints will withstand the stress of a normal installation. (A misaligned installation will cause excessive stresses in the joint.) For long runs of pipe, care should be taken not to disturb joints for 1/2 to 1 1/2 hours before handling or burying. In damp or humid weather and chemical applications, allow a minimum of 50% more set time.

## JOINT CURE SCHEDULE

The following cure schedules may be used to determine the necessary time required after assembly before testing the system or before line pressure can be applied.

### Relative Humidity      Average Joint cure Schedule for PVC & CPVC Solvent Cements \*\*

60% or less  Temp. Range During Assembly and Cure-Periods	1/2" - 1 1/4"		1 1/2" - 2"		2 1/2" - 8"		10" - 15"	15"+
	up to 160 psi	above 160 - 370 psi	up to 160 psi	above 160 - 315 psi	up to 160 psi	above 160 - 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 hr.	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 and chemical applicants, allow a minimum of 50% more cure time.

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

# CEMENT AND PRIMER

## XIRTEC Industrial PVC Cement, Medium Bodied

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Xirtec 05, Fast Setting, Grey	118 (1/4pt)	24	4.5 (10)	9010074344
	236 (1/2pt)	24	7.3 (16)	9010074345
	473 (pt)	12	6.8 (15)	9010074346
	946 (qt)	12	12.7 (28)	9010074347
	3,785 (gal)	6	24.5 (54)	9010074348

## XIRTEC Industrial PVC Cement, Heavy Bodied

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Xirtec 17, Medium Setting, Grey	473 (pt)	12	6.8 (15)	9010074443
	946 (qt)	12	12.7 (28)	9010074379
	3,785 (gal)	6	24.5 (54)	9010074133
Xirtec 11, Medium Setting, Grey	236 (1/2pt)	24	7.3 (16)	9010074362
	473 (pt)	12	6.8 (15)	9010074363
	946 (qt)	12	12.7 (28)	9010074364
	3,785 (gal)	6	24.5 (54)	9010074365

## XIRTEC Industrial PVC Cement, Extra Heavy Bodied

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Xirtec 19, Slow Setting, Grey	3,785 (gal)	4	24.5 (54)	9010074387

## XIRTEC Industrial CPVC Cement

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Xirtec 24, Medium Setting, Orange	473 (pt)	12	6.8 (15)	9010074008
	946 (qt)	12	12.7 (28)	9010074009

## XIRTEC 7 Primer

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Xirtec 7, Primer, Clear	118 (1/4pt)	24	4.5 (10)	9010074339
	236 (1/2pt)	24	7.3 (16)	9010074340
	473 (pt)	12	6.8 (15)	9010074341
	946 (qt)	12	12.7 (28)	9010074342
	3,785 (gal)	6	24.5 (54)	9010074343
Xirtec 7, Primer, Purple	118 (1/4pt)	24	4.5 (10)	9010074334
	236 (1/2pt)	24	7.3 (16)	9010074335
	473 (pt)	12	6.8 (15)	9010074336
	946 (qt)	12	12.7 (28)	9010074337
	3,785 (gal)	6	24.5 (54)	9010074338

## Duraplus Industrial Solvent Cement

	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
	473 (pt)	20	6.8 (15)	9010337466
	946 (qt)	12	12.7 (28)	9010337467

## Duraplus Airline Solvent Cement

	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
	473 (pt)	20	6.8 (15)	9010437354
	946 (qt)	12	12.7 (28)	9010437355

## Duraplus MEK Cleaner/Primer

	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
	473 (pt)	20	6.8 (15)	9010337468
	946 (qt)	12	12.7 (28)	9010337469

## IPEX 04 PVC General Purpose Cement, Medium Bodied, Fast Setting

Description	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
Clear	118 (1/4pt)	24	4.5 (10)	9010074314
	236 (1/2pt)	24	7.3 (16)	9010074313
	473 (pt)	12	6.8 (15)	9010074312
	946 (qt)	12	12.7 (28)	9010074311
	3.785 (gal)	6	24.5 (54)	9010074310
Grey	473 (pt)	12	6.8 (15)	9010074275
	946 (qt)	12	12.7 (28)	9010074801
	3.785 (gal)	6	24.5 (54)	9010074800

## CEMENT AND PRIMER

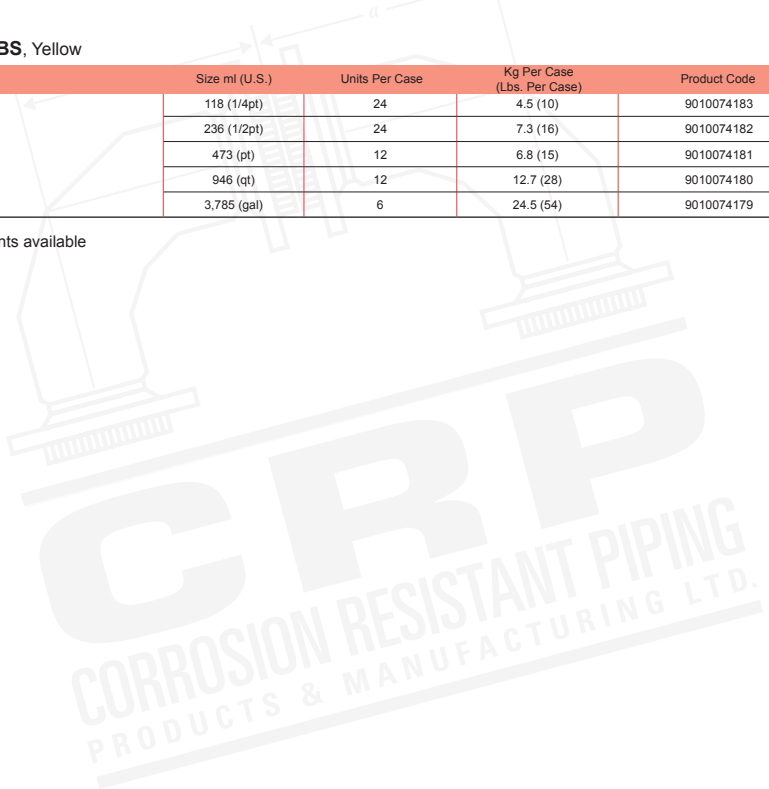
### IPEX 95 Flex, Clear

	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
	118 (1/4pt)	24	4.5 (10)	9010074440
	236 (1/2pt)	24	7.3 (16)	9010074163
	473 (pt)	12	6.8 (15)	9010074411
	946 (qt)	12	12.7 (28)	9010074412
	3,785 (gal)	6	24.5 (54)	9010074413

### IPEX 71 ABS, Yellow

	Size ml (U.S.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
	118 (1/4pt)	24	4.5 (10)	9010074183
	236 (1/2pt)	24	7.3 (16)	9010074182
	473 (pt)	12	6.8 (15)	9010074181
	946 (qt)	12	12.7 (28)	9010074180
	3,785 (gal)	6	24.5 (54)	9010074179

\*Other cements available



## Bristle Brush / Cap

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
PB-1 Plastic handle brush fits pint and quart size cans	25 (1)	100	5.9 (13)	9010074428
CM BCP Can-Mate adjustable brush fits pint and quart size cans	25 (1)	100	3.6 (8)	9010074454

## Can-Mate Dauber

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
CM-75	20 (3/4)	50	1.8 (4)	9010074436
CM-150	40-75 (1 1/2-3)	50	1.8 (4)	9010074437

Adjustable applicator with telescoping stem; fits 1/2 pint, pint, and quart size cans.

## Cap Dauber

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
DP 50 for pipes up to 1"	12 (1/2)	100	1.4 (3)	9010074455
DP 75 for pipes up to 1 1/2"	20 (3/4)	100	1.4 (3)	9010074420
DP 150 for pipes up tp 3"	40 (1 1/2)	100	1.4 (3)	9010074421
DQ 150 for pipes up tp 3"	40 (1 1/2)	100	1.4 (3)	9010074422

DP fits 1/2 pint and pint cans; DQ fits quart size cans.

## Roll-A-Weld Roller

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
3020 roller for pipe diameters 3" to 6". Fits an MT 653 can.	75 (3)	24	3.2 (7)	9010074426
7020 roller for pipe diameters 6" and larger. Fits an MT 648 can.	180 (7)	20	3.6 (8)	9010074427

## Swab

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
4020 swab for pipe diameters 6" and larger. Fits MT 648 can.	100 (4)	24	2.3 (5)	9010074456

## Can with Neck

Description	Size mm (in.)	Units Per Case	Kg Per Case (Lbs. Per Case)	Product Code
MT-654; 1 3/4" neck, 473 (pt)	-	100	10.0 (22)	9010074423
MT-653; paint style neck, 946 (qt)	-	50	6.4 (14)	9010074419
MT-651; 1 3/4" neck, 946 (qt)	-	50	6.8 (19)	9010074424
MT-648; 2 7/8" neck, 3785 (gal)	-	20	8.6 (19)	9010074425