AllFlow Supply Co. Pty Ltd
Piping & Flow Control Specialists
www.allflowsupply.com.au

Product Bulletin # DS0035

All Purpose Clear Heavy Duty Cement

ALL PURPOSE CLEAR HEAVY DUTY CEMENT

RECOMMENDED USES

The All Purpose Clear Heavy Duty Cement is specially formulated to solvent weld up to 6" (150 mm) diameter Sch. 40 and Sch. 80 ABS, PVC and Sch. 40 CPVC pipe.

TEMPERATURE RANGE USE

40°F (5°C) to 100°F (38°C)

WARNING:
EXTREMELY FLAMMABLE.

DO NOT USE NEAR HEAT, SPARKS OR OPEN FLAME.

STORE IN COOL, WELL VENTILATED AREA.

PRESSURE RANGE

Liquids

Up to 600PSI (4.36 kPa) on ABS*
Up to 350 PSI (2400 kPa) on PVC*
Up to 275 PSI (1900 kPa) on CPVC*

*LIQUID PRESSURE RANGE: For a 2" (50mm) diameter solvent welded pipe and fitting tested under liquid pressure at 73° (23°C). Sizes vary in accordance with pipe manufacturer's specifications for pressure ratings of pipe.

The All Purpose Clear Heavy Duty Cement is an extra strong medium bodied plastic weld cement of smooth consistency, formulated to work with ABS, PVC and CPVC solvent weld plastic pipe and fittings.

It also will solvent weld ABS to PVC, PVC to CPVC or CPVC to ABS, provided tolerances of pipe and fittings match. Should be used in conjunction with CLEAR CLEANER or PURPLE PRIMER.

DIRECTIONS FOR USE:

1. Cut the pipe square and remove all burrs.
2. Check fitting of pipe. If too loose or too tight, pipe should not be used. Ideal fit between pipe and fitting before cementing allows pipe to enter to full depth of socket easily.
3. Remove all dust, moisture, grease, oil and any other foreign material from pipe and fitting. Clean pipe and fitting with CLEAR CLEANER. While surface is still damp with primer, apply cement as follows.
4. Apply enough cement uniformly to pipe and fitting to form a bead of cement at outside end of pipe. Prevent excess cement from forming on bare inside walls of pipe.
5. Brush cement generously on the outside of the pipe to the depth of the fitting. Do not thin cement with primers or cleaners.
6. Immediately after cement is applied, insert pipe to the bottom of the socket, and hold in place 30 seconds until cement sets. Assemble parts QUICKLY. If cement is not fluid, re-coat both parts and repeat procedure.
7. Remove excessive cement with a dry cloth only.
8. Allow about 30 minutes for good handling strength. Allow 4 hours for high strength. For best quality joints, remove water or moisture from pipe and fitting and allow 2-24 hours cure time. Cure time before testing depends on size, fit, temperature and pressures.
9. Keep container closed at all times when not using to avoid moisture absorption and vapor losses. Keep cement from freezing.

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