

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 | 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 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**

| 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"+ | |
|-------------------------------|--|---------------|----------------------------------|---------------|------------------------------|---------------|--------------------------------|---------------|--------------------------|--|
| | 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 | 1½ 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.

** 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

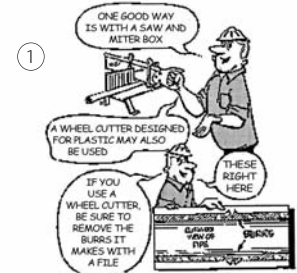
1. Cut pipe square and remove all burrs.
2. Wipe pipe end and fitting socket with a clean cloth to remove dirt and moisture.
3. Check the dry fit of the pipe and fitting; should be tight.
4. Use an applicator or brush that is a width of 1/2 the pipe diameter.
5. For best results, remove gloss from pipe 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



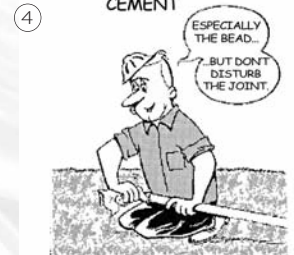
CLEAN PIPE WITH RAG



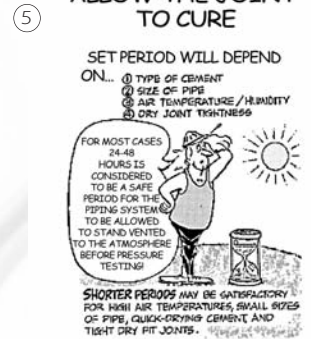
APPLY CEMENT



WIPE OFF EXCESS CEMENT



ALLOW THE JOINT TO CURE



PRESSURE TEST

