



Skill and knowledge are required on the part of the operator to obtain a good quality joint. Arrow recommends the following solvent welding techniques be followed, in addition to instructions on product labels.

HIGH HUMIDITY & WET CONDITIONS

In high humidity, quick application is important to minimize condensation of moisture on the cement surface. Allow longer curing time. **ARROW Pool & Turf PVC Cement '1132'**, is specially formulated for wet conditions and is EXTREMELY fast setting.

HOT WEATHER

Store solvent cement, primer, pipe and fittings in shaded or cool areas before solvent welding. At the time of assembly, the surface temperature of the mating surfaces should not exceed 100°F. In direct sunlight or in ambient temperatures above 100°F, the pipe surface may exceed 100°F. The pipe temperature should be reduced by swabbing the surface to be cemented with clean, wet rags. Be sure to thoroughly dry the pipe before applying the primer and cement. Work quickly so cement does not dry before assembly.

COLD WEATHER

In cold weather below freezing (32°F), solvents penetrate and soften the plastic surfaces more slowly than in warm weather. Also, the plastic is more resistant to solvent attack. For these reasons it is recommended that all solvent welding materials be stored in warm areas until ready for use. If solvent cement is exposed to cold temps for extended period of time, it may freeze. In this case, bring into warm area and allow material to sit and become fluid. Before use, shake vigorously to ensure usability.

OTHER COLD WEATHER TIPS

1. Prefabricate as much of the system as possible in a heated work area.
2. Store sealed cement cans in a warmer area when not in use and make sure they remain fluid. Use **ARROW Weather-All PVC Cement '1128'**, for best results.
3. Remove all moisture, ice and snow from pipe and fitting surfaces before assembly.
4. Use **ARROW Primer '911'**, to soften PVC and CPVC surfaces before applying cement.
5. Allow a longer cure time before the system is used. This is necessary because the solvents evaporate much slower in cold temperatures. The cure time required at 10 to 20°F is 8+ times longer than at 60 to 100°F. Refer to ASTM D 2855 for specific guidelines and instructions.

See also our [Frequently Asked Questions](#) and [How and Why](#) sheets for further information.