



A CSW Industrials Company

Solvent Cements

Fast, easy, and reliable
solvent cements, primers, and cleaners



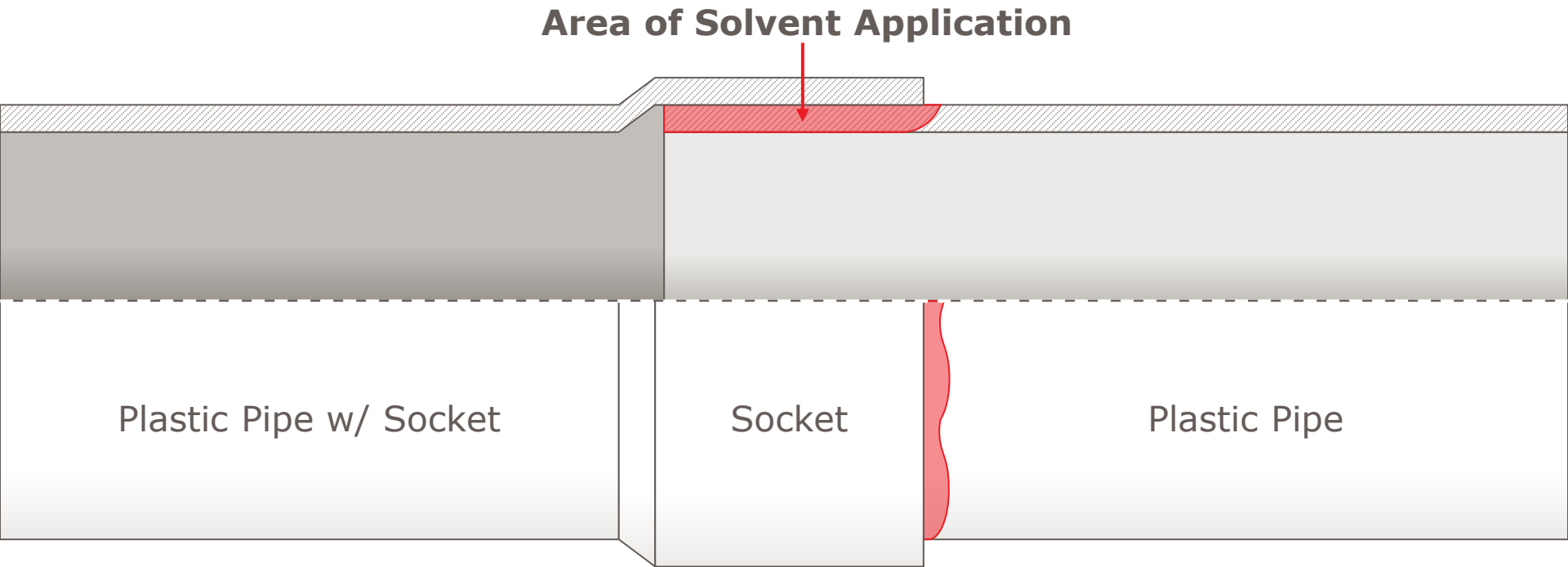
What are solvent cements used for?

Solvent cements create an **impermeable seal by dissolving the PVC surfaces**, fusing them together using the PVC filler in the cement.



How does solvent cement work?

Solvent cement is not a glue. It works by **dissolving the PVC surfaces and welds to the PVC filler in the cement** forming an integral matrix of PVC across the interface.



How to Use Plastic Solvent Cements

1. Cut the pipe to the proper length and ensure it fits as desired. Make sure the cut is straight (square and not angled)
2. Debur edges of pipe and inside fitting
3. Apply pipe cleaner with to both pipe and fitting
4. Apply high etch primer to both pipe and fitting
5. Apply proper solvent cement to both pipe and fitting
6. Insert pipe into fitting with a twisting motion until you bottom out in the fitting
7. Wipe excess solvent cement from pipe



Solvent Cement Body

The body of a solvent cement refers to its viscosity, or thickness.

Viscosity affects the way solvent cements flows and bonds pipes and fittings together.

Regular Body

*Typically used for joining
Small diameter
pipes and fittings*

Medium Body

*Typically used for joining
Larger diameter
pipes and fittings*

Heavy Body

*Typically used for
High pressure or
high temperature
applications*

Thinner

High viscosity

**Standard Bond
Quick Set Time**

Thicker

Low viscosity

**Stronger Bond
Longer Set Time**

Solvent Cement Colors

Solvent cement colors are used to **identify specific applications and piping material types.**



**Clear
PVC**

**Grey
Electrical
Conduit**

**Black
ABS**

**Gold
CPVC**

**Orange
CPVC**

**Blue
Irrigation
type use**

Types of Plastic Pipe

PVC

Polyvinyl Chloride

Designed for: **Pressured fluids**

CPVC

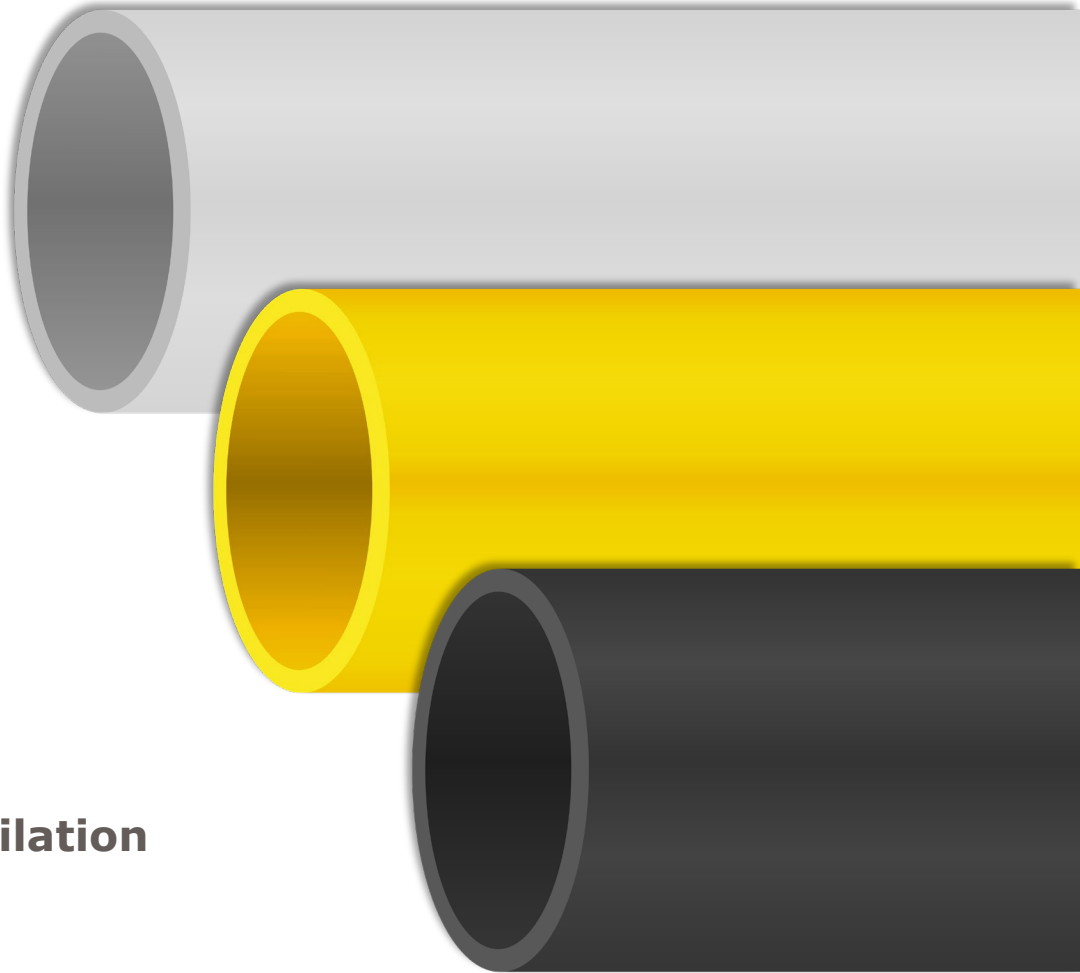
Chlorinated Polyvinyl Chloride

Designed for: **Pressured fluids**

ABS

Acrylonitrile Butadiene Styrene

Designed for: **Drain waste or ventilation**



Why RectorSeal Solvent Cements?



A CSW Industrials Company



RectorSeal solvent cements ensure a strong, consistent weld every time. Chemical batch quality validation.



RectorSeal solvent cements are available in the widest variety of sizes and formulas for welding PVC, CPVC, and ABS pipe installation.



RectorSeal solvent cements and primers have been delivering strong, consistent pipe installation for **over 50 years.**

RectorSeal solvent cements are available in the **widest variety of sizes and formulas** for welding PVC, CPVC, and ABS pipe installation.

Chemical Batch Quality Validation

RectorSeal solvent cements, primers and cleaners are tested for quality.

Complete Pipe Joining Solution

Our complete family of PVC, CPVC & ABS solvents are cousins to our unmatched lineup of pipe thread sealants.

Strong, consistent weld

RectorSeal primers properly etch the pipe surfaces to ensure a strong and consistent weld every time.



LEED
Compliant



NSF pw-dwv-sw



Note: Features, applications, and materials applicable to individual products. See individual products for details.

RectorSeal solvent cements are available in the **widest variety of sizes and formulas** for welding PVC, CPVC, and ABS pipe installation. Available in three body thicknesses - Regular, Medium & Heavy - to accommodate each application needs.

Color range easily identifies the right solvent cement for the application.



One source, complete line.



Note: Features, applications, and materials applicable to individual products. See individual products for details.

Trusted since 1937, RectorSeal has a history of **pipe joining chemical market leadership and innovation.**

RectorSeal solvent cements and primers have been delivering strong, consistent pipe installation for **over 50 years.**



Solvent Cements



Pete 602L



Gene 404L



Gold 844L



Homer 828L



Arctic 616L



Charlie 412L



Heavy Duty 811L



Mike 425L



Dura-Gold 627L



Hot 203L



**PVC Electrical
Conduit 633L**

Primers & Cleaners



Jim PR-1L



Clear PR-2L



Bill PR-3



Sam CL-3L

Pete 602L Solvent Cement

PVC Medium Body

○ Clear

- Pete 602L is a thicker formula, so it reduces product run-off and has excellent gap filling characteristics
- LEED compliant and NSF approved for potable water
- 3 year shelf life
- UPC (IAPMO) listed
- Exceeds ASTM D 2564 specifications
- Low-VOC

Applications

Used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784. For use on PVC pipe up to and including 6" for schedule 40 and 11/4" for schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems



PVC Regular Body

○ Clear

- Faster setting regular body formula is ideal where makeup time is at a premium on smaller diameter pipe
- LEED compliant and NSF approved for potable water
- 3 year shelf life
- UPC (IAPMO) listed
- Exceeds ASTM D 2564 specifications
- Low-VOC

Applications

Used for joining PVC pipe & socket-type fittings which meet Class 12454 as defined in ASTM specification D1784. For use on PVC pipe through 2" schedule 40 pressure piping & up to/including 4" Schedule 40 non-pressure (DWV) piping.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems



Gold 844L Solvent Cement



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PVC Heavy Body

○ Clear

- Heavy body formula provides superior bonding strength, flexibility of application and excellent gap filling characteristics
- UPC (IAPMO) listed
- Exceeds ASTM D 2564 specifications
- LEED compliant and NSF approved for potable water
- 3 year shelf life
- Low VOC

Applications

Polyvinyl chloride (PVC) solvent cement used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784. For pipe up to 12" all PVC pipe schedules and classes including schedule 40 and schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems



Homer 828L Solvent Cement



PVC Heavy Body

○ Gray

- Provides superior bonding strength and flexibility of application
- LEED Compliant and NSF approved for potable water
- 3 year shelf life
- Exceeds ASTM D 2564 specifications and UPC (IAPMO) listed
- Low VOC

Applications

Used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784. It is for use on all PVC pipe Types I and II through 12" Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems



Arctic 616L Solvent Cement



PVC Medium Body

○ Clear

- Specifically designed for use in cold weather. Remains stable from 0°F to 120°F
- LEED Compliant and NSF approved for potable water
- UPC (IAPMO) listed under File No. 1796 and exceeds ASTM D 2564 specifications
- 3 year shelf life
- Low VOC
- State of Wisconsin Approved

Applications

Used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784. It is for use on PVC pipe through 6" Schedule 40 and 1 1/4" Schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems



Charlie 412L Solvent Cement



CPVC Regular Body

Orange

- Charlie 412L's faster setting regular body formula is ideal where makeup time is at a premium on smaller diameter pipe
- UPC (IAPMO) listed under File No. 4586
- Meets ASTM F 493 specifications
- LEED Compliant
- 3 year shelf life
- Low VOC

Applications

Charlie 412L is for use on CPVC pipe through 2" Schedule 40 (excluding Schedule 80).

Recommended For

- Potable water
- Pressure pipe
- DWV systems



Heavy Duty 811L Solvent Cement



CPVC Heavy Body

Orange

- Heavy Duty - 811L's heavy body formula reduces product run-off and has excellent gap filling characteristics as well as superior bonding strength
- UPC (IAPMO) listed under File No. 4586
- Meets ASTM F 493 specifications
- LEED Compliant
- 3 year shelf life
- Low VOC

Applications

Heavy Duty 811L is for use on all classes of CPVC pipe through 12" Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Pressure pipe
- DWV systems



Mike 425L Solvent Cement



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Multi-purpose Medium Body

○ Amber

- Meets ASTM D3138 specifications and Exceeds ASTM F 493 specifications
- Multipurpose- can be used with PVC, CPVC, ABS
- LEED Compliant
- Features a regular body for faster set times and improved brushability
- 3 year shelf life
- Low VOC

Applications

For use on all PVC, CPVC and ABS pipe classes for pressure systems through 2" Schedule 40 and non-pressure piping systems through 6" Schedule 40 (excluding Schedule 80). It is also for use on transition joints to join PVC to CPVC & PVC to ABS.

Recommended For

- Water
- Pressure pipe
- DWV systems



Dura-Gold 627L Solvent Cement



CPVC Medium Body

○ Gold

- One-step, no primer needed (when code allows)
- Max VOC per SCAQMD 1168/316A or BAAQMD Method 40: 490 g/l
- NSF approved for potable water
- LEED compliant
- 3 year shelf life
- Meets ASTM F493 specs
- Low VOC

Applications

For use with Flowguard Gold CPVC and Dura-Temp G-75 pipe & fittings on all schedules & classes up to & including 2" on schedule 40 and 1 1/4" on schedule 80. Approved for all CPVC pipe uses including potable water, pressure pipe & DWV systems.

Recommended For

- All CPVC pipe
- Potable water
- Pressure pipe
- DWV systems



Hot 203L Solvent Cement



PVC Medium Body

○ Blue

- LEED compliant and safe for potable water systems. Excellent in cold weather applications.
- Our fastest setting PVC solvent cement. Can be pressure tested after 15 minutes. Accepts full line pressure after only one hour
- NSF approved, IAMPO listed and Meets ASTM D 2564 specifications
- 3 year shelf life
- Low VOC

Applications

For use on all rigid PVC classes up to & including 6" schedule 40 and 11/4" schedule 80. May also be used on flexible PVC hose with rigid fittings or hose-to-hose insertion-type connections that meet Class 12454 as defined in ASTM specifications D1784.

Recommended For

- Irrigation
- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems
- ENT



PVC Electrical Conduit 633L Solvent Cement



PVC Medium Body

○ Clear ● Gray

- Easier application on all PVC electrical conduit sizes
- Easier use with larger application dauber
- Better pouring capability
- LEED compliant
- 3 year shelf life
- Meets ASTM D2564
- NSF approved formula (clear only)
- Low VOC

Applications

Designed for use on PVC conduit types I & II, up to and including 6" for Schedule 40 and Schedule 80. It has excellent gap filling characteristics & a thick formula to reduce runoff. Medium fast setting allows corrections before setting up.

Recommended For

- PVC Conduit types I & II



PVC, CPVC Hi-etch

○ Purple

- Jim PR1L's purple color ensures easy visual check for complete coverage
- Meets ASTM F 656 specifications, Low-VOC and LEED Compliant. NSF approved for potable water systems.
- 3 year shelf life
- UPC (IAPMO) listed under File No. 4585
- Low VOC

Applications

Prepares surfaces for superior bonding strength. For use on PVC and CPVC pipe, tubing and socket-type fittings in both Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Conduit
- Sewers
- DWV systems
- Irrigation



PVC, CPVC Hi-etch

○ Clear

- Fast acting
- Superior bonding
- LEED compliant
- 3 year shelf life
- Low-VOC
- Meets ASTM F656
- NSF approved for potable water

Applications

Prepares surfaces for superior bonding strength. For use on PVC and CPVC pipe, tubing and socket-type fittings in both Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Irrigation
- Pressure pipe
- Conduit
- Sewers
- DWV systems



PVC, CPVC Hi-etch

○ Clear

- Manufactured from only high quality 100% virgin materials
- 3 year shelf life
- Low-VOC
- LEED compliant
- Meets ASTM F656
- NSF approved for potable water

Applications

Use on all PVC and CPVC pipe, tubing and socket-type fittings to etch and penetrate the surface increasing body strength. It is for use with all sizes and classes in both Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Irrigation
- Pressure pipe
- Conduit
- Sewers
- DWV systems



Multi-purpose Fast acting

○ Clear

- Low-VOC
- LEED compliant
- Safe for use on potable water systems
- 3 year shelf life

Applications

Clear cleaner for dissolving grease and dirt to prepare bonding surfaces for solvent cementing. Used for PVC, CPVC and ABS pipe, tubing and socket-type fittings Schedule 40 and Schedule 80.

Recommended For

- Potable water
- Pressure pipe
- Sewers
- Conduit
- DWV systems
- Irrigation



Why RectorSeal Solvent Cements?



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Quality

RectorSeal solvent cements ensure a strong, consistent weld every time. Chemical batch quality validation.

Versatility

RectorSeal solvent cements are available in the widest variety of sizes and formulas for welding PVC, CPVC, and ABS pipe installation.

Longevity

RectorSeal solvent cements and primers have been delivering strong, consistent pipe installation for **over 50 years.**

Additional Plumbing Chemical Products



Calci-free Tankless water heater flush

Tankless water heater coils can buildup deposits that restrict hot water pressure.

Calci-free removes coil deposits and fully restores hot water flow and efficiency.

- Restores circulation in 20 min.
- More effective than vinegar
- Easy to use with no strong odor
- Cleans heat exchanger fast
- Biodegradable*
- Kit offers a complete cleaning system including a heavy duty, chemical utility pump
- 8' power cord



*Contains the best available biodegradable surfactants and detergents.

Additional Plumbing Chemical Products



Calci-flush

Tanked water heater flush

Tanked gas and electric water heaters buildup tank deposits that inhibit the transfer of heat from the heating element to the water.

Calci-flush restores tank and hot water temperature efficiency.

- Restores tank and water temperature in under 60 minutes
- Removes tank sediment
- Restores water temperature
- More effective than vinegar
- Easy to use with no strong odor
- Biodegradable*
- 3/4" Hose Adapter included



*Contains the best available biodegradable surfactants and detergents.

Additional Plumbing Chemical Products



Nu Line AC Drain Line Cleaner

Formulated to prevent clogged A/C condensate drains and floods by loosening/removing slime & scum build-up in A/C, refrigeration & drinking fountain drain pans, lines, & pumps.

Non-corrosive alternate to chlorine tabs/bleach.

Resists build-up for <90 days.

- Easily dispensed
- Long lasting
- Enzyme based
- Environmentally friendly



Additional Plumbing Chemical Products



Liquid Drain Acid-Free Drain Cleaner

LiquidDrain is a commercial strength, non-acid, and non-flammable drain opener.

LiquidDrain's penetrating surfactant foaming action lifts and pushes contaminants off to rapidly clear drain, sewer, or waste line.

- Non-acid, non-flammable
- High foaming, odor free
- Will not harm septic tanks, cesspools, drainage fields and leaching systems when used according to directions
- Child-proof caps to prevent accidental openings
- Works in 15-30 minutes



Additional Products: Pipe Thread Sealants



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RectorSeal No. 5

Multi-purpose



T Plus 2

PTFE enriched



Tru-Blu

Vibration resistant



Blue+

PTFE enriched,
non-setting



No. 7

Corrosive chemical



No. 21

Black, slow
dry/soft set



No. 5 Sub-Zero

Low temperature,
low odor



No. 5 Special

Low odor



PTFE Tape

100% pure PTFE

Solvent Cements Product Selector



A CSW Industrials Company

	SOLVENT CEMENTS	PVC								ABS	CPVC			PVC/CPVC Multipurpose	PRIMERS & CLEANERS	PVC CPVC	PVC CPVC	PVC CPVC	PVC/CPVC ABS		
Product Name		Gene 404L	Pete 602L	Arctic 616L	Hot 203L	Electrical Conduit 633L	Electrical Conduit 633L	Gold 844L	Homer 828L		John 647L	Charlie 412L	Dura-Gold 627L	Heavy Duty 811L		Mike 425L	Jim PR-1L	Clear PR-2L	Bill PR-3	Sam CL-3L	
Body		Regular	Medium						Heavy			Medium	Regular	Medium		Heavy	Medium	Hi-Etch Primer			Cleaner
Color		Clear	Clear	Clear	Blue	Clear	Gray	Clear	Gray		Black	Orange	Gold	Orange		Light Amber	Purple	Clear	Clear	Clear	
Low-VOC		✓	✓	✓	✓	✓	✓	✓	✓		✓	✓	✓	✓		✓	✓	✓	✓	✓	
Max. Pipe Size Schedule 40		4 in	6 in	6 in	6 in	6 in	6 in	12 in	12 in		6 in	2 in	2 in	12 in		6 in	All	All	All	All	
Max. Pipe Size Schedule 80		-	1 ¼ in	1 ¼ in	1 ¼ in	6 in	6 in	12 in	12 in		6 in	-	1 ¼ in	12 in		-	All	All	All	All	
Max. Pipe Size Schedule 40 (pressure)		2 in	6 in	6 in	6 in	-	-	12 in	12 in		-	2 in	2 in	12 in		2 in	All	All	All	All	
Max. Pipe Size Schedule 80 (pressure)		-	1 ¼ in	1 ¼ in	1 ¼ in	-	-	12 in	12 in		-	-	1 ¼ in	12 in		-	All	All	All	All	
One Step Cement		-	-	-	-	-	-	-	-		-	-	✓	-		-	-	-	-	-	
Potable Water		✓	✓	✓	✓	-	-	✓	✓		-	✓	✓	✓		-	✓	✓	✓	✓	
Pressure Pipe		✓	✓	✓	✓	-	-	✓	✓		-	✓	✓	✓		✓	✓	✓	✓	✓	
Gas Lines		-	-	-	-	-	-	-	-		-	-	-	-		-	-	-	-	-	
Conduit		✓	✓	✓	✓	✓	✓	✓	✓		-	-	-	-		-	✓	✓	✓	✓	
Sewer Pipe		✓	✓	✓	✓	-	-	✓	✓		✓	-	-	-		-	✓	✓	✓	✓	
DWV Systems		✓	✓	✓	✓	-	-	✓	✓		✓	✓	✓	✓		✓	✓	✓	✓	✓	
Irrigation lines		-	-	-	✓	-	-	-	-		-	-	-	-		-	✓	✓	✓	✓	
Pool, Spa, Flexible hose		-	-	-	-	-	-	-	-		-	-	-	-		-	-	-	-	✓	
Industrial		-	✓	-	-	-	-	✓	✓		-	-	-	✓		-	✓	✓	✓	✓	
Max Service Temp		140°	140°	140°	140°	140°	140°	140°	140°		180°	180°	180°	180°		180°	180°	180°	180°	-	
Hot Water (180°)	-	-	-	-	-	-	-	-		-	✓	✓	✓	-	✓	✓	✓	✓			
Recommended Application Temp	40°-120°F	40°-120°F	0°-120°F	40°-120°F	40°-120°F	40°-120°F	40°-120°F	40°-120°F		40°-120°F	40°-120°F	40°-120°F	40°-120°F	40°-120°F	-15°-120°F	-15°-120°F	-15°-120°F	-15°-120°F			
Cure Time	Fast	Fast	Fast	Very Fast	Fast	Fast	Medium	Medium		Fast	Fast	Fast	Medium	Fast	-	-	-	-			
LEED Compliant	✓	✓	✓	✓	✓	✓	✓	✓		-	✓	✓	✓	-	✓	✓	✓	-			
Product code - Qtr. Pint (24)	55901	55922	-	55988	-	-	-	-		55938	55956	-	-	55969	55910	-	-	55929			
Product code - Half Pint (24)	55902	55924	-	55989	55980	-	55951	-		55940	55957	55992	-	55970	55912	-	-	55930			
Product code - Pint (12)	55904	55926	55919	55990	55983	-	55952	55961		55942	-	55998	55967	55973	55914	55972	55705	55932			
Product code - Quart (12)	55906	55928	55948	55993	55985	55996	55954	55963		55944	-	-	55968	55974	55918	55981	55707	55934			
Product code - Gallon (4)	55908	55916	55953	55994	55979	-	55955	55964		-	-	-	-	-	55920	55982	-	55936			
Shelf Life	3 year	3 year	3 year	3 year	3 year	3 year	3 year	3 year		2 year	2 year	2 year	2 year	2 year	3 year	3 year	3 year	3 year			



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