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.

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**Area of Solvent Application**

- **Plastic Pipe w/ Socket**
- **Socket**
- **Plastic Pipe**
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. Deburr 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
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
- Thinner
- High viscosity
- Standard Bond
- Quick Set Time

**Medium Body**
- Typically used for joining larger diameter pipes and fittings
- Thicker
- Low viscosity
- Stronger Bond
- Longer Set Time

**Heavy Body**
- Typically used for high pressure or high temperature applications
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?

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.

<table>
<thead>
<tr>
<th>Chemical Batch Quality Validation</th>
<th>Complete Pipe Joining Solution</th>
<th>Strong, consistent weld</th>
</tr>
</thead>
<tbody>
<tr>
<td>RectorSeal solvent cements, primers and cleaners are tested for quality.</td>
<td>Our complete family of PVC, CPVC &amp; ABS solvents are cousins to our unmatched lineup of pipe thread sealants.</td>
<td>RectorSeal primers properly etch the pipe surfaces to ensure a strong and consistent weld every time.</td>
</tr>
</tbody>
</table>

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.

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One source, complete line.

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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.**
Lineup

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

**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 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

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Gene 404L Solvent Cement

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

### 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

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

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
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

**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

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**CPVC Heavy Body**

- 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
Mike 425L Solvent Cement

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 11/4" 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

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 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
PVC Electrical Conduit 633L Solvent Cement

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 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
Jim PR-1L Primer

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
- 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
Clear PR-2L Primer

**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
Bill PR-3 Primer

**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
### Sam CL-3L Cleaner

#### Multi-purpose
- Fast acting
- Clear

#### 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

- Low-VOC
- LEED compliant
- Safe for use on potable water systems
- 3 year shelf life
Why RectorSeal Solvent Cements?

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

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

Liquid Drain'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

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

<table>
<thead>
<tr>
<th>Product Name</th>
<th>PVC</th>
<th>ABS</th>
<th>CPVC</th>
<th>PVC/CPVC Multipurpose</th>
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<td>Color</td>
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<td>Max Pipe Schedule 80</td>
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**PRIMERS & CLEANERS**

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