



IPS CORPORATION

IPS[®]

WELD·ON

P R O D U C T G U I D E

**Plastic Pipe Cements • Primers • Cleaners
Applicators • Accessories • Special Products**



**The Leader in Innovative Products
for the Plastic Pipe Industry**



IPS Corporation was the first company to formulate a reliable solvent cement for the joining of PVC, CPVC and ABS plastic pipe and fittings.

We have been recognized for over four decades as the industry leader in the development of solvent cements, primers and adhesives for joining plastic to plastic and to other dissimilar materials.



In a time when quality takes a back seat to reducing manufacturing costs in many companies, **IPS Corporation** continues to maintain the most extensive quality control program in the industry.

From day one, we have offered our customers the highest quality solvent cements commercially available. It is for this reason, **IPS Weld-On** products are used more than any other.



We thank you for choosing **IPS Weld-On** products. Feel free to contact us if further assistance regarding our products, their usage or installation information is needed.



IPS produces a wide range of high strength WELD-ON® solvent cements for rigid and flexible plastic pipe and fittings. Regular, medium, heavy and extra heavy bodied cements are specifically formulated for pipe and fittings up to 30” diameter. These products are ideal for use with potable water pressure systems, irrigation, turf, conduit, pool and spa, industrial piping, sewer, drain, waste and vent systems.















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PVC REGULAR BODIED SOLVENT CEMENTS

These are free-flowing, fast curing products for small diameter PVC pipe and fittings in all classes and schedules (except Schedule 80) with interference fit type sockets.

<p>Clear</p> 		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>700™</p> <p>Regular bodied, fast setting, PVC cement for all classes and schedules with interference fit through 4" diameter (except Schedule 80). This product may also be used on PVC foam core pipe.</p>
<p>Clear</p> 		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>702™</p> <p>Regular bodied, fast setting, PVC cement for all classes and schedules with interference fit through 4" diameter (except Schedule 80). This product may also be used on PVC foam core pipe.</p>
<p>Clear</p> 		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>710™</p> <p>Regular bodied, very fast setting, PVC cement for all classes and schedules with interference fit through 2" diameter (except Schedule 80).</p>


PVC MEDIUM BODIED SOLVENT CEMENTS

These products are approved for use on PVC pipe and fittings in all classes and schedules with interference fit type sockets up to 6" diameter; Schedule 80 through 4" diameter.

<p>Clear</p>  <p>Gray</p> 	 <p>Clear Gray</p>	<p>CLEAR/GRAY 3 Year Shelf Life Meets ASTM D-2564</p>    <p>Gray Only</p>	<p>704™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p>
<p>Clear</p>  <p>Gray</p>  <p>White</p> 		<p>CLEAR/GRAY/WHITE 3 Year Shelf Life Meets ASTM D-2564</p>    <p>Gray Only</p>	<p>705™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p>
<p>Blue</p> 		<p>BLUE 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>721™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p>

PVC HEAVY BODIED SOLVENT CEMENTS

Our heavy bodied products exhibit excellent pipe-to-fitting gap filling properties. They can be used on larger pipe and fittings in all classes and schedules with interference fit type sockets through 12" diameter.

<p>Gray</p> 		<p>GRAY 3 Year Shelf Life Meets ASTM D-2564</p>   	<p>711™</p> <p>Heavy bodied, medium setting, PVC cement for all classes and schedules with interference fit through 12" diameter, including Schedule 80. It has good gap filling properties and its medium set allows more working time in warm weather.</p>
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PVC HEAVY BODIED SOLVENT CEMENTS *(continued...)*

Our heavy bodied products exhibit excellent pipe-to-fitting gap filling properties. They can be used on larger pipe and fittings in all classes and schedules with interference fit type sockets through 12" diameter.

Clear 

Gray 



CLEAR/GRAY
3 Year Shelf Life
Meets ASTM D-2564

  
Gray Only

717™

Heavy bodied, medium setting, PVC cement for all classes and schedules (including Schedule 80) with interference fit through 12" diameter, non-pressure applications only up to 18" diameter. It has good gap filling properties and its medium set allows more working time in warm weather.

PVC EXTRA HEAVY BODIED SOLVENT CEMENTS

This product provides a thicker layer and has higher gap filling properties which makes it an excellent product for large diameter pipe and fittings with interference fit type sockets up to 30" diameter.

Gray 

White 



GRAY/WHITE
3 Year Shelf Life
Meets ASTM D-2564

  
Gray Only

719™

Extra heavy bodied, slow setting, PVC cement for all classes and schedules with interference fit through 30" diameter, including Schedule 80. It is a good fabrication cement, as it has excellent gap filling properties and because of its slow set, a good hot weather cement on large diameter pipe.

PVC SPECIALTY CEMENTS

These "Special Formula" products are approved for use on PVC pipe and fittings in all classes and schedules with interference fit type sockets.

Aqua Blue 



AQUA BLUE
3 Year Shelf Life
Meets ASTM D-2564

725™ Wet 'R Dry™

Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. Specially formulated for rigid and flexible applications where conditions are wet and/or when quick pressurization is desired. Can be used without primer on non-pressure systems if local codes permit.

Clear 



CLEAR
3 Year Shelf Life
Meets ASTM D-2564

727™ Hot 'R Cold™

Medium bodied, very fast setting, PVC cement for all classes and schedules of rigid and flexible pipe and fittings with interference fit through 6" diameter, Schedule 80 through 4" diameter. It is a superb cold weather product with performance to -15° F. Can be used without primer on non-pressure systems if local codes permit.

Blue 



BLUE
3 Year Shelf Life
Meets ASTM D-2564

735™ Wet 'N Fast™

Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. For rigid and flexible applications, wet conditions and/or quick pressurization. It is specifically formulated to meet the needs of the plumbing industry. Can be used without primer on non-pressure systems if local codes permit.

Blue fades to Clear 



BLUE (fades to CLEAR)
3 Year Shelf Life
Meets ASTM D-2564

737™ Turf 'N Ag™

Medium bodied, very fast setting, PVC cement for all classes and schedules with interference fit through 8" diameter, Schedule 80 through 4" diameter. It is an excellent product for PVC foam core, well casing, flexible and rigid applications. Works well in wet conditions. Can be used without primer on non-pressure systems if local codes permit.

Blue fades to Clear 



BLUE (fades to CLEAR)
3 Year Shelf Life
Meets ASTM D-2564

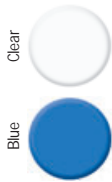
  

747™ Pool 'R Spa™

Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. Developed for rigid & flexible applications, wet conditions and/or quick pressurization. Can be used without primer on non-pressure systems if local codes permit.

PVC SPECIALTY CEMENTS *(continued...)*

These "Special Formula" products are approved for use on PVC pipe and fittings in all classes and schedules with interference fit type sockets.



CLEAR/BLUE
3 Year Shelf Life



795™

Medium bodied, fast setting, PVC cement for all flex/flex & flex/rigid PVC pipe and fittings with interference fit through 6" diameter, Schedule 80 through 3" diameter. Excellent product for flex/rigid applications. It has an elastomer in the formulation which allows a more flexible joint.

CPVC SOLVENT CEMENTS

These products are approved for use on CPVC pipe and fittings in all classes and schedules with interference fit type sockets.



YELLOW
2 Year Shelf Life
Meets ASTM D-2846 & F-493



FlowGuard Gold®

Medium bodied, fast setting, CPVC cement for copper tube size pipe and fittings with interference fit through 2" diameter. May be used on FlowGuard® CPVC Systems through 8" diameter. Approved by Noveon® for FlowGuard Gold® Systems.

ONE STEP CEMENT (Can be used without primer if local code permits.)

Flowguard®, Flowguard Gold® and Noveon® are registered trademarks of The Lubrizol Corporation **Low VOC**



YELLOW
2 Year Shelf Life
Meets ASTM D-2846 & F-493



All Weather FlowGuard Gold®

Medium to heavy bodied, fast setting, CPVC cement for copper tube size pipe and fittings with interference fit through 2" diameter. Specially formulated for wet or cold weather applications. Approved by Noveon® for FlowGuard Gold® Systems.

ONE STEP CEMENT (Can be used without primer if local code permits.)

Flowguard Gold® and Noveon® are registered trademarks of The Lubrizol Corporation **Low VOC**



ORANGE
2 Year Shelf Life
Meets ASTM D-2846 & F-493



713™

Regular bodied, fast setting, CPVC cement for copper tube size and Schedule 40 pipe and fittings with interference fit through 2" diameter. Approved for FlowGuard Gold® Systems.

Flowguard Gold® is a registered trademark of The Lubrizol Corporation



ORANGE/GRAY
2 Year Shelf Life
Meets ASTM D-2846 & F-493



714™

Heavy bodied, medium setting, CPVC cement for all classes and schedules with interference fit through 12" diameter. It has good gap filling properties and its medium set allows more working time in warm weather. Orange only is approved for Corzan® Piping Systems.

Corzan® is a registered trademark of The Lubrizol Corporation



GRAY
2 Year Shelf Life
Meets ASTM F-493



724™

Heavy bodied, medium setting, CPVC cement for all classes and schedules with interference fit through 12" diameter. Formulated for improved chemical resistance to caustics including hypochlorite solutions. **May be used on PVC industrial piping systems for chemical applications.** Approved for Corzan® Industrial Systems.

Corzan® is a registered trademark of The Lubrizol Corporation

Low VOC



GRAY
2 Year Shelf Life
Meets ASTM F-493

729™

Extra heavy bodied, slow setting, CPVC cement for all classes and schedules with interference fit of industrial piping and duct through 24" diameter. **Low VOC**

ABS SOLVENT CEMENTS

These products are approved for use on ABS pipe and fittings with interference fit type sockets.



MILKY/YELLOW
3 Year Shelf Life
Meets ASTM D-2235



771™

Medium bodied, fast setting, ABS cement for all classes and schedules with interference fit through 8" diameter (non-pressure applications only).



BLACK
3 Year Shelf Life
Meets ASTM D-2235



773™

Medium bodied, fast setting, ABS cement for all classes and schedules with interference fit through 8" diameter.

MULTI-PURPOSE AND TRANSITION SOLVENT CEMENTS

These products are used for joining dissimilar plastic pipe and fittings with interference fit type sockets.



CLEAR
3 Year Shelf Life
Meets performance requirements of ASTM D-2564, D-2235, F-493

790™

Medium bodied, fast setting, PVC to CPVC multi-purpose cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. May also be used on low-pressure ABS and Styrene systems.



CLEAR
3 Year Shelf Life

793™

Regular bodied, very fast setting, ABS to PVC transition cement for all classes and schedules with interference fit through 2 1/2" diameter (except Schedule 80).



GREEN
3 Year Shelf Life
Meets ASTM D-3138



794™

Medium bodied, fast setting, ABS to PVC transition cement for all classes and schedules with interference fit through 6" diameter (except Schedule 80).



WHITE
3 Year Shelf Life
Meets ASTM D-3138



796™

Regular bodied, fast setting, ABS to PVC transition cement for all classes and schedules with interference fit through 6" diameter (except Schedule 80). CSA certification for non-pressure ABS/PVC transition joints only.

**We offer Installation Seminars
- FREE of Charge.**

For more details contact IPS at (800)421-2677 or e-mail us at: info@ipscorp.com





Visit our web site: www.ipscorp.com

LOW VOC CEMENTS

All IPS Weld-On Low VOC (Volatile Organic Compounds) solvent cements and primers meet the requirements of all California air quality management district mandates. Low VOC products reduce emissions into the atmosphere and thereby contribute to cleaner air.

LOW VOC PVC REGULAR BODIED SOLVENT CEMENTS

These are free-flowing, fast curing products for small diameter PVC pipe and fittings in all classes and schedules (except Schedule 80) with interference fit type sockets.

<p>Clear</p> 		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2700™</p> <p>Regular bodied, fast setting, PVC cement for all classes and schedules with interference fit through 4" diameter (except Schedule 80). This product may also be used on PVC foam core pipe.</p> <p style="text-align: right;">Low VOC</p>
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LOW VOC PVC MEDIUM BODIED SOLVENT CEMENTS

These products are approved for use on PVC pipe and fittings in all classes and schedules with interference fit type sockets up to 6" diameter; Schedule 80 through 4" diameter.





<p>Clear</p> 		<p>CLEAR/GRAY 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2704™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p> <p style="text-align: right;">Low VOC</p>
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<p>Clear</p> 		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2705™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p> <p style="text-align: right;">Low VOC</p>
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<p>Blue</p> 		<p>BLUE 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2721™</p> <p>Medium bodied, fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. This product may also be used on PVC foam core pipe. Can be used without primer on non-pressure systems if local codes permit.</p> <p style="text-align: right;">Low VOC</p>
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LOW VOC PVC HEAVY BODIED SOLVENT CEMENTS


Our heavy bodied products exhibit excellent pipe-to-fitting gap filling properties. They can be used on larger pipe and fittings in all classes and schedules with interference fit type sockets through 12" diameter.

<p>Gray</p> 		<p>GRAY 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2711™</p> <p>Heavy bodied, medium setting, PVC cement for all classes and schedules with interference fit through 12" diameter, including Schedule 80. It has good gap filling properties and its medium set allows more working time in warm weather.</p> <p style="text-align: right;">Low VOC</p>
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<p>Clear</p> 		<p>CLEAR/GRAY 3 Year Shelf Life Meets ASTM D-2564</p>  	<p>2717™</p> <p>Heavy bodied, medium setting, PVC cement for all classes and schedules (including Schedule 80) with interference fit through 12" diameter, non-pressure applications through 18" diameter. It has good gap filling properties and its medium set allows more working time in warm weather.</p> <p style="text-align: right;">Low VOC</p>
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LOW VOC PVC EXTRA HEAVY BODIED SOLVENT CEMENTS


This product provides a thicker layer and has higher gap filling properties which makes it an excellent product for large diameter pipe and fittings with interference fit type sockets up to 30" diameter.

White		<p>WHITE 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2719™ Extra heavy bodied, slow setting, PVC cement for all classes and schedules with interference fit through 30" diameter, including Schedule 80. It is a good fabrication cement as it has excellent gap filling properties and because of its slow set, makes a good hot weather cement on large diameter pipe.</p>
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Low VOC

LOW VOC PVC SPECIALTY SOLVENT CEMENTS


These "Special Formula" products are approved for use on PVC pipe and fittings in all classes and schedules with interference fit type sockets.

Aqua Blue		<p>AQUA BLUE 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2725™ Wet 'R Dry Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. Specially formulated for rigid and flexible applications where conditions are wet and/or when quick pressurization is desired. Can be used without primer on non-pressure systems if local codes permit.</p>
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Low VOC

Blue		<p>BLUE 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2735™ Wet 'N Fast™ Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. For rigid and flexible applications, wet conditions and/or quick pressurization. It is specifically formulated to meet the needs of the plumbing industry. Can be used without primer on non-pressure systems if local codes permit.</p>
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Low VOC

Blue fades to Clear		<p>BLUE (fades to CLEAR) 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2737™ Turf 'N Ag™ Medium bodied, very fast setting, PVC cement for all classes and schedules with interference fit through 8" diameter, Schedule 80 through 4" diameter. It is an excellent product for PVC foam core, well casing, flexible and rigid applications. Works well in wet conditions. Can be used without primer on non-pressure systems if local codes permit.</p>
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Low VOC

Blue fades to Clear		<p>BLUE (fades to CLEAR) 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2747™ Pool 'R Spa Medium bodied, extremely fast setting, PVC cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. Developed for rigid & flexible applications, wet conditions and/or when quick pressurization is desired. Can be used without primer on non-pressure systems if local codes permit.</p>
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Low VOC

Clear		<p>CLEAR 3 Year Shelf Life Meets ASTM D-2564</p>	<p>2795™ Medium bodied, fast setting, PVC cement for all flex/flex and flex/rigid PVC pipe and fittings with interference fit through 6" diameter, Schedule 80 through 3" diameter. Excellent product for flex/rigid applications. It has an elastomer in the formulation which allows a more flexible joint.</p>
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Low VOC

Do you have a unique application?

Check out our Special Purpose Products on page 9.

For more details contact IPS at (800) 421-2677

Visit our web site: www.ipscorp.com









LOW VOC CPVC SOLVENT CEMENTS

These products are approved for use on CPVC pipe and fittings in all classes and schedules with interference fit type sockets.

<p>Yellow</p> 		<p>YELLOW 2 Year Shelf Life Meets ASTM D-2846 & F-493</p>   	<p>FlowGuard Gold®</p> <p>Medium bodied, fast setting, CPVC cement for copper tube size pipe and fittings with interference fit through 2" diameter. May be used on FlowGuard® CPVC systems through 8" diameter. Approved by Noveon® for FlowGuard Gold® Systems.</p> <p>ONE STEP CEMENT (Can be used without primer if local code permits.)</p> <p>Flowguard®, Flowguard Gold® and Noveon® are registered trademarks of The Lubrizol Corporation Low VOC</p>
<p>Yellow</p> 		<p>YELLOW 2 Year Shelf Life Meets ASTM D-2846 & F-493</p>   	<p>All Weather FlowGuard Gold®</p> <p>Medium to heavy bodied, fast setting, CPVC cement for copper tube size pipe and fittings with interference fit through 2" diameter. Specially formulated for wet or cold weather applications. Approved by Noveon® for FlowGuard Gold® Systems.</p> <p>ONE STEP CEMENT (Can be used without primer if local code permits.)</p> <p>Flowguard Gold® and Noveon® are registered trademarks of The Lubrizol Corporation Low VOC</p>
<p>Gray</p> 		<p>GRAY 2 Year Shelf Life Meets ASTM F-493</p>  	<p>724™</p> <p>Heavy bodied, medium setting, CPVC cement for all classes and schedules with interference fit through 12" diameter. Formulated for improved chemical resistance to caustics including hypochlorite solutions. May be used on PVC industrial piping systems for chemical applications. Approved for Corzan® Industrial Systems.</p> <p>Corzan® is a registered trademark of The Lubrizol Corporation Low VOC</p>
<p>Gray</p> 		<p>GRAY 2 Year Shelf Life Meets ASTM F-493</p>	<p>729™</p> <p>Extra heavy bodied, slow setting, CPVC cement for all classes and schedules with interference fit of industrial piping through 24" diameter.</p> <p>Low VOC</p>
<p>Orange</p>  <p>Gray</p> 		<p>ORANGE/GRAY 2 Year Shelf Life Meets ASTM D-2846 & F-493</p>   <p>Orange Only</p>	<p>2714™</p> <p>Heavy bodied, medium setting, CPVC cement for all classes and schedules with interference fit through 12" diameter. It has good gap filling properties and its medium set allows more working time in warm weather. Orange only is approved for Corzan® Piping Systems.</p> <p>Corzan® is a registered trademark of The Lubrizol Corporation Low VOC</p>

LOW VOC ABS SOLVENT CEMENTS

These products are approved for use on ABS pipe and fittings with interference fit type sockets through 8" diameter.

<p>Milky</p> 		<p>MILKY 3 Year Shelf Life Meets ASTM D-2235</p>  	<p>2771™</p> <p>Medium bodied, fast setting, ABS cement for all classes and schedules with interference fit through 8" diameter (non-pressure applications only).</p> <p>Low VOC</p>
<p>Black</p> 		<p>BLACK 3 Year Shelf Life Meets ASTM D-2235</p>  	<p>2773™</p> <p>Medium bodied, fast setting, ABS cement for all classes and schedules with interference fit through 8" diameter.</p> <p>Low VOC</p>


Do you have a technical question?


Contact IPS at (800) 421-2677 or send e-mail to: info@ipscorp.com

Visit our web site: www.ipscorp.com

LOW VOC MULTI-PURPOSE & TRANSITION SOLVENT CEMENTS

These products are used for joining dissimilar plastic pipe and fittings with interference fit type sockets.


Clear 




CLEAR
3 Year Shelf Life
Meets performance requirements of
ASTM D-2564, D-2235, F-493



2790™
Medium bodied, fast setting, PVC to CPVC multi-purpose cement for all classes and schedules with interference fit through 6" diameter, Schedule 80 through 4" diameter. May also be used on low-pressure ABS to Styrene systems.

Low VOC

Green 



GREEN
3 Year Shelf Life
Meets ASTM D-3138


 


2794™
Medium bodied, fast setting, ABS to PVC transition cement for all classes & schedules with interference fit through 6" diameter (except Schedule 80).


Low VOC

PRIMERS AND CLEANERS



These products are used for surface preparation of plastic pipe and fittings.

Purple 

Clear 





PURPLE/CLEAR
3 Year Shelf Life
Meets ASTM F-656


 
Purple Only

P-68™ Primer
For surface preparation of all PVC and CPVC pipe and fittings prior to cement application. If used properly, P-68 will soften pipe and fitting surfaces which is necessary for the proper solvent welding of the materials.



Low VOC

Purple 

Clear 





PURPLE/CLEAR
3 Year Shelf Life
Meets ASTM F-656

 
Purple Only


P-70™ Primer
P-70 is the most aggressive PVC and CPVC primer commercially available. Excellent product for cold weather applications. If used properly P-70 will soften pipe and fitting surfaces which is necessary for the proper solvent welding of the materials.

Low VOC

Aqua Blue 





AQUA BLUE
3 Year Shelf Life
Meets ASTM F-656




P-75 Wet 'R Dry™ PVC Primer
Primer specifically for use with 725 and 2725 Wet 'R Dry™ cement. Excellent primer for wet applications or when quick penetration of pipe and fitting surfaces is desired.

Low VOC

Purple 


Clear 




PURPLE/CLEAR
3 Year Shelf Life

PC-64™ Primer - Cleaner
For cleaning and surface preparation of PVC and CPVC pipe and fittings.

Low VOC

Clear 



CLEAR
Unlimited Shelf Life

C-65™ Cleaner
For PVC, CPVC, ABS and Styrene piping applications. This fast acting cleaner will remove surface dirt and grease from the pipe and fitting surface.

Low VOC

Do you have any installation questions?

Contact IPS at (800) 421-2677 or send e-mail to: info@ipscorp.com

SPECIAL PURPOSE PRODUCTS

<p>White</p> 		<p>WHITE 1 Year Shelf Life</p>	<p>810 (A & B) Kit Two-component, high strength, reactive adhesive for joining, fabricating and repairing PVC and CPVC pipe and fittings. Bonds PVC and CPVC to dissimilar materials, such as metals, concrete, clay and others. Low VOC</p>
<p>White</p> 		<p>WHITE 1 1/2 Year Shelf Life</p>	<p>811 Cartridge Two-component, high strength, reactive adhesive packaged in a dual cylinder cartridge. Used for joining, fabricating and repairing PVC and CPVC pipe and fittings. Bonds PVC and CPVC to dissimilar materials, such as metals, concrete, clay and others. For dispensing gun and mixing tip information refer to page 11 of this guide. Low VOC</p>
<p>Tan</p> 		<p>TAN 1 Year Shelf Life</p>	<p>845 and 845SK (Starter Kit) Two-component, high strength, reactive acrylic adhesive. For bonding and repairing most plastics (PVC, CPVC, ABS), metals, fiberglass, copper, concrete and other dissimilar materials. Withstands pressure and may be used in wet conditions. Not recommended for Ceramic, Teflon, Silicone, Polypropylene, Polyethylene and other Polyolefin's. Weld-On 845SK (Starter Kit) consists of (2) 845 Dual Cartridges, (1) Dispensing Gun, (6) Mixing Tips. For dispensing gun & mixing tip information refer to page 11 of this guide.</p>
<p>Clear</p> 		<p>CLEAR 2 Year Shelf Life</p>	<p>600™ Light bodied, fast setting, contact adhesive for Polyethylene, Polypropylene, PVC, ABS and Styrene non-pressure drainage systems through 4" diameter; HVAC Duct applications through 12" diameter interference fit. Low VOC</p>
<p>Milky</p> 		<p>MILKY 3 Year Shelf Life Meets ASTM D-2852</p>	<p>2763™ Styrene Rubber Cement Medium bodied, fast setting, MILKY, Styrene Rubber cement for drain, sewer or vacuum pipe systems through 6" diameter interference fit. Low VOC</p>






















Look at our Special Applicators and Accessories on page 11.

For more details contact IPS at (800) 421-2677
Visit our web site: www.ipscorp.com



811 Dispensing Gun

SEALANTS, COMPOUNDS & LUBRICANTS

<p>Beige</p> 		<p>BEIGE</p> 	<p>All Seal</p> <p>A beige grit-free, non-hardening, heavy duty pipe joint compound with a unique blend of non-toxic oils: for sealing and lubricating all metal and most plastic threaded piping systems carrying natural and LP gases, gasoline, kerosene, oils, caustics, solvents, acids, water, food, steam and air. Not for oxygen, fluorine or liquid sodium systems.</p>
<p>Blue</p> 		<p>BLUE</p> 	<p>Blue Seal</p> <p>A blue grit free, heavy duty pipe joint compound with a unique blend of non-toxic oils: for sealing and lubricating all metal and most plastic threaded piping systems carrying acids, air, gases, ammonia, brine, caustic alkalis, corrosives, freons, fuel, oils, solvents, sugar, steam and water. Not for flourine, alcohol, acetone, strong acids and alkalis or oxygen systems.</p>
<p>Gold</p> 		<p>GOLD</p> 	<p>Gold Seal</p> <p>A gold grit-free, heavy duty pipe joint compound with a unique blend of non-toxic oils; for sealing and lubricating all threaded CPVC plastic pipe and fittings carrying natural and LP gases, gasoline, kerosene, oils, caustics, solvents, acids, water, food, steam and air. Not for oxygen, fluorine or liquid sodium systems.</p>
<p>Gray</p> 		<p>GRAY</p> <p>N/A</p>	<p>Gray Seal</p> <p>A gray grit-free, smooth pipe joint compound of vegetable and mineral oils, prime and extender pigments, plus an anti-oxidant; for sealing and lubricating all metal (not for plastic) threaded piping systems carrying air, water, steam, natural gases, ammonia, brine, dilute acids and alkalis. Not for oxygen systems.</p>
<p>White</p> 		<p>WHITE</p> 	<p>White Seal</p> <p>A white grit-free, extreme duty pipe joint compound with a special blend of homogenized Teflon® particles and non-toxic oils; for sealing and lubricating all metal and plastic threaded piping systems carrying acids, air, gases, ammonia, brine, caustic alkalis, corrosives, freons, fuel, oils, solvents, sugar, steam and water. Not for fluorine, molten metals or oxygen systems. Teflon® is a registered trademark of Dupont.</p>
<p>Milky</p> 		<p>MILKY</p> 	<p>Seal Lube</p> <p>Primes and lubricates slip-on or "O" Ring type joints with rubber or synthetic rubber gaskets.</p>
<p>Green</p> 		<p>GREEN</p> <p>N/A</p>	<p>505™ Key-Tite®</p> <p>For threaded, gasketed and flanged metal joints. Lead free. Not for use on ABS or CPVC pipe or fittings.</p> <p>Key-Tite® is a registered trademark of Joy Mfg. Co.</p>
			<p>Epoxy Putty Stick</p> <p>Quick hardening sealant/adhesive. Plugs, seals, patches or repairs almost any material except Polyethylene or Polypropylene. Excellent for underwater repairs. Non-toxic, safe for potable water lines. Hardens in 20 minutes; cures in 60 minutes.</p>
			<p>Pipe Stick Joint Compound</p> <p>No lead. Non-toxic. For metal or plastic pipe. Prevents rust and corrosion, allowing easier disassembly.</p>

APPLICATORS AND ACCESSORIES



3020

Roll-A-Weld 3" roller for pipe diameters from 3" through 6"; fits MT-653 empty quart can.



Empty Metal Cans

Available in gallon, quart, quart (paint style) and pint sizes.



6020

Roll-A-Weld 4" roller for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can.



Disposable Gloves

Protects hands against irritation from working with slow curing cements. Interchangeable for right or left hand.



7020

Jumbo Roll-A-Weld 7" roller for pipe diameters of 6" or larger; fits MT-648 gallon can and cements available in wide mouth cans.



Reusable Latex Gloves (Type Y-18)

Protects hands against irritation from working with slow curing cements. Long cuffs with textured grip surfaces.



4020

4" swab for pipe diameters of 6" or larger; fits MT-648 empty gallon can and cements available in wide mouth cans.



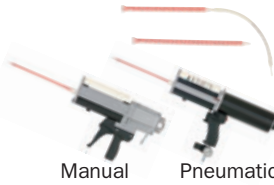
845 & 845SK Dispensing Gun & Mixing Tip

Manual dispensing gun and straight mixing tip for the application of 845 and 845SK dual cartridge, high strength adhesives. For 845 and 845SK dual cartridge, refer to page 9 of this guide.



5020

4" swab for pipe diameters from 3" through 8"; fits standard quart can as well as MT-651 empty quart can.



811 Dispensing Gun & Mixing Tips

Manual or pneumatic dispensing gun for the application of our 811 dual cartridge high strength adhesive. Flexible and straight mixing tips available. For 811 dual cartridge, refer to page 9 of this guide.



Can-Mate Daubers

Adjustable plastic applicator with telescoping stem to fit all cans (except 1/4 pint). Available in 1/2", 3/4" and 1 1/2" dauber sizes.



Can-Tote Cement & Primer Carrier

For carrying quart and pint cans.



Cap Daubers

DP daubers fit 1/2 pint & pint cans; DQ daubers fit quart cans. Available in 1/2", 3/4", and 1 1/2" dauber sizes.



Can-Mate® Carrier Kit

Kit includes plastic carrier arm and two Can-Mate® CM-150 adjustable shaft 1 1/2" diameter daubers. Job site convenience for carrying 1/2 pint, pint or quart cans of cement and primer.



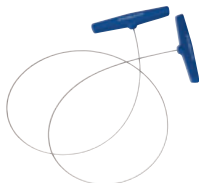
Brushes

PB-1: Plastic Handle Brush; fits standard pint and quart cans.
CM BCP Can-Mate®: Adjustable Plastic Handle Natural Bristle Brush; fits standard pint and quart cans.



GLUEBUSTER Professional Hand Cleaner

An advanced, liquid hand cleaner for removing solvent cements (PVC, CPVC, ABS), primers and sealants from hands. Also removes dirt, oil, grease, roof mastics (tar) and much more.



CST-36 Cable Saw

36" cable saw with T-Handle for cutting plastic pipe through 8" diameters.



Professional Hand Cleaner Wipes

An advanced, strong hand cleaner wipe formulated for removing solvent cements (PVC, CPVC, ABS), primers, adhesives and sealants from hands, tools and equipment. Also removes dirt, oil, grease, roof mastics (tar) & much more.

APPLICATORS AND ACCESSORIES *(continued...)*



Easy-Pour Spout

Makes pouring solvent cements and primers easy and with less mess. Fits pint, quart and standard gallon size metal cans.



Power Beveling Machine

For beveling the ends of larger diameter plastic pipe (PVC, CPVC, ABS) for solvent cementing. Nominal pipe sizes 4" - 24" diameter.



DEB-2 Deburring Tool

For PVC, CPVC, ABS, PE & PB pipe from 1/2" through 2" IPS.



Mounted Power Beveling Tool

For beveling the ends of small diameter plastic pipe (PVC, CPVC, ABS) for solvent cementing. Nominal pipe sizes 1/2" CTS - 3" IPS.



Pipe and Fitting Pullers

For installation of large diameter plastic pipe and fittings (PVC, CPVC, ABS). Available for pipe and fittings sizes 4" - 12" diameter and 14" - 20" diameter. It is lightweight, durable and can easily be operated by one person.

INSTALLATION LITERATURE/DVD/CD/SELECTION GUIDE



Product Catalog

Includes all information on Weld-On products.



MSDS Book

Includes individual Material Safety Data Sheets for all Weld-On products.



English or Spanish DVD/CD

Covers the proper techniques for joining plastic pipe and fittings.



Hot / Cold Weather Bulletins

Tips for hot or cold weather installation.



English or Spanish Cartoon Book

Proper installation techniques in a cartoon format.



Helpful Hints Bulletin

Tips for making proper plastic pipe and fitting joints.



English or Spanish Installation Guide

Joining techniques, set and cure times, large diameter installation, etc.



English or Spanish Selection Guide

Assists you in selecting the correct solvent cement, primer and applicator for your application.

INSTALLATION SEMINARS

Besides literature and videos, we also have available hands-on Installation Seminars. For more information, please contact your local Weld-On Distributor or IPS Corporation.



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Web Site: www.ipscorp.com

Warehouse Only
 600 Ellis Road, Durham, NC 27703 U.S.A.

Average Initial Set Schedule For WELD-ON PVC / CPVC Solvent Cements**

Temperature Range	Pipe Sizes 1/2" to 1 1/4"	Pipe Sizes 1 1/2" to 2"	Pipe Sizes 2 1/2" to 8"	Pipe Sizes 10" to 15"	Pipe Sizes 15"+
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

Note - Initial set schedule is the necessary time to allow before the joint can be carefully handled. In damp or humid weather allow 50% more set time.

Average Joint Cure Schedule For WELD-ON PVC / CPVC Solvent Cements**

Relative Humidity 60% or Less	Cure Time Pipe Sizes 1/2" to 1 1/4"		Cure Time Pipe Sizes 1 1/2" to 2"		Cure Time Pipe Sizes 2 1/2" to 8"		Cure Time Pipe Sizes 10" to 15"	Cure Time Pipe Sizes 15"+
	up to 160 psi	above 160 to 370 psi	up to 160 psi	above 160 to 315 psi	up to 160 psi	above 160 to 315 psi	up to 100 psi	up to 100 psi
Temperature range during assembly and cure periods								
60°-100°F	15 min	6 hrs	30 min	12 hrs	1 1/2 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 hour	96 hrs	72 hrs	8 days	8 days	14 days

Note - Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.
 **These figures are estimates based on our laboratory tests; extended set and cure times are required for chemical applications.
 Due to the many variables in the field, these figures should be used as a general guide only.

Average Number of Joints/Qt. of WELD-ON Cement*

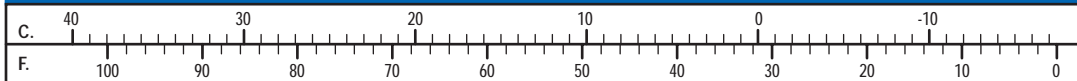
Pipe Diameter	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

Note - For Primer: Double the number of joints shown for cement. *These figures are estimates based on our laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only. Note - 1 Joint = 1 Socket

Nominal Pipe Size Inches to Millimeters Conversion Chart

Nominal Pipe Size	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"	6"	8"	10"	12"	14"	24"	30"
in.																
mm.	15	20	25	32	40	50	65	80	100	150	200	250	300	350	600	750

Fahrenheit to Celsius Conversion Chart



WARNING - IPS Weld-On products must never be used in PVC & CPVC systems using or being tested by compressed air or gases.

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