



ARROW ADHESIVES ORDER TODAY: P 770.448.9058 F 770.449.1361

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	4 minutes	10 minutes	40 minutes	2 hours	4 hours
40°- 60° F	10 minutes	15 minutes	3 hours	8 hours	16 hours
0°- 40° F	15 minutes	25 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**

Joint/Cure Schedule*

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
60°- 100° F	1 hr.	6 hrs.	2 hrs.	12 hrs.	8 hrs.	24 hrs.	48 hrs.	72 hrs.
40°- 60° F	2 hrs.	12 hrs.	4 hrs.	24 hrs.	16 hrs.	48 hrs.	96 hrs.	8 days
0°- 40° F	8 hrs.	48 hrs.	16 hrs.	96 hrs.	4 days	12 days	10 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.



ARROW ADHESIVES COMPANY

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Quality Solvent Cements
Since 1964

PVC, CPVC, ABS Cements
Primers & Cleaners
Sealants & Lubricants



www.arrowadhesives.com



Company History

Arrow Adhesives Company was founded in 1964 by Carroll Voss. Mr. Voss, with a chemical engineering degree, realized the probable future of solvent cements for joining plastic pipe. Since then, **ARROW** has continued to specialize in the manufacturing of quality solvent cements for the plastic pipe industry. Our manufacturing plant was built specifically for the production of such cements and our chemical laboratory is equipped to ensure the high quality of all of our products.

The employees of **ARROW** are both qualified and experienced in all processes and remain dedicated to providing exceptional service to our customers. **ARROW** continues to be an ambassador for the plastic pipe cement industry, involving themselves in the development of industry and product standards by serving on ASTM committees.

Our premium products are quality tested and manufactured to exceed industry standards and are offered under the **ARROW** brand as well as through private-label brands. Quality has always been an attitude we apply to all areas of our business. Our brands, service, and people, make the difference for you, our customer.

Thanks for choosing **ARROW!**



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Selecting the right Solvent Cement

Contractors have learned that solvent cement is a relatively minor part of total piping job cost but is absolutely critical to job performance. Cutting corners on the quality of solvent cements can be a costly error. All Arrow cements are formulated for maximum performance and cost effectiveness. Each meets a particular industry need and is produced under the highest standards of quality control throughout the entire manufacturing process. Use the chart below to determine which Arrow products are right for your application.

Thanks for choosing Arrow, you can count on Arrow products to perform!



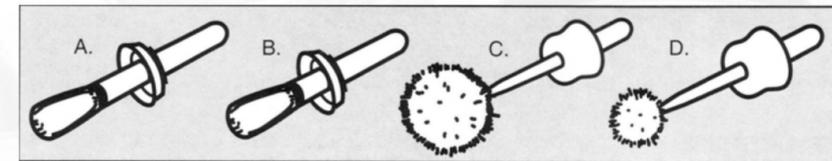
PVC



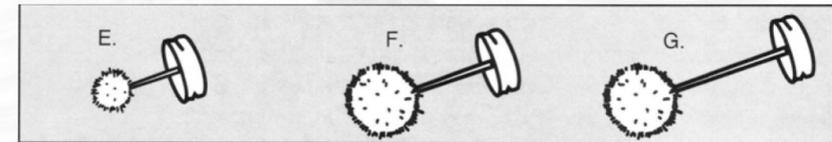
PRIMERS/
CLEANERS

PRODUCTS	1104HB	901
FOR USE ON	PVC	PVC CPVC, ABS
COLOR	CLEAR, GRAY, WHITE	CLEAR
BODY	HEAVY	WATER THIN
SET TIME	MEDIUM	
MAXIMUM PIPE DIAMETER	12"	ALL
TYPES, SCHEDULES & CLASSES	ALL RIGID SCH.40 & 80	ALL PVC, CPVC & ABS
ASTM SPEC.	D-2564	
APPLICATION	PW/DWV/SW	ALL
INDUSTRY LISTINGS	NSF, U.P. Code	
COMMENTS	Heavy bodied, medium setting, very high strength industrial grade PVC cement.	Removes dirt, oil, grease and other foreign substances from pipe and fitting surface.

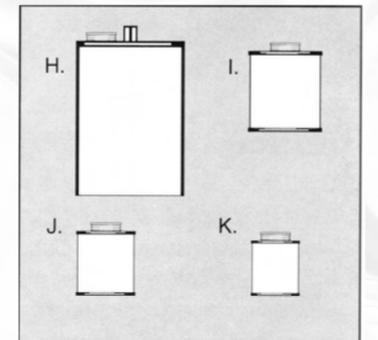
Applicators and Accessories



- A. **Brush Cap** (1" D-BC) fits standard pint & quart cans.
- B. **Brush Cap** available to fit 1/4 pt., 1/2 pt., pt. & qt. cans.
- C. **Adjustable 1-3/4"** (large Ball) **Dauber** for up to 3" pipe; fits 1/2 pt., pt. & qt. cans
- D. **Adjustable 3/4"** (small Ball) **Dauber** for up to 1/2" pipe; fits 1/2 pt., pt. & qt. cans



- E. **3/4"** (Small Ball) **Dauber** fits 1/2 pt. cans.
- F. **1-1/2"** (Large Ball) **Dauber** fits pint cans.
- G. **1-1/2"** (Large Ball) **Dauber** fits quart cans.



- H. **Gallon** (Gal. can) 1 3/4" neck.
- I. **Quart** (Qt. can) 1 3/4" neck.
- J. **Pint** (Pt. can) 1 3/4" neck.
- K. **1/2 Pint** (1/2 Pt. can) 1 3/4" neck.

* **Flowguard Gold**® registered trademark of the Lubrizol Corporation. **NOTE:** Low-VOC (LV) products are also available.