






Professional Solvent Cements

Since 1964



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



MADE IN U.S.A.

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!



PRODUCTS	1104RB	1104MB	1104HB	1122	1128	1130	1132	1106	1106HB	1148	1604	1108	911	921	901	A-10	A-15
FOR USE ON	PVC	PVC	PVC	PVC-FLEX	PVC	PVC	PVC	CPVC	CPVC	CPVC	ABS	PVC, CPVC, ABS	PVC, CPVC	PVC, CPVC	PVC, CPVC, ABS	THREADED JOINTS	GASKETED JOINTS
COLOR	CLEAR	CLEAR, GRAY, WHITE	CLEAR, GRAY, WHITE	CLEAR	CLEAR	GRAY, WHITE	BLUE	ORANGE	ORANGE, GRAY	YELLOW	BLACK	CLEAR	CLEAR, PURPLE	CLEAR, PURPLE	CLEAR	WHITE	AMBER
BODY	REGULAR	MEDIUM	HEAVY	MEDIUM	MEDIUM	EXTRA HEAVY	MEDIUM	REGULAR	HEAVY	MEDIUM	MEDIUM	MEDIUM	WATER THIN	WATER THIN	WATER THIN	HEAVY	HEAVY
SET TIME	FAST	FAST	MEDIUM	VERY FAST SET	FAST	SLOW	EXTREMELY FAST	FAST	MEDIUM	FAST	FAST	FAST					
MAXIMUM PIPE DIAMETER	4" (Sch. 40)	4" (Sch. 80) 6" (Sch. 40)	12" (Sch. 40, 80)	3" (Sch. 80) 6" (Sch. 40)	4" (Sch. 80) 6" (Sch. 40)	30" (Sch. 40, 80)	4" (Sch. 80) 6" (Sch. 40)	4" (Sch. 40)	12" (Sch. 40, 80)	2" (CTS)	8"	4" (Sch. 80) 6" (Sch. 40)	ALL	ALL	ALL	ALL	ALL
ASTM SPEC.	D-2564	D-2564	D-2564	D-2564	D-2564	D-2564	D-2564	D-2846 F-493	D-2846 F-493	D-2846 F-493	D-2235	D-2564 D-2235, F-493	F-656	F-656			
INDUSTRY LISTINGS	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code	NSF, U.P.Code		NSF, U.P.Code			NSF	NSF
COMMENTS	<ul style="list-style-type: none"> Regular body Fast setting High strength PVC cement 	<ul style="list-style-type: none"> Medium body Fast setting High strength PVC cement 	<ul style="list-style-type: none"> Heavy body Medium setting High strength industrial grade PVC cement 	<ul style="list-style-type: none"> Medium body Very fast setting Premium formula for joining flex/flex and flex/rigid PVC 	<ul style="list-style-type: none"> Medium body Fast setting Premium formula for use in temps -15°F to 110°F 	<ul style="list-style-type: none"> Extra Heavy body Slow setting High Strength industrial grade PVC cement Excellent gap filling properties and good fabrication cement 	<ul style="list-style-type: none"> Medium body Extremely fast setting High strength PVC cement for joining rigid or flexible PVC in wet conditions where quick pressurization is desired 	<ul style="list-style-type: none"> Regular body Fast setting CPVC cement for copper tube size pipe and fitting thru 4" 	<ul style="list-style-type: none"> Heavy body Medium setting High strength industrial grade CPVC cement 	<ul style="list-style-type: none"> Medium body Fast setting High strength CPVC cement for CTS pipe and fittings thru 2" For use with Flowguard Gold® systems. One step cement (where permitted) 	<ul style="list-style-type: none"> Medium body Fast setting High strength ABS cement 	<ul style="list-style-type: none"> Medium body Fast setting High strength PVC/CPVC/ABS cement 	<ul style="list-style-type: none"> Aggressively softens and prepares the pipe and fittings for solvent cement 	<ul style="list-style-type: none"> Removes foreign material Cleans and prepares surfaces to be joined 	<ul style="list-style-type: none"> Removes dirt, oil, grease and other foreign substances from pipe and fitting surface 	<ul style="list-style-type: none"> A soft-set, non-hardening, smooth pipe joint compound, for use on metal and plastic threaded connections Pressure range for gases up to 3,000 PSI, liquids up to 10,000 PSI 	<ul style="list-style-type: none"> A water soluble lubricant for joining gasketed pipe with rubber, synthetic rubber or plastic seals

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Average Initial Set Schedule for Arrow PVC / CPVC Solvent Cements**					
Temperature Range	Pipe Size 1/2" to 1 1/4" 20mm to 40mm	Pipe Size 1 1/2" to 2" 50mm to 63mm	Pipe Size 2 1/2" to 8" 75mm to 200mm	Pipe Size 10" to 15" 250mm to 380mm	Pipe Size 15" + 380mm +
60°-100°F/16°-38°C	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40°-60°F/5°-16°C	5 minutes	10 minutes	2 hours	8 hours	16 hours
0°-40°F/-18°-5°C	10 minutes	15 minutes	12 hours	24 hours	48 hours

Note - The handling/set schedule is the time required before handling joint.
In case of humid/damp weather or loose fitting joints, allow +50% additional cure time.

Average Joint Cure Schedule for Arrow PVC / CPVC Solvent Cements**								
Relative Humidity 60% or less	Pipe Size 1/2" to 1 1/4" 20mm to 40mm		Pipe Size 1 1/2" to 2" 50mm to 63mm		Pipe Size 2 1/2" to 8" 75mm to 200mm		Pipe Size 10" to 15" 250mm to 380mm	Pipe Size 15" + 380mm +
Temperature range during assembly and cure periods.	up to 160 psi / 11 Bar	160 to 370 psi / 11 to 26 Bar	up to 160 psi / 11 Bar	160 to 315 psi / 11 to 22 Bar	up to 160 psi / 11 Bar	160 to 315 psi / 11 to 22 Bar	up to 100 psi / 7 Bar	up to 100 psi / 7 Bar
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1 1/2 hrs	24 hrs	48 hours	72 hours
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hours	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

Note - The joint cure schedule shows the required time to allow before pressurizing a system.
In case of humid/damp weather or loose fitting joints, allow +50% additional cure time.

**These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

Pipe Size Equivalent Chart - Inches / Millimeters																	
in.	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm.	20	25	32	40	50	63	75	90	110	160	200	250	315	355	450	600	800

Average Number of Joints / Quart (1Kg) of Arrow Cement*													
Pipe Diameters	1/2" 20mm	3/4" 25mm	1" 32mm	1 1/2" 50mm	2" 63mm	3" 90mm	4" 110mm	6" 160mm	8" 200mm	10" 250mm	12" 315mm	15" 380mm	18" 450mm
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

Note - For Cleaner or 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.**

Thank you for your interest in ARROW products.

At Arrow, our founders happen to be solvent cement pioneers with over 100 years experience. Our products are formulated based on this experience and designed with each specific application in mind to perform in the most challenging conditions. Use Arrow products and see for yourself how we are still leading the way.



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