



Schedule 40 
 Schedule 80 

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 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.

PVC															CPVC				ABS		Multi-Purpose		Primers			Nominal Pipe Size in. mm						
Regular Body			Medium Body			Heavy Body		Extra Heavy Body		Specialty Cements																						
Nominal Pipe Size in. mm	700 2700	702	710	704† 2704†	705† 2705†	721† 2721†	711 2711	717§ 2717§	719 2719	725† 2725†	727†	735† 2735†	737† 2737†	747† 2747†	795 2795	713	714 2714	724◇	729	FlowGuard Gold††	Alli†† Weather Flow Guard Gold	771 2771	773 2773	790* 2790*	793**	794** 2794**	796**	P68	P70	P75	Nominal Pipe Size in. mm	
1/2	15																														1/2	15
3/4	20																														3/4	20
1	25																														1	25
1 1/4	32																														1 1/4	32
1 1/2	40																														1 1/2	40
2	50																														2	50
2 1/2	65																														2 1/2	65
3	80																														3	80
4	100																														4	100
6	150																														6	150
8	200																														8	200
10	250																														10	250
12	300																														12	300
14	350																														14	350
24	600																														24	600
30	750																														30	750

† Can be used without a primer with fittings having an interference fit (unless required by local code).
 § Non-pressure only up to 18"
 ◇ For CPVC and PVC Chemical Piping Systems
 * PVC, CPVC, ABS and Styrene
 ** ABS to PVC
 *** Copper Tube Size
 †† FlowGuard Gold® is a registered trademark of The Lubrizol Corporation

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.
 ** These figures are estimates based on our laboratory tests using water; extended set 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 Per Quart of WELD•ON Cement and Primer*

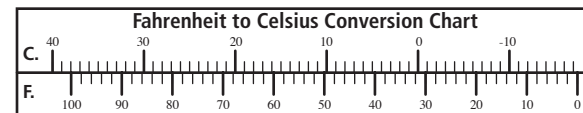
Pipe Diameter	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

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

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"+
Temperature range during assembly and cure periods	up to 160 psi	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
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 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.



WARNING - IPS WELD•ON products must never be used in a PVC or CPVC system using or being tested by compressed air or gases.

Joint Compounds and Lubricants

All Seal - Beige, grit-free, heavy duty, non-hardening pipe joint compound for sealing metal and most plastic threaded piping systems.

Blue Seal - Blue, grit-free, heavy duty pipe joint compound for sealing all metal and most plastic threaded piping systems.

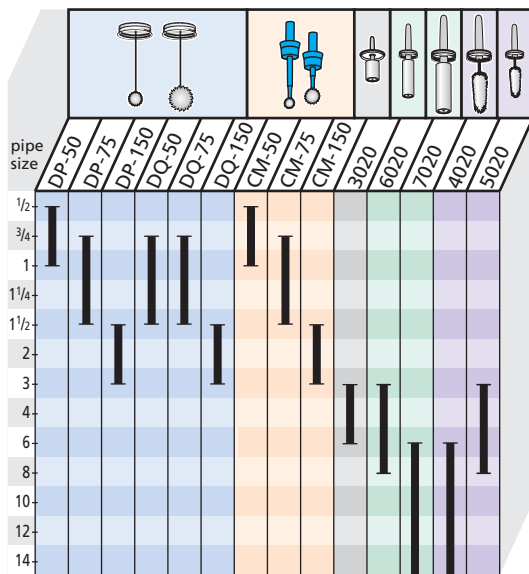
Gold Seal - Gold, grit-free, heavy duty pipe joint compound for sealing all threaded CPVC and other plastic piping systems.

Gray Seal - Gray, grit-free, pipe joint compound for sealing all metal threaded piping systems (not for plastic piping systems).

White Seal - White, extreme duty, Teflon®* compound for sealing all metal and plastic threaded systems.

*Teflon® is a registered trademark of Dupont.

Applicator Guide



- 3020 3" roller fits MT-653
- 6020 4" roller fits MT-651
- 7020 7" roller fits MT-648
- 4020 4" swab fits MT-648
- 5020 4" swab fits MT-651
- CM & DP fits 1/2 pint & pint
- DQ fits QT cans

For additional information on WELD•ON applicators, accessories or products, please see our Product Guide, authorized distributor or contact IPS Corporation.

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WELD•ON

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Solvent Cement, Sealant & Applicator Selection Guide

