



RECTORSEAL

# PLUMBING

SOLUTIONS solvent cement

rectorseal.com

Leading the industry in quality, warranty and support.

**RS** TO THE **Rescue**



A CSW Industrials Company

SOLVENT CEMENTS

# Single source for distributors,



RectorSeal solvent cements and primers have been delivering strong, consistent pipe installation for over 50 years.



# plumbers, electricians and irrigation specialists.



SOLVENT CEMENTS • PRIMERS • CLEANERS

**RectorSeal manufactures solvent cements in the widest variety of sizes and formulas for welding PVC, CPVC, and ABS pipe installation.**

**Solvent Cement Body.** Solvent cements are available in three body thicknesses - Regular, Medium, Heavy. To some degree the body of the solvent is chosen by the preference of the contractor. However, body thicknesses can affect setting times. For smaller 2"-3" piping use regular body. Heavy body cements provide a slower set that allows the contractor more time to get adequate cement around the pipe to avoid flash off.

**Solvent Cement color.** Colors range from clear for welding PVC to gray for electrical conduit and black for ABS application. Gold and orange color designate CPVC pipe. Blue quickly indicates irrigation type use.

**Primers.** RectorSeal primers properly etch the pipe surfaces to ensure a strong and consistent weld every time. Primers are offered in both purple as well as clear, satisfying applicable plumbing code.

Complete application usage chart can be found on pages 12-13.



Solvent cements, primers and cleaners are available in multiple sizes.

Action videos and full details @ [rectorseal.com/solventcements](http://rectorseal.com/solventcements)



## RECTORSEAL LOW-VOC SOLVENT CEMENTS

Apply all solvent cements in conjunction with RectorSeal primer

### Pete™ 602L

Code	Description	Qty
55922	¼ pt.	24
55924	½ pt.	24
55926	1 pt.	12
55928	1 qt.	12
55916	1 gal. wide mouth	4



pwddwsw

#### FEATURES

- LEED compliant
- NSF approved for potable water
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC

### ○ Clear - medium body PVC solvent cement

**APPLICATION** • 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 up to 6" for Schedule 40; 4" for Schedule 80

**RECOMMENDED FOR** • Potable water  
• Pressure pipe • Conduit • Sewers  
• DWV systems



## RECTORSEAL LOW-VOC SOLVENT CEMENTS

Continued

### Gene™ 404L

○ Clear - regular body PVC solvent cement

Code	Description	Qty
55901	¼ pt.	24
55902	½ pt.	24
55904	1 pt.	12
55906	1 qt.	12
55908	1 gal.	4



pvc-dwv-sw

#### FEATURES

- Fast setting formula
- LEED compliant
- NSF approved for potable water
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC

**APPLICATION** • Polyvinyl chloride (PVC) solvent cement used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784

- Schedule 40 up to 2" pressure; up to 4" non-pressure pipe (DWV) • ABS to PVC non-pressured transition joints

**RECOMMENDED FOR** • Potable water

- Pressure pipe • Conduit
- Sewers • DWV systems



### Gold™ 844L

○ Clear - heavy body PVC solvent cement

Code	Description	Qty
55951	½ pt.	24
55952	1 pt.	12
55954	1 qt.	12
55955	1 gal. wide mouth	4



pvc-dwv-sw

#### FEATURES

- Excellent gap filling
- LEED compliant
- NSF approved for potable water
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC

**APPLICATION** • 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" Schedule 40 and Schedule 80

**RECOMMENDED FOR**

- Potable water • Pressure pipe
- Conduit • Sewers • DWV systems





## RECTORSEAL LOW-VOC SOLVENT CEMENTS

Continued

### Homer™ 828L

Code	Description	Qty
55961	1 pt.	12
55963	1 qt.	12
55964	1 gal. wide mouth	4



pw-dw-sw

#### FEATURES

- Superior bonding strength
- LEED compliant
- NSF approved for potable water
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC

### ○ Gray - heavy body PVC solvent cement

**APPLICATION** • 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" Schedule 40 and Schedule 80 • Remains stable from 40°F to 110°F

#### RECOMMENDED FOR

- Potable water • Pressure pipe
- Conduit • Sewers • DWV systems



### Arctic™ 616L

Code	Description	Qty
55919	1 pt.	12
55948	1 qt.	12
55953	1 gal. wide mouth	4



pw-dw-sw

#### FEATURES

- Formulated for use in cold weather
- LEED compliant
- NSF approved for potable water
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC
- State of Wisconsin Approved

### ○ Clear - medium body PVC solvent cement

**APPLICATION** • Premium polyvinyl chloride (PVC) solvent cement used for joining PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784 • Pipe up to 6" Schedule 40; Up to 4" Schedule 80 • Remains stable from 0°F to 120°F

#### RECOMMENDED FOR

- Potable water • Pressure pipe
- Conduit • Sewers
- DWV systems



## RECTORSEAL LOW-VOC SOLVENT CEMENTS

Continued

### Charlie™ 412L

Orange - regular body CPVC solvent cement

Code	Description	Qty
55956	¼ pt.	24
55957	½ pt.	24



pw-dww-sw

#### FEATURES

- For CPVC pipe
- LEED compliant
- 3 year shelf life
- Meets ASTM F493 specs
- Low-VOC
- NSF approved for potable water

**APPLICATION** • Chlorinated polyvinyl chloride (CPVC) solvent cement for joining CPVC pipe, tubing and socket-type fittings which meet Class 23497 as defined in ASTM specification D1784 • For use on CPVC pipe up to 2" Schedule 40

#### RECOMMENDED FOR

- Potable water • Pressure pipe
- DWV systems



### Heavy Duty 811L

Orange - heavy body CPVC solvent cement

Code	Description	Qty
55967	1 pt.	12
55968	1 qt.	12



pw-dww-sw

#### FEATURES

- For CPVC pipe
- LEED compliant
- 3 year shelf life
- Meets ASTM F493 specs
- Low-VOC
- NSF approved for potable water

**APPLICATION** • Chlorinated polyvinyl chloride (CPVC) solvent cement for joining CPVC pipe, tubing and socket-type fittings which meet Class 23497 as defined in ASTM specification D1784 • For use on CPVC pipe up to 12" Schedule 40 and Schedule 80

#### RECOMMENDED FOR

- Potable water • Pressure pipe
- DWV systems



### Mike™ 425L

Amber - medium body multi purpose solvent cement

Code	Description	Qty
55969	¼ pt.	24
55970	½ pt.	24
55973	1 pt.	12
55974	1 qt.	12

#### FEATURES

- Multi purpose
- LEED compliant
- 3 year shelf life
- Low-VOC

**APPLICATION** • For use on PVC, CPVC and ABS plastic pipe and socket-type fittings • Can be used on transitions joints to join PVC to CPVC and PVC to ABS • Pipe up to 6" Schedule 40

#### RECOMMENDED FOR

- Water • Pressure pipe
- DWV systems



## LOW-VOC SPECIALTY SOLVENT CEMENTS

### Dura-Gold™ 627L

Code	Description	Qty
55992	½ pt.	24
55998	1 pt.	12



pw-dw-sw

#### FEATURES

- One-step, no primer needed\*
- LEED compliant
- 3 year shelf life
- Meets ASTM F493 specs
- Low-VOC
- NSF approved for potable water

\*when code allows

### Gold - Medium body CPVC solvent cement

**APPLICATION** • Chlorinated polyvinyl chloride (CPVC) solvent cement for joining FlowGuard Gold®\* CPVC and fittings • All schedules and classes up to 2" Schedule 40

#### RECOMMENDED FOR

- All CPVC pipe • Potable water Pressure pipe • DWV systems

\*FlowGuard Gold is a licensed trademark of The Lubrizol Corporation



### Hot™ 203L

Code	Description	Qty
55988	¼ pt.	24
55989	½ pt.	24
55990	1 pt.	12
55993	1 qt.	12
55994	1 gal. wide mouth	4



pw-dw-sw

#### FEATURES

- Very fast drying
- Excellent in cold weather
- LEED compliant
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC
- NSF approved for potable water

### Blue - medium body PVC solvent cement

**APPLICATION** • Polyvinyl chloride (PVC) solvent cement joins both rigid and flexible PVC pipe and socket-type fittings which meet Class 12454 as defined in ASTM specification D1784 • For all rigid PVC classes up to 6" Schedule 40 and 4" Schedule 80

#### RECOMMENDED FOR

- Irrigation
- Potable water
- Pressure pipe • Conduit
- Sewers • DWV systems
- ENT



### PVC Electrical Conduit 633L

Code	Description	Qty
55980	½ pt. - clear	24
55983	1 pt. - clear	12
55985	1 qt. - clear	12
55996	1 qt. - gray	12
55979	1 gal. wide mouth clear	4



pw-dw-sw

#### FEATURES

- Conduit types I & II
- LEED compliant
- 3 year shelf life
- Meets ASTM D2564
- Low-VOC
- NSF approved for potable water

### Clear/Gray - medium body solvent cement

**APPLICATION** • Clear or gray to match conduit color • Thick formula to reduce runoff • Up to 6" Schedule 40 and Schedule 80

#### RECOMMENDED FOR

- PVC conduit







## RECTORSEAL PRIMERS & CLEANERS

### Jim™ PR-1L

○ Purple - Low-VOC hi-etch primer



Code	Description	Qty
55910	¼ pt.	24
55912	½ pt.	24
55914	1 pt.	12
55918	1 qt.	12
55920	1 gal.	4

**APPLICATION** • 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



**FEATURES**

- Fast acting
- Superior bonding
- LEED compliant
- 3 year shelf life
- Meets ASTM F656
- NSF approved for potable water
- Low-VOC



## RECTORSEAL PRIMERS & CLEANERS

### Clear PR-2L

Code	Description	Qty
55972	1 pt.	12
55981	1 qt.	12
55982	1 gal.	4



pw-dww-sw

#### FEATURES

- Fast acting
- Superior bonding
- LEED compliant
- 3 year shelf life
- Low-VOC
- Meets ASTM F656
- NSF approved for potable water

### ○ Clear - Low-VOC hi-etch primer

**APPLICATION** • 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



Also available in gallon can.

### Bill™ PR-3

Code	Description	Qty
55705	1 pt.	12
55707	1 qt.	12



pw-dww-sw

#### FEATURES

- PVC & CPVC systems
- Etches & penetrates
- 3 year shelf life
- Low-VOC
- LEED compliant
- Meets ASTM F656
- NSF approved for potable water

### ○ Clear - Low-VOC hi-etch primer

**APPLICATION** • Primer for use on all PVC and CPVC pipe, tubing and socket-type fittings to etch and penetrate the surface increasing body strength • Use with all sizes and classes in both Schedule 40 and Schedule 80

#### RECOMMENDED FOR

- Pressure pipe
- Conduit • DWV systems • Sewers
- Potable water • Irrigation



### Sam™ CL-3L

Code	Description	Qty
55929	¼ pt.	24
55930	½ pt.	24
55932	1 pt.	12
55934	1 qt.	12
55936	1 gal.	4

#### FEATURES

- Fast acting
- Safe for potable water
- 3 year shelf life
- Low-VOC

### ○ Clear - cleaner

**APPLICATION** • Clear cleaner for dissolving grease and dirt to prepare bonding surfaces for solvent cementing • Use 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



Also available in gallon can.

# Applicator

PVC solvent cement roller

Code	Description	Qty.
19073	Roller Applicator	4

**Quicker application**  
for larger diameter pipe sizes.  
Fits both wide mouth  
can and regular gallon cans.



Made in the U.S.A.

## SOLVENT CEMENT WELDING INSTRUCTIONS



1. Supplies needed to make weld: pipe fittings, primer, cleaner (if needed), solvent cement and deburring tool.

2. Before welding, dry fit the assembly, making sure the pipe and fittings are set snug and correctly positioned. Apply cleaner to both surfaces to be welded.

3. Apply primer to the outside of the male connection and to the inside of the female socket to etch the surfaces to be welded. For ABS pipe use a clear cleaner, not a primer.

4. Apply cement liberally over the primer on the male connection to the depth of the socket. Coat entire surface. Apply a thin coat of cement on the inside of the socket, being careful not to puddle cement, weakening the joint.

5. Once cement is applied, parts must be assembled quickly. If cement dries, recoat both surfaces before welding. Push pipe or fitting into socket with a quarter turn motion until you feel it bottom out. Hold the weld together for 30 seconds to prevent push out. Hold longer as needed for colder weather application.

6. Wipe off excess solvent to finish weld. Allow 15 minutes to set to cure. Both size of pipe and temperature will affect actual cure times.



## GENERAL SERVICE RECOMMENDATIONS

Product Name	SOLVENT CEMENTS	PVC							
		Gene 404L	Pete 602L	Arctic 616L	Hot 203L	Electrical Conduit 633L	Electrical Conduit 633L	Gold 844L	Homer 828L
Body	Regular	Medium					Heavy		
Color	Clear	Clear	Clear	Blue	Clear	Gray	Clear	Gray	
Low-VOC	✓	✓	✓	✓	✓	✓	✓	✓	
Max. Pipe Size Schedule 40	4 in	6 in	6 in	6 in	6 in	6 in	12 in	12 in	
Max. Pipe Size Schedule 80	-	4 in	4 in	4 in	6 in	6 in	12 in	12 in	
Max. Pipe Size Schedule 40 (pressure)	2 in	6 in	6 in	6 in	-	-	12 in	12 in	
Max. Pipe Size Schedule 80 (pressure)	-	1¼ in	1¼ in	1¼ in	-	-	12 in	12 in	
One Step Cement	-	-	-	-	-	-	-	-	
Potable Water	✓	✓	✓	✓	-	-	✓	✓	
Pressure Pipe	✓	✓	✓	✓	-	-	✓	✓	
Gas Lines	✓	✓	✓	✓	-	-	✓	✓	
Conduit	✓	✓	✓	✓	✓	✓	✓	✓	
Sewer Pipe	✓	✓	✓	✓	-	-	✓	✓	
DWV Systems	✓	✓	✓	✓	-	-	✓	✓	
Irrigation lines	-	-	-	✓	-	-	-	-	
Pool, Spa, Flexible hose	-	-	-	✓	-	-	-	-	
Industrial	-	✓	-	✓	-	-	✓	✓	
Max Service Temp	140°	140°	140°	140°	140°	140°	140°	140°	
Hot Water (180°)	-	-	-	-	-	-	-	-	
Recommended Application Temp	40°-120°F	40°-120°F	0°-120°F	40°-120°F	40°-120°F	40°-120°F	40°-120°F	40°-120°F	
Cure Time	Fast	Fast	Fast	Very Fast	Fast	Fast	Medium	Medium	
LEED Compliant	✓	✓	✓	✓	✓	✓	✓	✓	
Product code - Qtr. Pint (24)	55901	55922	-	55988	-	-	-	-	
Product code - Half Pint (24)	55902	55924	-	55989	55980	-	55951	-	
Product code - Pint (12)	55904	55926	55919	55990	55983	-	55952	55961	
Product code - Quart (12)	55906	55928	55948	55993	55985	55996	55954	55963	
Product code - Gallon (4)	55908	55916	55953	55994	55979	-	55955	55964	
Shelf Life	3 year	3 year	3 year	3 year	3 year	3 year	3 year	3 year	

	CPVC			PVC/CPVC ABS
	Charlie 412L	Dura-Gold 627L	Heavy Duty 811L	Mike 425L
	Regular	Medium	Heavy	Medium
	Orange	Gold	Orange	Amber
	✓	✓	✓	✓
	2 in	2 in	12 in	6 in
	-	-	12 in	-
	2 in	2 in	12 in	6 in
	-	-	12 in	-
	-	✓	-	-
	✓	✓	✓	-
	✓	✓	✓	✓
	-	-	-	-
	-	-	-	✓
	✓	-	✓	-
	✓	✓	✓	✓
	-	-	-	-
	-	-	-	-
	-	✓	✓	-
	180°	180°	180°	-
	✓	✓	✓	✓
	40°-120°F	40°-120°F	40°-120°F	40°-120°F
	Fast	Fast	Medium	Fast
	✓	✓	✓	-
	55956	-	-	55969
	55957	55992	-	55970
	-	55998	55967	55973
	-	-	55968	55974
	-	-	-	-
	3 year	3 year	3 year	3 year

PRIMERS & CLEANERS	PVC CPVC	PVC CPVC	PVC CPVC	PVC/CPVC ABS
	Jim PR-1L	Clear PR-2L	Bill PR-3	Sam CL-3L
	Hi-Etch Primer			Cleaner
	Purple	Clear	Clear	Clear
	✓	✓	✓	✓
	All	All	All	All
	All	All	All	All
	All	All	All	All
	All	All	All	All
	-	-	-	-
✓	✓	-	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓	✓	
180°	180°	180°	-	
✓	✓	✓	✓	
-15°-120°F	-15°-120°F	-15°-120°F	-15°-120°F	
-	-	-	-	
✓	✓	✓	-	
55910	-	-	55929	
55912	-	-	55930	
55914	55972	55705	55932	
55918	55981	55707	55934	
55920	55982	-	55936	
3 year	3 year	3 year	3 year	



A CSW Industrials Company

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RectorSeal provides industry-leading digital and print support materials for its extensive chemical and mechanical solutions that include:

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