

Choosing the correct solvent cement is vital to the performance of your IPEX integrated piping system. We offer a complete range of IPEX brand cements, primers and applicators, designed to ensure the integrity of your application.

Cements & Primers



Solvent Cements

120



IPEX Solvent Cements

Choosing the correct cement is a vital link in a thermoplastic piping system. Although cement is one of the most critical components of a piping system, it is most often overlooked.

Cements are formulated to best meet specific needs – for example, general-purpose cement is thinner and less aggressive in bonding than heavy-duty industrial cement.

IPEX offers a wide range of high strength solvent cements for thermoplastic piping systems. Regular, medium, heavy or extra heavy cements are specially formulated for PVC pipe and fittings up to 900 mm (36") diameter for both pressure and non-pressure applications, CPVC through 300 mm (12") diameter and ABS through 200 mm (8") diameter.

IPEX offers a complete range of cements, primers and applicators so installers can choose the RIGHT ONE for their project and, following the basic steps, be assured of a good joint every time.

Call your nearest IPEX representative for assistance with this critical part of your plastic piping system. On-the-job training, videos and instruction booklets are all available to help ensure you achieve perfect results.

APPLICATIONS

- Industrial Piping Systems
- Plumbing Piping Systems
- Pressure & Non-pressure applications

STANDARDS



ASTM D2564	PVC Solvent Cements
ASTM D2846	CPVC Solvent Cements
ASTM D3138	Transition Cements
ASTM F493	CPVC Solvent Cements
ASTM F656	Primers

i DID YOU KNOW?

You can take IPEX's 'Solvent Cements Online Training' course, developed by leading experts in thermoplastic systems and offered through the IPEX Training Room. To register for this course go to www.ipexna.com.



SELECTION GUIDES

General Purpose Solvent Cement Products		
Product	IPEX Products / Material	Size Range
Xirtec 05	Xirtec PVC Sch 40/80 Pressure	up to 6" (Sch 40) up to 4" (Sch 80)
Xirtec 11	Xirtec PVC Sch 40/80 Pressure	up to 12"
Xirtec 17	Xirtec PVC Sch 40/80 Pressure	up to 12"
Xirtec 19	Xirtec PVC Sch 40/80 Pressure	14" to 30"
Xirtec 24	Xirtec CPVC Sch 40/80 Pressure	up to 12"
IPS 729	Xirtec CPVC Sch 40/80 Pressure	14" and larger
Xirtec 7	Primer for Xirtec PVC and CPVC	all sizes
IPEX 04	PVC Building Drain Sewer, Septic	3" to 6"
IPEX 25	PVC Wet/Dry Rigid PVC or Flexible	up to 6" (Sch 40) up to 4" (Sch 80)
IPEX 47	PVC Pool/Spa Rigid PVC or Flexible	up to 6" (Sch 40) up to 4" (Sch 80)
IPEX 95	PVC Flexible	up to 6" (Sch 40) up to 3" (Sch 80)
IPEX 71	ABS Drain, Waste and Vent	up to 6"
IPEX 90	PVC-ABS Transition Low Pressure	up to 6" (Sch 40) up to 4" (Sch 80)
IPEX 96	PVC-ABS Transition Non-Pressure	up to 6" (Sch 40)

Product Specific Cements		
Product	Application	Size Range
System 15 / XFR Cement	Drain, Waste & Vent	1-1/2" to 6" (One-Step) 8" and larger (Two-Step)
System 15 / XFR Primer	Drain, Waste & Vent	1-1/2" to 6" (optional) 8" and larger (mandatory)
System 636 PVC	Flue Gas Vent	up to 6"
System 636 CPVC	Flue Gas Vent	up to 8"
System 636 Primer	Flue Gas Vent	up to 4" (at 0°C or lower) 6" & 8" (mandatory)
AquaRise One-Step Cement	AquaRise Pressure	1/2 to 2" (do not use primer)
AquaRise Two-Step Cement & Primer	AquaRise Pressure	2-1/2", 3", 4"
IPEX 100	Scepter PVC Conduit/Duct	up to 6"
IPEX 100T Primer	Scepter PVC Conduit/Duct	all sizes (cold weather)
BlazeMaster One-Step	BlazeMaster CPVC	3/4" to 3"
Duraplus	Duraplus ABS Pressure	up to 12"



XIRTEC® INDUSTRIAL CEMENTS & PRIMER

	Volume		Product Code
	imperial	metric	

XIRTEC 05 PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

NSF and IAPMO listed to ASTM D2564 standard. NSF listed for potable water and sewer pipe. CSA listed for pressure and non-pressure applications.

Medium-bodied, fast setting PVC cement for all classes and schedules through 150 mm (6") diameter with interference fit Sch. 80 through 100 mm (4") only.



pint	473 ml	074346
quart	946 ml	074347

	Volume		Product Code
	imperial	metric	

XIRTEC 11 PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

NSF listed to ASTM D2564 for potable water and sewer pipe. IAPMO listed to ASTM D2564 standard. CSA certified for PVC pressure and non-pressure applications.

Heavy-bodied, medium setting, PVC cement for all classes and schedules through 300 mm (12") diameter, including Schedule 80. Its strong, aggressive penetration properties provide a strong bond. Its medium set allows more working time in warm weather.



1/2 pint	236 ml	074362
pint	473 ml	074363
quart	946 ml	074364
gallon	3785 ml	074365

XIRTEC 7 PRIMER

PURPLE/CLEAR ■ □

LOW VOC, 3 Year Shelf Life

NSF listed to ASTM F656 standard for potable water and sewer pipe.

Xirtec 7 is the most aggressive PVC and CPVC primer commercially available. Excellent product for cold weather applications. If used properly, Xirtec 7 will soften pipe and fitting surfaces which is necessary for the proper solvent welding of the materials.



PURPLE PRIMER

1/2 pint	236 ml	074335
pint	473 ml	074336
quart	946 ml	074337
gallon	3785 ml	074338

CLEAR PRIMER

1/4 pint	118 ml	074339
1/2 pint	236 ml	074340
pint	473 ml	074341
quart	946 ml	074342
gallon	3785 ml	074343

XIRTEC 17 PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

NSF listed to ASTM D2564 for potable water and sewer pipe. IAPMO listed to ASTM D2564 standard. CSA certified for PVC pressure and non-pressure applications.

Heavy-bodied, medium setting, PVC cement for all classes and schedules through 300 mm (12") diameter, including Schedule 80. It has good gap filling properties and its medium set allows more working time in warm weather.



quart	946 ml	074379
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DURAPLUS® CEMENTS & CLEANER

	Volume		Product Code
	imperial	metric	

XIRTEC 19 PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

NSF listed to ASTM D2564 for potable water and sewer pipe. IAPMO listed to ASTM D2564 standard. CSA certified for PVC pressure and non-pressure applications.

Extra heavy-bodied, slow setting, PVC cement for all classes and schedules through 750 mm (30") diameter, including Sch. 80 and System 15 in sizes 350 mm - 600 mm (14" - 24"). It is a good fabrication cement, as it has excellent gap filling properties, and because of its slow set, it is ideal for hot weather cement on large diameter pipe.



gallon	3785 ml	074387
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XIRTEC 24 CPVC CEMENT

ORANGE ■

LOW VOC, 2 Year Shelf Life

NSF listed to ASTM F493 standard for potable water and sewer pipe.

Heavy-bodied, medium setting, CPVC cement for all classes and schedules through 300 mm (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 Xirtec CPVC Industrial Systems.



pint	473 ml	074008
quart	946 ml	074009

	Volume		Product Code
	imperial	metric	

DURAPLUS ABS INDUSTRIAL CEMENT

GREY ■

LOW VOC, 1 Year Shelf Life

Medium-bodied, fast setting ABS cement for all sizes and products in the Duraplus Industrial line. The Grey Duraplus ABS solvent cement is manufactured from ABS particles identical to the material used for the manufacturing of Duraplus Industrial components. The cement is designed to withstand continuous applied pressures up to 230 psi @ 23°C (73°F). Duraplus MEK primer must be used prior to cementing.



pint	473 ml	337085
quart	946 ml	337084

DURAPLUS AIR-LINE CEMENT

LIGHT BLUE ■

LOW VOC, 1 Year Shelf Life

Medium-bodied, fast setting ABS cement for all sizes and products in the Duraplus Air-Line. Duraplus ABS solvent cement, is manufactured from ABS particles identical to the material used for the manufacturing of Duraplus Air-Line components. The cement is designed to withstand continuous applied pressures up to 185 psi @ 23°C (73°F). Duraplus MEK primer must be used prior to cementing.



pint	473 ml	437037
quart	946 ml	437038

DURAPLUS MEK CLEANER

CLEAR □

Duraplus MEK Cleaner/Primer must be used prior to solvent welding of any Duraplus and IPEX industrial ABS piping systems.



pint	473 ml	337468
quart	946 ml	337469

GENERAL PLUMBING CEMENTS & PRIMER

Volume		Product Code
imperial	metric	

IPEX 04 GENERAL PURPOSE PVC CEMENT

CLEAR/GREY

LOW VOC, 3 Year Shelf Life

Meets ASTM D2564. NSF and IAPMO listed for potable water and sewer pipe.

Medium-bodied, fast setting, PVC cement For rigid pipe sizes with interference fit through 160 mm (6") diameter. Sch 80 through 110 mm (4") diameter. For irrigation or drain. No primer needed for drainage applications unless required by local code.



CLEAR

1/4 pint	118 ml	074314
1/2 pint	236 ml	074313
pint	473 ml	074312
quart	946 ml	074311
gallon	3785 ml	074310

GREY

1 gal	3785 ml	074800
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Volume		Product Code
imperial	metric	

IPEX 25 WET/DRY PVC CEMENT

AQUA BLUE

LOW VOC, 3 Year Shelf Life

Meets the requirements of ASTM D2564 for use with PVC pipe and fittings. NSF and IAPMO listed for potable water and sewer pipe.

Medium-bodied, extremely fast setting PVC cement for pipe sizes through 150 mm (6") interference fit, Sch. 80 through 100 mm (4"). Specially formulated for rigid and flexible applications where conditions are very wet and/or when quick pressurization is desired.



1/2 pint	236 ml	074392
pint	473 ml	074393
quart	946 ml	074394

IPEX 47 POOL/SPA PVC CEMENT

BLUE - Blue fades to clear

LOW VOC, 3 Year Shelf Life

Meets ASTM D2564. CSA certified for joining flexible PVC pipe to rigid PVC fittings used in hydromassage bathtubs. NSF and IAPMO listed for potable water and sewer pipe.

Medium-bodied, extremely fast setting, for PVC pipe sizes through 150 mm (6") interference fit, Sch. 80 through 100 mm (4"). Developed for rigid & flexible applications, wet conditions and/or when quick pressurization is desired.



quart	946 ml	074139
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IPEX 5 WET/DRY PRIMER

AQUA BLUE

3 Year Shelf Life

Meets the requirements of ASTM F656 for use with PVC pipe and fittings. NSF listed for potable water and sewer pipe.

Very fast acting primer especially formulated for use with IPEX 25 Wet/Dry cement. Excellent primer for wet applications or when quick penetration of pipe and fitting surfaces is desired. Can also be used with any other PVC or CPVC cement.



pint	473 ml	074397
quart	946 ml	074398

Volume		Product Code
imperial	metric	

IPEX 71 ABS CEMENT

YELLOW ■

LOW VOC, 3 Year Shelf Life

Meets ASTM D2235 for use with ABS pipe. NSF listed to CSA B181.1 for ABS DWV pipe and fittings.

Medium-bodied, fast setting ABS cement for all classes and schedules through 150 mm (6") interference fit.



quart	946 ml	074180
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Volume		Product Code
imperial	metric	

IPEX 95 FLEX PVC CEMENT

CLEAR

Low VOC, 3 Year Shelf Life

Meets ASTM D2564. NSF and IAPMO listed for potable water and sewer pipe.

Medium-bodied, fast setting, for bonding flex/flex and flex/rigid PVC pipe and fittings through 150 mm (6") diameter interference fit, Sch. 80 through 75 mm (3") only. Excellent product for flex/rigid applications. It has an elastomer in the formulation which allows a more flexible joint.



1/4 pint	118 ml	074440
1/2 pint	236 ml	074163
quart	946 ml	074412

IPEX 96 ABS/PVC CEMENT

WHITE

3 Year Shelf Life

CSA certified for nonpressure ABS/PVC systems only. Meets ASTM D3138.

Regular-bodied, fast setting, FOR TRANSITION JOINTS ONLY IN NON-PRESSURE SYSTEMS. Pipe sizes through 150 mm (6") interference fit. Not for Sch. 80. Suitability of IPEX 96 should be verified for specific ABS/PVC materials.



pint	473 ml	074461
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AQUARISE® CEMENTS & PRIMER

	Volume		Product Code
	imperial	metric	

AQUARISE CPVC ONE-STEP CEMENT

YELLOW ■

LOW VOC, 2 Year Shelf Life

Meets ASTM F493. ANSI/NSF Standard 14 & 61 listed for potable water. Certified to CSA B137.6.

Medium-bodied, for use on 12 mm to 50 mm (1/2" to 2") diameters only. DO NOT USE PRIMER.



473	pint	359086
946	quart	359092
3785	gallon	359091

AQUARISE CPVC TWO-STEP CEMENT W/PRIMER

YELLOW ■

LOW VOC, 2 Year Shelf Life

AQUARISE TWO-STEP CEMENT meets ASTM F493. ANSI/NSF Standard 14 & 61 listed for potable water. Certified to CSA B137.6.

Heavy-bodied, for use on 63 mm, 75 mm & 100 mm (2-1/2", 3" & 4") diameters only.

MUST BE USED IN CONJUNCTION WITH AQUARISE CPVC PRIMER.



CLEAR □

LOW VOC, 2 Year Shelf Life

AQUARISE CPVC PRIMER meets ASTM F656. ANSI/NSF Standard 14 & 61 listed for potable water, drain waste & vent & sewer.

AquaRise CPVC Primer will soften pipe and fitting surfaces which is necessary for the proper solvent welding of the materials. Approved for use with AquaRise in potable water applications. For use on 63 mm, 75 mm & 100 mm (2-1/2", 3" and 4") diameters only.



473	pint	primer	359087
946	quart	cement	-
473	pint	primer	359093
3785	gallon	cement	-

SYSTEM 15 DWV, SYSTEM XFR CEMENTS & PRIMER

	Volume		Product Code
	imperial	metric	

SYSTEM 15/SYSTEM XFR ONE-STEP PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

Meets the requirements of ASTM D2564. cNSF Listed to CSA B181.2 for DWV applications.

Heavy-bodied, medium setting, grey, suitable for 40 mm to 150 mm (1-1/2 – 6”), without primer. Not recommended for use without primer below 0°C (32°F).



quart	946 ml	074232
gallon	3785 ml	074231

Medium-bodied, fast setting, grey, suitable for 40 mm to 150 mm (1-1/2 – 6”), without primer. Not recommended for use without primer below 0°C (32°F).



pint	473 ml	074098
quart	946 ml	074097
gallon	3785 ml	074096

	Volume		Product Code
	imperial	metric	

SYSTEM 15/SYSTEM XFR TWO-STEP PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

Meets the requirements of ASTM D2564. cNSF Listed to CSA B181.2 for DWV applications.

Heavy-bodied, medium setting, suitable for System 15 and System XFR pipe sizes 200 mm to 300 mm (8” to 12”) where gap filling is required. Use with System 15 / System XFR DWV primer. For System 15 pipe 14” to 24” (350mm to 600mm), refer to Xirtec 19 PVC cement.



quart	946 ml	074226
gallon	3785 ml	074225

SYSTEM 15/SYSTEM XFR DWV PRIMER

PURPLE ■

LOW VOC, 3 Year Shelf Life

Meets the requirements of ASTM F656.

For quick softening and preparation of System 15 and System XFR pipe and fitting sizes 40 mm to 600 mm (1-1/2” to 24”). A primer suitable for use with System 15 / System XFR DWV Two-Step Cement.



quart	946 ml	074354
gallon	3785 ml	074355

SYSTEM 636® CEMENTS & PRIMERS

Volume		Product Code
imperial	metric	

SYSTEM 636 PVC CEMENT

GREY ■

LOW VOC, 3 Year Shelf Life

Suitable for use with System 636 Flue Gas Venting, Type BH, Class IIA 65°C (149°F) pipe and fittings.

Meets ASTM D2564 "Standard Specification for Solvent Cements for Polyvinyl Chloride (PVC) Plastic Piping Systems".

Medium-bodied, fast setting, PVC cement certified as a system component for use with all diameters of System 636 PVC pipe and fittings. Primer is always required for 6" and 8" (150 mm and 200 mm) piping systems and for all installations performed at temperatures of 0°C (32°F) or less.



pint	473 ml	196040
quart	946 ml	196041

Volume		Product Code
imperial	metric	

SYSTEM 636 CPVC CEMENT

ORANGE ■

LOW VOC, 2 Year Shelf Life

Suitable for use with System 636 Flue Gas Venting, Type BH, Class IIB 90°C (194°F) pipe and fittings.

Meets ASTM F493 "Standard Specification for Chlorinated Polyvinyl Chloride (CPVC) Plastic Pipe and Fittings".

Heavy-bodied, medium setting, CPVC cement certified as a system component for use with all diameters of System 636 PVC or CPVC pipe and fittings. Primer is always required for 6" and 8" (150 mm and 200 mm) piping systems and for all installations performed at temperatures of 0°C (32°F) or less.



pint	473 ml	196046
quart	946 ml	196047

SYSTEM 636 PVC/CPVC PRIMER

CLEAR/PURPLE □ ■

LOW VOC, 3 Year Shelf Life

Suitable for use with System 636 Flue Gas Venting pipe and fittings that meet ULC S636 standards.

Meets ASTM F656 "Standard Specification for Primers for use in Solvent Cement Joints of Polyvinyl Chloride (PVC) Plastic Pipe and Fittings"

System 636 PVC/CPVC Primer is certified as a system component for use with all diameters of System 636 PVC/CPVC pipe and fittings. Primer is always required for 6" and 8" (150 mm and 200 mm) piping systems and for all installations performed at temperatures of 0°C (32°F) or less. DO NOT USE PRIMER ON ABS SURFACES.



CLEAR

pint	473 ml	196017
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PURPLE

pint	473 ml	196042
quart	946 ml	196043

BLAZEMASTER® CEMENT

	Volume		Product Code
	imperial	metric	

BLAZEMASTER BM5 ONE-STEP CEMENT

RED ■

LOW VOC, 2 Year Shelf Life

Meets the requirements of ASTM F493 for use with CPVC pipe. NSF listed for potable water.

Heavy-bodied, for use with BlazeMaster® CPVC pipe & fittings 20 mm – 80 mm (3/4" – 3"). Component for sprinkler pipe and fittings. For use with ULC 15S7 labeled IPEX BlazeMaster sprinkler pipe and fittings.



pint	473 ml	074328
quart	946 ml	074329

ADHESIVE

	Volume		Product Code
	inches	mm	

IPEX / IPS 810 REACTIVE ADHESIVE

WHITE □

Low VOC, 1 Year Shelf Life

Two-component, high-strength reactive adhesive for joining, fabricating and repairing PVC and CPVC pipe and fittings.



1/4 pint	118 ml	074176
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AVERAGE NUMBER OF JOINTS PER 946 ML (1 QUART) OF IPEX CEMENT AND PRIMER

Pipe Diameter mm	Pipe Diameter inches	Average Primer Joints per quart	Average Cement Joints per quart
12	1/2	600	300
20	3/4	400	200
25	1	250	125
40	1-1/2	180	90
50	2	120	60
75	3	80	40
100	4	60	30
150	5	20	10
200	6	10	5
250	10	4 – 6	2 – 3
300	12	2 – 4	1 – 2
400	16	1-1/2	3/4
450	18	1	1/2

These figures are estimates based on laboratory tests. Due to the many variables in the field, these figures should be used as a general guide only.

APPLICATORS & ACCESSORIES

	Size		Product Code
	imperial	metric	

BRISTLE BRUSH / CAP

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.



1"	25 mm	074454
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CAN-MATE DAUBER

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



3/4"	20 mm	074436
1-1/2 - 3"	40-75 mm	074437

CAP DAUBER

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.



1/2"	12 mm	074455
3/4"	20 mm	074420
1-1/2"	40 mm	074421
1-1/2"	40 mm	074422

SWAB

4020 swab for pipe diameters of 150 mm (6") or larger; fits MT-648 can. 5020 Swab available for quart can.



4"	100 mm	074456
		074317

	Size		Product Code
	imperial	metric	

AQUARISE SUPERSWAB REPLACEMENT

Swab holder and handle are reusable and can be used to cap the cement can. The swab is disposable and replaceable.



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ROLL-A-WELD ROLLER

3020 roller for pipe diameters from 75 mm through 150 mm (3" through 6"); fits MT-653 empty quart can.

7020 roller for pipe diameters of 150 mm (6") or larger; fits MT-648 can.



3"	75 mm	074426
7"	180 mm	074427

Description	Volume		Product Code
	U.S.	metric	

CAN WITH NECK

Can with neck is available in gallon (with 2-7/8" neck), quarts (with 2-7/8" neck or paint style neck) and pint (1-3/4" neck).



MT-654: 1-3/4" neck	pint	473 ml	074423
MT-653: paint style neck	quart	946 ml	074419
MT-651: 1-3/4" neck	quart	946 ml	074424
MT-648: 2-7/8" neck	gallon	3785 ml	074425

	Size		Product Code
	imperial	metric	

EMPTY APPLICAN WITH BRUSH



pint	500 ml	074728
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Visit our website:

www.ipexna.com

for
ON-SITE TRAINING



Learn more about IPEX products through in-person and online training programs.



ON-SITE SYSTEM 636 FLUE GAS VENTING TRAINING

Do you or your organization require System 636 product installation and solvent welding training? Contact IPEX to discuss organizing a group training session or find out when courses are being held in your local area.