

PRICE LIST

Plumbing and Industrial Solvent Cement Products



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Plumbing & Industrial Solvent Cement Products

Cements and Primers

Choosing the proper cement is vital to a successful installation of solvent weld thermoplastic piping. 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 cements meet CSA LM26895 and/or ASTM D2564 "Solvent Cements for (PVC) Plastic Piping Systems", ASTM F493 "Solvent Cements for CPVC Plastic Pipe and Fittings" and ASTM D2235 "Solvent Cements for ABS Plastic Pipe and Fittings", where required.

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 perfect results are achieved.

Additional Cements & Primers

The following Solvent Cement Products are not shown in this price list and are sold in specific pipe and fitting packages for each product line. Please refer to the latest edition of the following price lists for list prices on those products.

<u>Cement Product</u>	<u>Price List</u>
System 15/XFR	System XFR Fittings
System 636	System 636 PVC & CPVC Flue Gas Venting
AquaRise	AquaRise CPVC Pipe, Fittings and Cements
Blazemaster	Blazemaster CPVC Fire Sprinkler Systems
Duraplus	Duraplus ABS Industrial Systems
Scepter Conduit, Super Duct	PVC Conduit and Duct Solvent Cement & Primer

NOTE: Xirtec24 is mandatory to be used for all sodium hypochlorite piping (PVC or CPVC) applications. In addition, it is the preferred solvent cement for all Xirtec and Corzan chemical process line applications.

Description	Size ml (U.S.)	Product Code	Units Per Case	Weight / Case Kg (Lb)	Price Per Unit
Xirtec 05 PVC Cement , Medium Bodied * Low VOC *					
Fast Setting, Grey	473 (pt)	074346	12	6.8 (15)	\$ 24.00
	946 (qt)	074347	12	12.7 (28)	\$ 38.70
Xirtec 17 PVC Cement , Heavy Bodied * Low VOC *					
Medium Setting, Grey	946 (qt)	074379	12	12.7 (28)	\$ 38.35
					
Xirtec 11 PVC Cement , Heavy Bodied * Low VOC *					
Medium Setting, Grey	236 (1/2pt)	074362	24	7.3 (16)	\$ 18.15
	473 (pt)	074363	12	6.8 (15)	\$ 31.95
	946 (qt)	074364	12	12.7 (28)	\$ 54.70
	3,785 (gal)	074365	6	24.5 (54)	\$ 183.00
Xirtec 19 PVC Cement , Extra Heavy Bodied * Low VOC *					
Slow Setting, Grey	3,785 (gal)	074387	4	24.5 (54)	\$ 208.00
					
Xirtec 24 CPVC Cement (see note below) * Low VOC *					
Medium Setting, Orange	473 (pt)	074008	12	6.8 (15)	\$ 32.65
	946 (qt)	074009	12	12.7 (28)	\$ 76.00
Xirtec 7 Primer * Low VOC *					
Clear	118 (1/4pt)	074339	24	4.5 (10)	\$ 11.55
	236 (1/2pt)	074340	24	7.3 (16)	\$ 15.30
	473 (pt)	074341	12	6.8 (15)	\$ 26.25
	946 (qt)	074342	12	12.7 (28)	\$ 42.15
	3,785 (gal)	074343	6	24.5 (54)	\$ 142.00
Purple	236 (1/2pt)	074335	24	7.3 (16)	\$ 15.30
	473 (pt)	074336	12	6.8 (15)	\$ 26.25
	946 (qt)	074337	12	12.7 (28)	\$ 42.15
	3,785 (gal)	074338	6	24.5 (54)	\$ 142.00

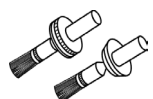
NOTE: Xirtec24 is mandatory to be used for all sodium hypochlorite piping (PVC or CPVC) applications. In addition, it is the preferred solvent cement for all Xirtec and Corzan chemical process line applications.

Description	Size ml (U.S.)	Product Code	Units Per Case	Weight / Case Kg (Lb)	Price Per Unit
IPEX 04 PVC General Purpose Cement, Medium Bodied, Fast Settling * Low VOC *					
	Clear	118 (1/4pt)	074314	24	4.5 (10) \$ 8.60
		236 (1/2pt)	074313	24	7.3 (16) \$ 11.00
		473 (pt)	074312	12	6.8 (15) \$ 17.85
		946 (qt)	074311	12	12.7 (28) \$ 29.75
		3,785 (gal)	074310	6	24.5 (54) \$ 104.00
	Grey	3,785 (gal)	074800	6	24.5 (54) \$ 104.00
IPEX 25 Wet / Dry, Aqua Blue * Low VOC *					
		236 (1/2pt)	074392	24	7.3 (16) \$ 17.00
		473 (pt)	074393	12	6.8 (15) \$ 29.40
		946 (qt)	074394	12	12.7 (28) \$ 47.15
IPEX 47 Pool / Spa, Blue * Low VOC *					
		946 (qt)	074139	12	12.7 (28) \$ 36.80
IPEX 95 Flex, Clear * Low VOC *					
		118 (1/4pt)	074440	24	4.5 (10) \$ 11.15
		236 (1/2pt)	074163	24	7.3 (16) \$ 16.35
		946 (qt)	074412	12	12.7 (28) \$ 47.35
IPEX 71 ABS, Yellow * Low VOC *					
		946 (qt)	074180	12	12.7 (28) \$ 23.70
IPEX 96 ABS/PVC Transition Cement					
IPEX 96 ABS/PVC, White	473 (pt)	074461	12	6.8 (15)	\$ 23.70
IPEX 5 Wet / Dry Primer * Low VOC *					
		473 (pt)	074397	12	6.8 (15) \$ 26.60
		946 (qt)	074398	12	12.7 (28) \$ 42.50
IPEX / IPS 810 Reactive Adhesive					
	118 (1/4pt)	074176	24	1.8 (4)	\$ 33.65

NOTE: Xirtec24 is mandatory to be used for all sodium hypochlorite piping (PVC or CPVC) applications. In addition, it is the preferred solvent cement for all Xirtec and Corzan chemical process line applications.

Description	Size mm (in.)	Product Code	Units Per Case	Weight / Case Kg (Lb)	Price Per Unit
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Bristle Brush / Cap



CM BCP Can-Mate adjustable brus
fits pint and quart size cans

25 (1)

074454

100

3.6 (8)

\$ 21.40

Can-Mate Dauber



CM-75

20 (3/4)

074436

50

1.8 (4)

\$ 10.95

CM-150

40-75 (1 1/2-3)

074437

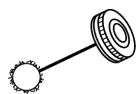
50

1.8 (4)

\$ 10.95

Adjustable applicator with telescoping stem; fits 1/2 pint, pint and quart size cans .

Cap Dauber



DP 75 for pipes up to 1 1/2"

20 (3/4)

074420

100

1.4 (3)

\$ 2.40

DP 150 for pipes up to 3"

40 (1 1/2)

074421

100

1.4 (3)

\$ 2.50

DQ 150 for pipes up to 3"

40 (1 1/2)

074422

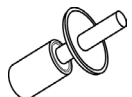
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1.4 (3)

\$ 2.50

DP fits 1/2 pt and pt cans; DQ fits quart size cans.

Roll-A-Weld Roller



3020 roller for pipe diameters
from 3" to 6". Fits an MT 653 can.

75 (3)

074426

24

3.2 (7)

\$ 31.60

7020 roller for pipe diameters 6"
and larger. Fits MT- 648 can.

180 (7)

074427

20

3.6 (8)

\$ 37.90

Swab



4020 swab for pipe diameters 6"
and larger; fits MT-648 can.

100 (4)

074456

24

2.3 (5)

\$ 37.90

5020 swab for pipe diameters 3"-8",
fits MT-651 can

100 (4)

074317

24

2.0 (4)

\$ 34.50

Can with Neck



MT-654. 1 3/4" neck, 473(pt)

-

074423

100

10.0 (22)

\$ 9.35

MT-653; paint style neck 946(qt)

-

074419

50

6.4 (14)

\$ 10.15

MT-651; 1 3/4" neck, 946(qt)

-

074424

50

6.8 (19)

\$ 12.00

MT-648; 2 7/8" neck, 3,785(gal)

-

074425

20

8.6 (19)

\$ 36.25

Initial Set Time

Average Initial Set Schedule For PVC & CPVC Solvent Cements *

Temp. Range	Pipe Size 1/2" - 1 1/4"	Pipe Size 1 1/2" - 2"	Pipe Size 2 1/2" - 8"	Pipe Size 10" - 15"	Pipe Size 15" +
60° – 100°F	2 min.	5 min.	30 min.	2 hrs.	4 hrs.
40° – 60°F	5 min.	10 min.	2 hrs.	8 hrs.	16 hrs.
0° – 40°F	10 min.	15 min.	12 hrs.	24 hrs.	48 hrs.

NOTE: Initial set schedule is the necessary time to allow before the joint can be carefully handled.

*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.

After initial set, the joints will withstand the stresses of a normal installation. (A misaligned installation will cause excessive stresses in the joint.) For long runs of pipe, care should be taken not to disturb joints for 1/2 to 1 1/2 hours before handling or burying. In damp or humid weather and chemical applications, allow a minimum of 50% more set time.

Joint Cure Schedule

The following cure schedules may be used to determine the necessary time required after assembly before testing the system or before line pressure can be applied.

Average Joint Cure Schedule for PVC & CPVC Solvent Cements **

Temperature Range During Assembly	1/2" - 1 1/4"		1 1/2" - 2"		2 1/2" - 8"		10" - 15"	15" +
	up to 160 psi	from 160 – 370 psi	up to 160 psi	from 160-315 psi	up to 160 psi	from 160-315 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 hr.	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 (over 60% Relative Humidity) and chemical applications, allow a minimum of 50% more cure time.

**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.

Cement Selection Chart

	XIRTEC 05 PVC CEMENT	XIRTEC 17 PVC CEMENT	XIRTEC 11 PVC CEMENT	XIRTEC 19 PVC CEMENT	XIRTEC 24 CPVC CEMENT	XIRTEC 7 PRIMER	IPEX 04 PVC CEMENT	IPEX 95 PVC FLEX CEMENT	IPEX 71 ABS CEMENT	IPEX 96 ABS/PVC TRANSITION CEMENT	IPEX 90 PVC/CPVC/ABS TRANSITION CEMENT	IPEX 05 PVC/CPVC PRIMER
Medium Body - Fast Set	Y	-	-	-	-	-	Y	Y	Y	-	Y	-
Heavy Body - Medium Set	-	Y	Y	-	Y	-	-	-	-	-	-	-
Extra Heavy Body - Slow Set	-	-	-	Y	-	-	-	-	-	-	-	-
Max Dia For Pressure (Sch 40)	6"	12"	12"	30"	12"	30"	6"	6"	6"	6"	6"	30"
Max Dia for Pressure (Sch 80)	4"	12"	12"	30"	12"	30"	4"	3"	6"	-	4"	30"
Max Dia for Drainage Systems	6"	12"	12"	30"	12"	30"	6"	6"	6"	8"	6"	30"
CSA Certified	Y	Y	Y	Y	-	-	Y	-	Y	Y	-	-
NSF Listed	Y	Y	Y	Y	Y	Y	Y	-	Y	-	-	-
Primer Required	Y	Y	Y	Y	Y	-	Y	Not in ABS	N	Not in ABS	Not in ABS	-
Product Shelf Life (Years)	3	3	3	3	2	3	3	3	3	3	3	3

Average Number of Joints /Qt. of IPEX Cement *

Pipe Diameter (inches)	1/2	3/4	1	1-1/2	2	3	4	6	8	10	12	16	18
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

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.

Primer volume usage is estimated to be 50% of cement.

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