



SOLVENT CEMENT & ACCESSORIES

SOLV-2-0217

Spears® Low VOC Solvent Cements, Primers & Accessories

Spears® is Your Single Source Manufacturer of Plastic Pipe, Fittings, Valves, & Solvent Cements



Low VOC for LEED® Credit

Environmentally friendly. LEED® Compliant (Leadership in Energy and Environmental Design). Credit can be gained through the use of Spears® Low VOC products. This program, developed by the US Green Building Council, uses SCAQMD Rule 1168 as a benchmark to qualify one credit toward LEED® certification for green building.

NSF® Certified & Listed

Listed for use in piping applications such as potable water, turf, irrigation, pool & spa, industrial, plumbing, DWV, and/or sewer plus special applications including fire protection, chemical waste, and ultra-pure water. Certified as applicable to the Uniform Plumbing Code (NSF® U.P.Code) and CSA B181.2 B137.3 requirements – see specific listings.

Certified to ASTM Standards

Certified by NSF International to ASTM D 2564 for PVC Solvent Cements, F 493 for CPVC Solvent Cements, D 2235 for ABS Solvent Cements, D 3138 for ABS To PVC Solvent Cements and F656 for Primers.

Professional grade solvent cements developed for contractors' essential needs in joining PVC, CPVC and ABS pipe and fittings. Available in 1/4 pints, 1/2 pints, pints, quarts, gallons, and 5 gallons according to cement type. Spears® also offers a full assortment of daubers, swabs, rollers, brushes, cans and accessories.

Cements for Specialty Systems

Specialty Cements formulated for special systems such as Copper Tube Size (CTS) Hot & Cold Water Distribution Systems, LabWaste® CPVC Corrosive Waste Drainage Systems, FlameGuard® CPVC Fire Sprinkler Systems, and Low Extractable PVC Ultra High Purity Water Systems.

Plus, special CPVC cements are specially formulated for use with Spears® ABS Type Approved and USCG Approved Pipe & Fittings for Marine Applications

Cements for Special Applications

Solvent cements specially formulated for a variety of environmental applications. Such as POOL-PRO™ for PVC Pool & Spa applications, Wet-N-Dry for other PVC high moisture conditions, CPVC-24 the most Chemically Resistant cement available for both CPVC & PVC chemical applications, Transition cement for ABS to PVC, Multi-Purpose cement for use on PVC, CPVC, ABS & Styrene, and Hot Blue cement for PVC installation in challenging conditions including wet, damp or cold temperatures requiring rapid set and fast drying.

Notice: One-Step Cements are limited to applicable sizes. See Specific One-Step Cement for limitations

Only Spears® Offers a **Lifetime Warranty** on Joints Properly Made with Spears® Cements & Primers

Progressive Products From Spears® Innovation & Technology

Applicators & Accessories

	<p>Can-Mate Kit: Includes Plastic Carrier Strap and two (2) Can-Mate 150 adjustable Daubers. Provides convenient carrying of 1/2 pint, pint or quart cans of cement and primer.</p>
	<p>Can-Mate Daubers: Adjustable Plastic Applicator with Telescoping Stem for use with Standard 1/2 Pint, Pint and Quart Cans. See application footnotes below.</p>
	<p>Cap Dauber: Fits 1-3/4" Neck Cans. Size by Dauber Diameter and Can Fitment.</p>
	<p>Swab with Wire Handle: 4" cotton for pipe size 6" & larger.</p>
	<p>Swab Small-Cap: Fits 1-3/4" Neck Quart Cans (MT-651). 4" length for pipe size 3" to 8".</p>
	<p>Swab Large-Cap: Fits 2-7/8" Neck Gallon Can (MT-648). For pipe size 6" & larger.</p>
	<p>Swab with Heavy Handle: For pipe size 6" & larger.</p>
	<p>Adjustable Swab: Adjustable Length, Dual Cap design fits Quart & Gallon containers (S14108). Bulk pack (S14111) and Replacement Swabs (S14109) available. The swab tip is disposable and swab holder is reusable. A Sturdy easy-to-grip Swab for pipe diameter from 4" through 8", S14108, S14111, S14109.</p>
	<p>Roller Small-Cap: Fits 1-3/4" Neck Quart Cans (MT-651). Replaceable Cover. For pipe size 3" to 6".</p>
	<p>Roller Can: Fits Paint Type Quart Can (MT-653). For use with pipe sizes 3" to 6".</p>
	<p>Roller Large-Cap: Fits 2-7/8" Neck Gallon Can (MT-648). Roller for pipe size 6" & larger.</p>
	<p>Roller with Heavy Handle: Replaceable Cover. For pipe size 6" & larger.</p>
	<p>Roller Replacement Covers: Fits Rollers with Heavy Handles #5520, 6020 & #6520. Sold as Pack of 2, full pack only.</p>
	<p>Cap Brushes: For Pint and Quart Cans</p>
	<p>Acid Brush: Small Utility Brush.</p>
	<p>Standard Empty Cans: 1-3/4" Neck</p>
	<p>Large Mouth Empty Cans: 2-7/8" Neck</p>
	<p>Easy Pour Spout: Fits 1/4 Pint, 1/2 Pint, Pint, Quart, Gallon Can 1-3/4" Neck.</p>
	<p>Empty Paint Type Cans</p>
	<p>Deburring Tool: Cone Type for PVC, CPVC, ABS, PE & PB pipe from 1/2" through 2".</p>

Solvent Cemented Pipe Joints Initial Set Schedule, Cure Schedule And Cement Usage Table

The following are basic guidelines and may require adjustment according to application or installation conditions. Certain specialty cements, such as FlameGuard® FS-5, may have different instructions for specific application conditions. Consult appropriate installation instructions for details.

INITIAL SET SCHEDULE: The Initial set schedule is the necessary waiting period before handling newly assembled joints. After initial set, the joint will withstand the stress of a normal installation. In damp or humid weather allow 50% more set time.

AVERAGE INITIAL SET SCHEDULE FOR SPEARS® 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/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

JOINT CURE SCHEDULE: The Joint cure schedule is the necessary waiting period before pressurizing newly assembled joints. Follow the schedule carefully. In damp or humid weather or chemical applications, allow a minimum of 50% more cure time.

AVERAGE JOINT CURE SCHEDULE FOR SPEARS® 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"+
	Up to 160 psi	Above 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
Temperature range during assembly and cure periods								
60°-100°F/16°-38°C	15 min	6 hrs	30 min	12 hrs	1-1/2 hrs	24 hrs	48 hrs	72 hrs
40°-60°F/5°-16°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
0°-40°F/-18°-5°C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

AVERAGE NUMBER OF JOINTS PER QUART OF SPEARS® CEMENT

Pipe Diameter	1/2"	3/4"	1"	1-1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"	20"	24"
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2	7/16	5/16

NOMINAL INCH AND CORRESPONDING NOMINAL MILLIMETER PIPE SIZES

in.	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	2-1/2"	3"	4"	6"	8"	10"	12"	14"	16"	18"	20"	24"
mm.	15	20	25	32	40	50	65	80	100	160	200	250	300	350	400	450	500	600

SPEARS® APPLICATOR SELECTION GUIDE

For proper solvent cement welding of pipe and fittings, the cement applicator must be no less than half the size of the pipe

DAUBERS	Pipe Diameters								
	1/4"	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	3"	
3/8" Dauber	•	•	•						
1/2" Dauber			•	•					
5/8" Dauber				•	•				
3/4" Dauber					•	•			
1-1/4" Dauber							•	•	
ROLLERS & SWABS		SIZE		FOR PIPE DIAMETERS					
3020		3" Roller		3" - 6"					
6020		4" Roller		3" - 8"					
7020		7" Roller		6" +					
5520		4" Roller		6" +					
6520		6" Roller		6" +					
4020		4" Swab		6" +					
5020		4" Swab		3" - 8"					
4520		4" Swab		6" +					
8020		4" Swab		6" +					
S14108		4" Adjustable Swab		4" - 8"					

PRODUCT SHELF LIFE

Spears® Products	Shelf Life	Spears® Products	Shelf Life
Primers / Cleaners	3 years	CPVC Solvent Cement	2 years
PVC Solvent Cement	3 years	ABS Solvent Cement	3 years



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