CSI 3-Part Specification for Combination of WELD-ON® Low VOC 724™ Cement and WELD-ON P-70™ Primer for CPVC and PVC Plastic Pipe

(Specifier Note: The purpose of this guide specification language is to assist the specifier in correctly specifying primer for PVC and CPVC piping (WELD-ON P-70™) and cement for CPVC plastic piping (WELD-ON 724™) for process piping applications. The specifier needs to edit the guide specifications to fit the needs of specific projects. Contact Weld-On to assist in making appropriate product selections. Throughout the guide specification, there are Specifier Notes to assist in the editing of the file.

The language provided is not adequate as a complete stand-alone specification section because it is an accessory product. Recommended section numbers and titles where this information may be appropriately included are Section 40 05 13.73 - Plastic Process Piping; Section 40 23 00 - Water Process Piping or other process piping sections. Language that the specifier may elect to include in each of the 3-Parts has been provided. Article numbering is only for navigating this document and language should be incorporated into the appropriate Article heading in the desired section.

References have been made within the text of the specification to MasterFormat 2004 Section numbers and titles; specifier needs to coordinate these numbers and titles with sections included for the specific project.

Specifier Notes included in (italicized red text) are included to provide assistance in selecting appropriate text for inclusion in a Specification. ***[Bracketed Bold Text]*** *indicates a selection is required. Text in the brackets may not be the only options available, but are recommended or common selections.*

PART 1— GENERAL

1.1 SECTION INCLUDES

A. (Accessory) Low VOC Primer and Solvent Cement for Process Piping

1.2 REFERENCES

A. ASTM International

1. ASTM D 2855 Standard Practice for Making Solvent-Cemented Joints with Poly (Vinyl Chloride) (PVC) Pipe and Fittings
2. ASTM F 493 Standard Specification for Solvent Cements for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe and Fittings
3. ASTM F 656 Standard Specification for Primers for use in Solvent Cement Joints of Poly (Vinyl Chloride) (PVC) Plastic Pipe and Fittings

B. NSF International/American National Standards Institute

1. NSF/ANSI 14 Plastics Piping System Components and Related Materials
2. NSF/ANSI 61 Drinking Water System Components - Health Effects

C. SCAQMD: South Coast Air Quality Management District

1. SCAQMD Rule 1168/316A: Adhesive and Sealant Applications

1.3 SUBMITTALS

(Specifier Note: DELETE Submittal Procedures paragraph when not required. Coordinate requirements with Division 01, Section 01 33 00 – Submittal Procedures.)

A. Refer to Section **[01 33 00 Submittal Procedures] [insert section number and title]**.

B. Product Data: Submit manufacturer current technical literature for each type of product, including installation instructions.

C. LEED Submittals:

1. Product Data for Credit **[IEQ 4.1] [EQ 4.1]**: For sealants, including printed statement of VOC content.

PART 2— PRODUCTS

(Specifier Note: Product information is proprietary to Weld-On. For Weld-On technical support, contact 877-477-8327.)

2.1 MANUFACTURER

A. Weld-On, PO Box 379, Gardena, CA 90248-0379; 310-898-3300; www.weldon.com

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2.2 SOLVENT CEMENTS

(Specifier Note: Product Information is proprietary to Weld-On.)

A. Primer: Basis of Design - WELD-ON® P70™

1. Characteristics:

a. Color: **[Clear] [Purple]**

b. Specific Gravity: 0.858 ± 0.040

c. Complies with ASTM F 656 for use on potable water, drain, waste, vent, and sewer applications.

d. Conforms to NSF/ANSI 61- Drinking Water System Components - Health Effects.

e. VOC Content ≤ 550 g/l, applied as directed, per SCAQMD Rule 1168/316a

B. Cement: Basis of Design - WELD-ON CPVC 724

1. Characteristics:

a. Color: **[Orange] [Gray]**

b. Specific Gravity: 0.984 ± 0.040

c. Meets Complies with ASTM F 493 for use on potable water and chemical transport applications.

d. Conforms to NSF/ANSI 61- Drinking Water System Components - Health Effects.

e. VOC Content ≤ 490 g/l, applied as directed, per SCAQMD Rule 1168/316a

f. Viscosity of 1600 cP @ 73 degrees ± 2 degrees F, minimum.

g. CPVC Resin Content: 10% minimum

h. Cement capable of dissolving an additional 3% by weight, of CPVC 41 compound.

PART 3— EXECUTION

3.1 EXAMINATION

A. Verify pipe to be joined is cut square and deburred. Pipe outside diameter should have a 10-15 degree chamfer, 3/32 inch from the end.

B. Remove residue from inside and outside of pipe, pipe bell, or fitting socket. Pipe and fitting shall be free of any chemical, paint, coatings, and other residue.

3.2 SOLVENT AND PRIMER APPLICATION

A. Comply with standard practices indicated in ASTM D 2855.

B. Apply primer, using a swab or roller, working it into the fitting socket, keeping the surface and applicator wet, until the surface has been softened. Remove any primer puddles. Apply second coat of primer in accordance with primer manufacturer's recommendations.

C. Apply primer to outside diameter of pipe, in same manner as fitting socket, to a depth equal to the fitting socket.

D. While primed surfaces are wet, apply an even layer of solvent cement to primed pipe equal to the depth of the fitting socket. Apply second coat of cement in accordance with manufacturer's recommendations.

E. Immediately after application to outside diameter surface, apply medium layer of solvent cement to fitting socket.

F. Assemble pipe and fitting while solvent cement is still wet.

G. Hold joint together as recommended by manufacturer.

H. Clean excess cement from pipe including bead around socket entrance.

I. Avoid disturbing joint during curing.