



# i-FUSE CEMENTS



Contact Name

Cell Phone

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# i-FUSE PVC Regular



- Clear
- Fast Setting
- Regular Bodied

PVC cement for all classes and schedules through 4" diameter interference fit. Schedule 80 through 2" diameter.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP100 | 1/4 Pint | 24         | 8        | 0.22         | 049081071035    |
| IFHP100 | 1/2 Pint | 24         | 15       | 0.37         | 049081071028    |
| IFPT100 | Pint     | 12         | 14       | 0.36         | 049081071011    |
| IFQT100 | Quart    | 12         | 27       | 0.67         | 049081071004    |
| IFGA100 | Gallon   | 6          | 56       | 1.07         | 810116842285    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Regular



- Gray
- Fast Setting
- Regular Bodied

PVC cement for all classes and schedules through 4" diameter interference fit. Schedule 80 through 2" diameter.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP170 | 1/4 Pint | 24         | 9        | 0.22         | 810116842339    |
| IFHP170 | 1/2 Pint | 24         | 18       | 0.38         | 810116842322    |
| IFPT170 | Pint     | 12         | 16       | 0.36         | 810116842315    |
| IFQT170 | Quart    | 12         | 30       | 0.68         | 810116842308    |
| IFGA170 | Gallon   | 6          | 56       | 1.07         | 810116842292    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Medium



- Clear
- Fast Setting
- Medium Bodied

PVC cement for all classes and schedules through 6" diameter interference fit. Schedule 80 through 4" diameter.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP105 | 1/4 Pint | 24         | 8        | 0.22         | 049081071080    |
| IFHP105 | 1/2 Pint | 24         | 15       | 0.37         | 049081071073    |
| IFPT105 | Pint     | 12         | 14       | 0.36         | 049081071066    |
| IFQT105 | Quart    | 1          | 227      | 0.67         | 049081071059    |
| IFGA105 | Gallon   | 6          | 52       | 1.07         | 049081071042    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Medium



- Gray
- Fast Setting
- Medium Bodied

PVC cement for all classes and schedules through 6" diameter interference fit. Schedule 80 through 4" diameter.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP110 | 1/4 Pint | 24         | 8        | 0.22         | 049081071134    |
| IFHP110 | 1/2 Pint | 24         | 15       | 0.37         | 049081071127    |
| IFPT110 | Pint     | 12         | 14       | 0.36         | 049081071110    |
| IFQT110 | Quart    | 12         | 27       | 0.67         | 049081071103    |
| IFGA110 | Gallon   | 6          | 52       | 1.07         | 049081071097    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Heavy



- Clear
- Medium Setting
- Heavy Bodied

PVC cement for all classes and schedules through 12" diameter interference fit.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFGA115 | GALLON   | 6          | 53       | 1.07         | 049081071141    |
| IFQT115 | QUART    | 12         | 28       | 0.67         | 049081071158    |
| IFPT115 | PINT     | 12         | 14       | 0.36         | 049081071165    |
| IFHP115 | 1/2 PINT | 24         | 15       | 0.37         | 049081071172    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Heavy



- Gray
- Medium Setting
- Heavy Bodied

PVC cement for all classes and schedules through 12" diameter interference fit.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP120 | 1/4 Pint | 24         | 9        | 0.22         | 81011684346     |
| IFHP120 | 1/2 Pint | 24         | 15       | 0.37         | 049081071226    |
| IFPT120 | Pint     | 12         | 14       | 0.36         | 049081071219    |
| IFQT120 | Quart    | 12         | 28       | 0.67         | 049081071202    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE PVC Wet or Dry



## • Aqua Blue • Very Fast Setting • Medium Bodied

PVC Cement for all classes an schedules through 6" diameter interference fit. Schedule 80 through 4" diameter. For wet or dry conditions.

| PART #  | SIZE     | UNITS/ CASE | LBS/ CASE | CU. FT./ CASE | UPC CODE ON CAN |
|---------|----------|-------------|-----------|---------------|-----------------|
| IFGA130 | GALLON   | 6           | 53        | 1.07          | 049081071288    |
| IFQT130 | QUART    | 12          | 27        | 0.67          | 049081071295    |
| IFPT130 | PINT     | 12          | 14        | 0.36          | 049081071301    |
| IFHP130 | 1/2 PINT | 24          | 15        | 0.37          | 049081071318    |
| IFQP130 | 1/4 PINT | 24          | 8         | 0.22          | 049081071325    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



PW-G/DWV/SW



# i-FUSE PVC Hot Pro



## • Blue • Extremely Fast Setting • Medium Bodied

PVC Cement for all classes an schedules through 6" diameter interference fit. Schedule 80 through 4" diameter. Excellent for wet, damp or cold conditions.

| PART #  | SIZE     | UNITS/ CASE | LBS/ CASE | CU. FT./ CASE | UPC CODE ON CAN |
|---------|----------|-------------|-----------|---------------|-----------------|
| IFQP125 | 1/4 Pint | 24          | 8         | 0.22          | 049081071271    |
| IFHP125 | 1/2 Pint | 24          | 15        | 0.37          | 049081071264    |
| IFPT125 | Pint     | 12          | 14        | 0.36          | 049081071257    |
| IFQT125 | Quart    | 12          | 27        | 0.67          | 049081071240    |
| IFGA125 | Gallon   | 6           | 53        | 1.07          | 049081071233    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



PW-G/DWV/SW



# I-FUSE PVC Flex Pro



- Clear
- Fast Setting
- Heavy Bodied

PVC Cement for all classes an schedules through 6" diameter interference fit. Schedule 80 through 3" diameter.

For use on flexible and rigid PVC. Forms flexible, high-strength joints.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFGA160 | GALLON   | 6          | 51       | 1.07         | 049081071981    |
| IFQT160 | QUART    | 12         | 27       | 0.67         | 049081071998    |
| IFPT160 | PINT     | 12         | 14       | 0.36         | 049081072001    |
| IFHP160 | 1/2 PINT | 24         | 15       | 0.37         | 049081072018    |
| IFQP160 | 1/4 PINT | 24         | 8        | 0.22         | 049081072025    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# I-FUSE POOL & SPA – Pool Pro



- Blue
- Very Fast Setting
- Medium Bodied

PVC Cement for all classes an schedules through 6" diameter interference fit. Schedule 80 through 3" diameter. Excellent for maintenance/repair; wet or quick, pressurization conditions.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQT225 | QUART    | 12         | 28       | 0.67         | 049081071783    |
| IFPT225 | PINT     | 12         | 14       | 0.36         | 049081071790    |
| IFHP225 | 1/2 PINT | 24         | 15       | 0.37         | 049081071806    |
| IFQP225 | 1/4 PINT | 24         | 8        | 0.22         | 049081071813    |

Meets following performance specifications:

ASTM D 2564, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE CPVC Hot 'N Cold



- Yellow
- Fast Setting
- Medium Bodied

CPVC cement for copper tube size through 2" diameter interference fit. 1-step cement for potable water to 180°F/82°C. Suitable for residential plumbing.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP135 | 1/4 Pint | 24         | 8        | 0.22         | 049081071370    |
| IFHP135 | 1/2 Pint | 24         | 16       | 0.37         | 049081071363    |
| IFPT135 | Pint     | 12         | 15       | 0.36         | 049081071356    |
| IFQT135 | Quart    | 12         | 29       | 0.67         | 049081071349    |

Meets following performance specifications:

ASTM D 2846, ASTM F 493, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE CPVC Heavy



- Orange
- Medium Setting
- Heavy Bodied

CPVC cement for all classes and schedules through 12" diameter interference fit. Suitable for applications up to 180°F/82°C.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP140 | 1/4 Pint | 24         | 9        | 0.22         | 810116842452    |
| IFHP140 | 1/2 Pint | 24         | 15       | 0.37         | 049081071400    |
| IFPT140 | Pint     | 12         | 14       | 0.36         | 049081071394    |
| IFQT140 | Quart    | 12         | 29       | 0.67         | 049081071387    |

Meets following performance specifications:

ASTM D 2846, ASTM F 493, NSF/ANSI 14, NSF/ANSI 61



# i-FUSE ABS Yellow



- Yellow
- Fast Setting
- Medium Bodied

ABS cement for all classes and schedules through 8" diameter interference fit.

For plumbing application (DWV, sewer and drain pipe), conduit and foam core.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP175 | 1/4 Pint | 24         | 9        | 0.22         | 810116842391    |
| IFHP175 | 1/2 Pint | 24         | 18       | 0.38         | 810116842384    |
| IFPT175 | Pint     | 12         | 16       | 0.36         | 810116842377    |
| IFQT175 | Quart    | 12         | 30       | 0.68         | 810116842360    |
| IFGA175 | Gallon   | 6          | 56       | 1.07         | 810116842353    |

Meets following performance specifications:

ASTM D2235 and NSF/ANSI 14



PW-G/DWV/SW



# i-FUSE ABS Black



- Black
- Fast Setting
- Medium Bodied

ABS cement for all classes and schedules through 8" diameter interference fit.

For plumbing application (DWV, sewer and drain pipe), conduit and foam core.

| PART #  | SIZE     | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE ON CAN |
|---------|----------|------------|----------|--------------|-----------------|
| IFQP180 | 1/4 Pint | 24         | 9        | 0.22         | 810116842445    |
| IFHP180 | 1/2 Pint | 24         | 18       | 0.38         | 810116842438    |
| IFPT180 | Pint     | 12         | 16       | 0.36         | 810116842421    |
| IFQT180 | Quart    | 12         | 30       | 0.68         | 810116842414    |
| IFGA180 | Gallon   | 6          | 56       | 1.07         | 810116842407    |

Meets following performance specifications:

ASTM D2235 and NSF/ANSI 14



PW-G/DWV/SW



# i-FUSE Primer



- **Purple**

Applicable for all pvc & cpvc classes, schedules and sizes.

| PART #  | SIZE     | UNITS/<br>CASE | LBS/<br>CASE | CU. FT./<br>CASE | UPC CODE ON<br>CAN |
|---------|----------|----------------|--------------|------------------|--------------------|
| IFQP150 | 1/4 Pint | 24             | 7            | 0.22             | 049081071509       |
| IFHP150 | 1/2 Pint | 24             | 14           | 0.37             | 049081071493       |
| IFPT150 | Pint     | 12             | 13           | 0.36             | 049081071486       |
| IFQT150 | Quart    | 12             | 25           | 0.67             | 049081071479       |
| IFGA150 | Gallon   | 6              | 49           | 1.07             | 049081071462       |



PW-G/DWW/SW



# i-FUSE Primer



- **Clear**

Applicable for all pvc & cpvc classes, schedules and sizes.

| PART #  | SIZE     | UNITS/<br>CASE | LBS/<br>CASE | CU. FT./<br>CASE | UPC CODE ON<br>CAN |
|---------|----------|----------------|--------------|------------------|--------------------|
| IFGA145 | GALLON   | 6              | 49           | 1.07             | 049081071417       |
| IFQT145 | QUART    | 12             | 25           | 0.67             | 049081071424       |
| IFPT145 | PINT     | 12             | 13           | 0.36             | 049081071431       |
| IFHP145 | 1/2 PINT | 24             | 14           | 0.37             | 049081071448       |
| IFQP145 | 1/4 PINT | 24             | 7            | 0.22             | 049081071455       |



PW-G/DWW/SW



# i-FUSE Cleaner



- **Clear**

Applicable for all pvc & cpvc classes, schedules and sizes.

| PART #  | SIZE     | UNITS/<br>CASE | LBS/<br>CASE | CU. FT./<br>CASE | UPC CODE ON<br>CAN |
|---------|----------|----------------|--------------|------------------|--------------------|
| IFGA155 | Gallon   | 6              | 46           | 1.07             | 049081071516       |
| IFQT155 | Quart    | 12             | 24           | 0.67             | 049081071523       |
| IFPT155 | Pint     | 12             | 12           | 0.36             | 049081071530       |
| IFHP155 | 1/2 Pint | 24             | 13           | 0.37             | 049081071547       |
| IFQP155 | 1/4 Pint | 24             | 7            | 0.22             | 049081071554       |

**Meets following performance specifications:**

SCAQMD Rule 1168/316A.



# i-FUSE Empty Can



Empty quart metal can  
(cap not included).

| PART # | SIZE  | UNITS/<br>CASE | UPC CODE ON<br>CAN |
|--------|-------|----------------|--------------------|
| IFQT-E | Quart | 12             | 049081072162       |

# i-FUSE Thread Sealant

- White



**i-FUSE Thread Sealant with PTFE particles.**

For sealing and lubricating pipe threads. Contains finely homogenized PTFE particles for filling cracks and thread imperfections – ensuring a leakproof seal.

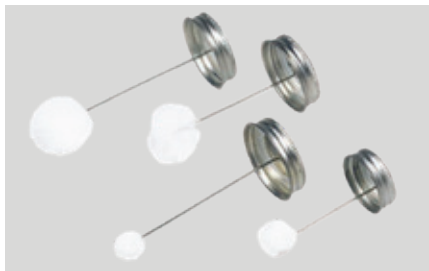
| PART #  | SIZE   | UNITS/<br>CASE | LBS/<br>CASE | CU. FT./<br>CASE | UPC CODE ON<br>CAN |
|---------|--------|----------------|--------------|------------------|--------------------|
| IFHP-TS | ½ Pint | 24             | 20           | 0.386            | 049081072186       |



PW-G/DWW/SW



## i-FUSE Daubers



### Screw-cap dauber

- Fits 1/4 pint, 1/2 pint, pint and quart cans.
- Available in dauber sizes 3/8" to 1 1/2".

| PART # | DAUBER SIZE | FOR CAN TYPE             | FOR USE WITH PIPE DIAMETER | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|-------------|--------------------------|----------------------------|------------|----------|--------------|--------------|
| GD-200 | 3/4"        | 1/4 PINT, 1/2 PINT, PINT | 3/4" to 1 1/2"             | 50         | 1.5      | 0.2          | 049081070113 |
| GD-300 | 1 1/2"      | 1/4 PINT, 1/2 PINT, PINT | 1 1/2" to 3"               | 50         | 1.5      | 0.2          | 049081070120 |
| GD-400 | 3/4"        | QUART                    | 3/4" to 1 1/2"             | 50         | 1.5      | 0.2          | 049081070137 |
| GD-500 | 1 1/2"      | QUART                    | 1 1/2" to 3"               | 50         | 1.7      | 0.2          | 049081070144 |

## i-FUSE 3" Roller



- 3" roller for pipe diameter from 3" through 6".
- Fits i-Fuse empty quart paint-style can

| PART # | SIZE | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|------|------------|----------|--------------|--------------|
| GD-550 | 3"   | 24         | 6        | 0.93         | 049081070175 |

## i-FUSE 7" Roller



- 7" roller for pipe diameter from 6" or larger.
- Fits i-Fuse empty wide mouth gallon can.

| PART # | SIZE | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|------|------------|----------|--------------|--------------|
| GD-560 | 7"   | 20         | 7        | 0.93         | 049081070182 |

## i-FUSE Quart Swab



- 4" swab for pipe diameter 3" through 8".
- Fits quart can.

| PART # | SIZE | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|------|------------|----------|--------------|--------------|
| GD-600 | 4"   | 24         | 4        | 0.93         | 049081070191 |

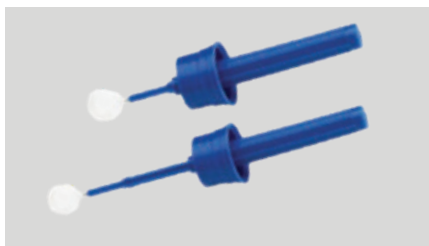
## i-FUSE Gallon Swab



- 4" swab for pipe diameters 6" or larger.
- Fits gallon can.

| PART # | SIZE | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|------|------------|----------|--------------|--------------|
| GD-700 | 4"   | 24         | 5        | 0.93         | 049081070168 |

## i-FUSE Expandable Daubers



- Expandable, fully adjustable dauber stem.
- Easy grip handle for better dauber control.
- Fits 1/2 pint, pint and quart cans.
- Available in dauber sizes 3/4" and 1 1/4".

| PART # | DAUBER SIZE | FOR CAN TYPE              | FOR USE WITH PIPE DIAMETER                                              | UNITS/CASE | LBS/CASE | CU. FT./CASE | UPC CODE     |
|--------|-------------|---------------------------|-------------------------------------------------------------------------|------------|----------|--------------|--------------|
| GD-800 | 3/4"        | 1/2 PINT<br>PINT<br>QUART | 3/4" - 1 1/2" CTS pipe<br>1/2" - 1 1/2" Sch. 40 and<br>Sch. 80 IPS pipe | 50         | 2.0      | 0.2          | 049081070199 |
| GD-810 | 1 1/4"      | 1/2 PINT<br>PINT<br>QUART | 1 1/2" - 2" CTS pipe<br>1 1/4" - 3" Sch. 40 and<br>Sch. 80 IPS pipe     | 50         | 2.0      | 0.2          | 049081070090 |

# i-FUSE SOLVENT CEMENT, PRIMER AND CLEANER GUIDE

| IRRIGATION & PLUMBING |              | IRRIGATION & PLUMBING SOLVENT CEMENT, PRIMER AND CLEANER GUIDE |           |      |     |     |    |    |    |     |     |     |     |     |
|-----------------------|--------------|----------------------------------------------------------------|-----------|------|-----|-----|----|----|----|-----|-----|-----|-----|-----|
|                       |              | NUMBER                                                         | COLOR     | INCH | 1/2 | 3/4 | 1  | 2  | 3  | 4   | 6   | 8   | 10  | 12  |
|                       |              |                                                                |           | MM   | 20  | 25  | 32 | 63 | 90 | 110 | 160 | 200 | 250 | 315 |
| PVC                   | REGULAR BODY | 100                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |
|                       |              | 170                                                            | GRAY      |      |     |     |    |    |    |     |     |     |     |     |
|                       | MEDIUM BODY  | 105                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |
|                       |              | 110                                                            | GRAY      |      |     |     |    |    |    |     |     |     |     |     |
|                       | HEAVY BODY   | 115                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |
|                       |              | 120                                                            | GRAY      |      |     |     |    |    |    |     |     |     |     |     |
| SPECIALTY             | FLEX PRO     | 160                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |
|                       | WET OR DRY   | 130                                                            | AQUA BLUE |      |     |     |    |    |    |     |     |     |     |     |
|                       | HOT PRO      | 125                                                            | BLUE      |      |     |     |    |    |    |     |     |     |     |     |
|                       | POOL & SPA   | 225                                                            | BLUE      |      |     |     |    |    |    |     |     |     |     |     |
|                       |              |                                                                |           |      |     |     |    |    |    |     |     |     |     |     |
|                       |              |                                                                |           |      |     |     |    |    |    |     |     |     |     |     |
| CPVC                  | MEDIUM BODY  | 135                                                            | YELLOW    |      |     |     |    |    |    |     |     |     |     |     |
|                       | HEAVY BODY   | 140                                                            | ORANGE    |      |     |     |    |    |    |     |     |     |     |     |
| ABS                   | MEDIUM BODY  | 175                                                            | YELLOW    |      |     |     |    |    |    |     |     |     |     |     |
|                       |              | 180                                                            | BLACK     |      |     |     |    |    |    |     |     |     |     |     |
| PRIMER & CLEANER      | PRIMER       | 150                                                            | PURPLE    |      |     |     |    |    |    |     |     |     |     |     |
|                       |              | 145                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |
|                       | CLEANER      | 155                                                            | CLEAR     |      |     |     |    |    |    |     |     |     |     |     |

## LEGEND

PVC SCHEDULE 40 

SCHEDULE 80 

# i-FUSE SOLVENT CEMENT, PRIMER AND CLEANER GUIDE

**AVERAGE INITIAL SET SCHEDULE FOR i-FUSE PVC/CPVC SOLVENT CEMENTS\*\***

| Temperature Range        | Pipe Sizes<br>1/2" to 1 1/4"<br>20mm to 40mm | Pipe Sizes<br>1 1/2" to 2"<br>50mm to 63mm | Pipe Sizes<br>2 1/2" to 8"<br>75mm to 200mm | Pipe Sizes<br>10" to 15"<br>250mm to 380mm | Pipe Sizes<br>15"+<br>380mm + |
|--------------------------|----------------------------------------------|--------------------------------------------|---------------------------------------------|--------------------------------------------|-------------------------------|
| 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                      |

**Note** - Initial set schedule is the necessary time to allow before the joint can be carefully handled. In damp or humid weather allow 50% more set time.

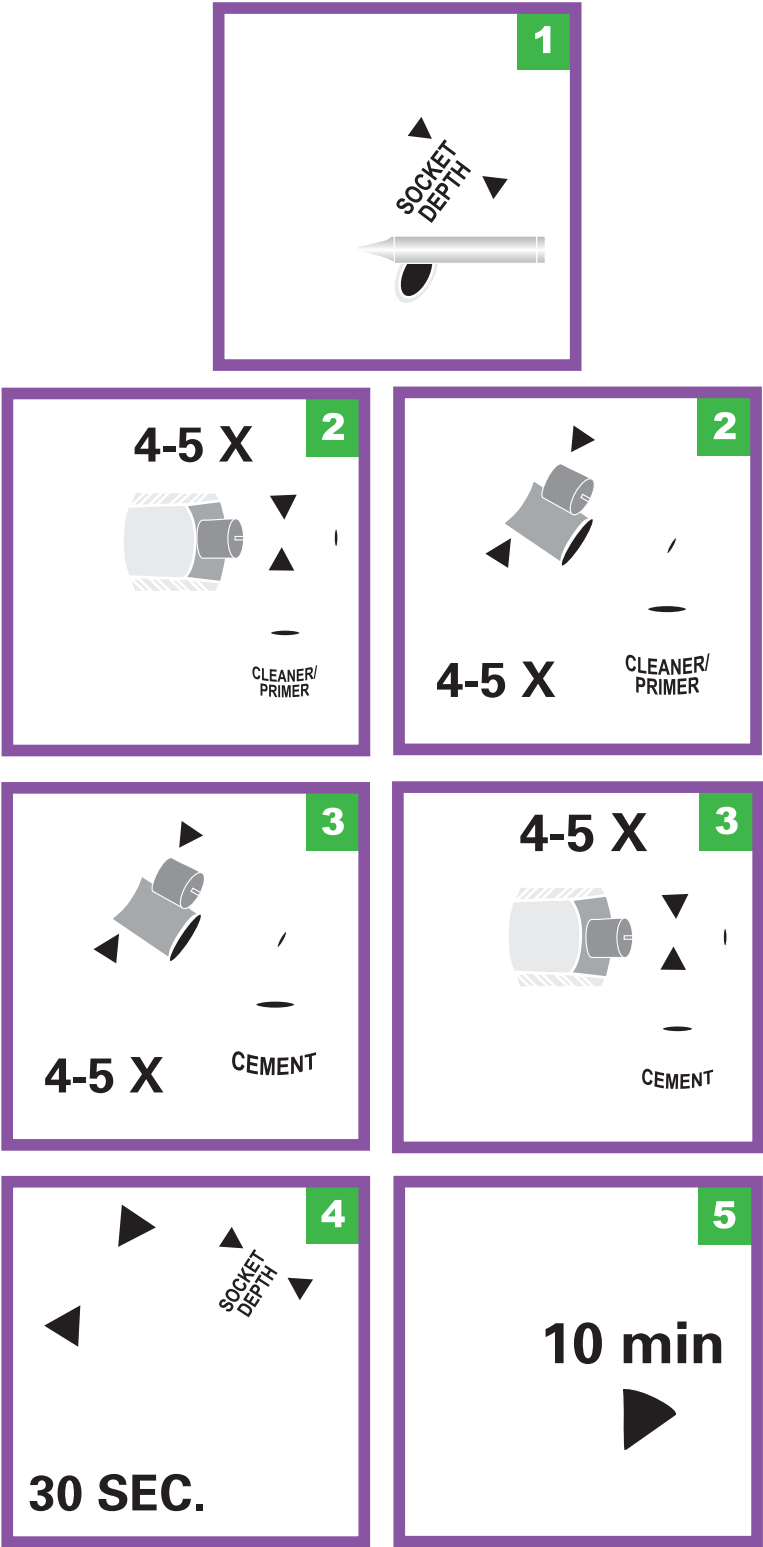
**AVERAGE JOINT CURE SCHEDULE FOR i-FUSE PVC/CPVC SOLVENT CEMENTS\*\***

| Relative Humidity<br>60% or Less                         | Pipe Sizes<br>1/2" to 1 1/4"<br>20mm to 40mm |                                     | Pipe Sizes<br>1 1/2" to 2"<br>50mm to 63mm |                                     | Pipe Sizes<br>2 1/2" to 8"<br>75mm to 200mm |                                     | Pipe Sizes<br>10" to 15"<br>250mm to 380mm | Pipe Sizes<br>15" +<br>380mm + |
|----------------------------------------------------------|----------------------------------------------|-------------------------------------|--------------------------------------------|-------------------------------------|---------------------------------------------|-------------------------------------|--------------------------------------------|--------------------------------|
| Temperature range<br>during assembly and<br>cure periods | up to<br>160 psi /<br>11 Bar                 | 160 to<br>370 psi /<br>11 to 26 Bar | up to<br>160 psi /<br>11 Bar               | 160 to<br>315 psi /<br>11 to 22 Bar | up to<br>160 psi /<br>11 Bar                | 160 to<br>315 psi /<br>11 to 22 Bar | up to<br>100 psi /<br>7 Bar                | up to<br>100 psi /<br>7 Bar    |
| 60° - 100°F / 16° - 38°C                                 | 15 min                                       | 6 hrs                               | 30 min                                     | 12 hrs                              | 1½ 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                        |

**Note** - Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.

\*\*These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a general reference only.

**i-FUSE SOLVENT CEMENT, PRIMER AND CLEANER GUIDE**





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