



Technical Specification

Fusion Single Step Clear Self-Priming Medium PVC Cement

CURE CHART

Pipe Diameter		Temperature during assembly and cure period		
		60° to 100 °F 16° to 38 °C	40° to 60 °F 4° to 16 °C	0° to 40 °F -18° to 4 °C
1/2" to 1 1/4" (13 to 32 mm)	Up to 180 PSI	15 min	20 min	60 min
1 1/2" to 3" (40 to 80 mm)	Up to 180 PSI	30 min	2 hrs	4 hrs
4" to 5" (100 to 125 mm)	Up to 180 PSI	2 hrs	16 hrs	***
6" (150 mm)	Up to 180 PSI	8 hrs	***	***

*** Please contact Oatey Technical Services for cure time information.

Precautions

Read all information carefully before using this product.

DANGER!: HIGHLY FLAMMABLE LIQUID AND VAPOR. HARMFUL IF SWALLOWED. MAY BE FATAL IF SWALLOWED AND ENTERS AIRWAYS. CAUSES SKIN IRRITATION. CAUSES SERIOUS EYE IRRITATION. MAY CAUSE DROWSINESS OR DIZZINESS. KEEP OUT OF REACH OF CHILDREN.

PRECAUTIONS: Prevention: Keep away from heat/sparks/open flames/hot surfaces. - No smoking. Keep container tightly closed. Ground/bond container and receiving equipment. Use explosion-proof electrical/ventilating/lighting equipment. Use only non-sparking tools. Take precautionary measures against static discharge. Avoid breathing mist or vapor. Wash thoroughly after handling. Use only outdoors or in a well-ventilated area. Wear protective gloves/eye protection/face protection. Frequent or prolonged contact may defat and dry the skin, leading to discomfort and dermatitis. **KEEP OUT OF REACH OF CHILDREN.** Frequent or prolonged contact may defat and dry the skin, leading to discomfort and dermatitis.

EMERGENCY/FIRST AID: CALL 1-877-740-5015 FOR INSTRUCTIONS.

Response: If swallowed: Immediately call a poison center/doctor. Do NOT induce vomiting. If on skin (or hair): Take off immediately all contaminated clothing. Rinse skin with water/shower. If inhaled: Remove person to fresh air and keep comfortable for breathing. If in eyes: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Call a poison center/doctor if you feel unwell. Take off contaminated clothing and wash before reuse. In case of Fire: Use appropriate media to extinguish.

Storage: Keep cool. Store in a well-ventilated place. Keep container tightly closed. Store locked up.

Disposal: Dispose of contents/container in accordance with local/ regional/national/international regulations.

FIRE: Use dry chemical, foam, carbon dioxide extinguisher or appropriate media. Water spray may be applied to reduce potential vapors or for cooling. Burning liquid extinguished with water will float and may re-ignite on surface of water.

SPILLS: Remove all sources of ignition and ventilate area. Personnel cleaning up the spill should wear appropriate personal protective equipment, including respirators if vapor concentrations are high. Soak up spill with absorbent material. Put absorbent material in covered, labeled metal containers.



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Directions for Use

Store and use at temperatures between 40°F and 110°F. At temperatures outside of this range, special care must be taken to prepare good joints and prevent exposure to solvents. Stir or shake before using; if jelly-like, don't use. Do not thin.

1. Cut pipe ends square, chamfer and clean pipe ends.
2. Check dry fit of pipe and fitting. Pipe should easily go 1/3 of the way into the fitting. If pipe bottoms, fit should be snug.
3. Use a suitable applicator at least 1/2 the size of the pipe diameter. For larger size pipe systems use a natural bristle brush or roller.
4. Clean pipe and fitting. Where local codes permit, may be used without primer.
5. Apply liberal coat of cement to pipe to the depth of the socket, leave no uncoated surface.
6. Apply a thin coat of cement to inside of fitting, avoid puddling of cement. Puddling can cause weakening and premature failure of pipe or fitting. Apply a second coat of cement to the pipe.
7. Assemble parts QUICKLY. Cement must be fluid. If cement surface has dried, recoat both parts.
8. Push pipe FULLY into fitting using a ¼ turning motion until pipe bottoms.
9. Hold pipe and fitting together for 30 seconds to prevent pipe push-out - longer at low temperatures. Wipe off excess.
10. Allow 15 minutes for good handling strength and 2 hours cure time at temperatures above 60°F before pressure testing up to 180 psi. Longer cure times may be required at temperatures below 60°F or with pipe above 3".

DO NOT TEST WITH AIR.

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