



# 7117 PVC CEMENT

Heavy Bodied

## DESCRIPTION:

Weld-All™ 7117 PVC™ is a Gray, Heavy Bodied, High Strength, Slow Setting PVC Solvent Cement for all classes and schedule. This cement is manufactured in the U.S.A.

## APPLICATION:

7117 For PVC™ is for use on PVC pipes and fittings. This cement may be used for up to 12" pipes and fittings with interference fit for such applications as potable water, irrigation drain, waste, vent, sewer and conduit.

## PROPERTIES AND SPECIFICATIONS:

Color	Gray
Appearance	Liquid
Set Time/Fast	Slow
Cure Time	Consult ASTM schedule
Exceeds	ASTM D-2564 specification
Shelf Life:	2 years



7117

This cement has passed the following tests performed according to ASTM Standard D-2564 at 73 degree Fahrenheit (22.77 Celsius)

2 hour Hydrostatic Burst Test	400 psi	(27.58 Bar)
2 Hour Lap Shear Test	250 psi	(17.24 Bar)
16 Hour Lap Shear Test	500 psi	(34.47 Bar)
72 Hour Lap Shear Test	900 psi	(62.05 Bar)

Thinners should not be added to change viscosity (thickness) of the cement. It may change properties and performance of the cement

## AVAILABILITY

size	part no	units/carton	
4 Fluid Oz / 120ml	<b>711704</b>	24	Can with brush in cap
8 Fluid Oz / 237ml	<b>711708</b>	24	Can with brush in cap
16 Fluid Oz / 437ml	<b>711716</b>	12	Can with brush in cap
32 Fluid Oz / 947ml	<b>711732</b>	12	Can with brush in cap

## CURE TIME GUIDE

The ASTM has developed the following schedule and may be used as a guide

Temperature Range - Degree F	Pipe Size 1/2" to 1 1/4"		Pipe Size 1 1/2" to 3"		Pipe Size 3" to 6"	
	Up to 180 psi	181 psi to 370 psi	Up to 180 psi	181 psi to 315 psi	Up to 180 psi	181 psi to 315 psi
<b>60 to 100</b>	1 hour	6 hours	2 hours	12 hours	6 hours	24 hours
<b>40 to 60</b>	2 hours	12 hours	4 hours	24 hours	12 hours	48 hours
<b>10 to 40</b>	8 hours	12 hours	16 hours	96 hours	48 hours	8 days

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## **DIRECTION FOR USE:**

Shake well before using (do not use if cement is not fluid)  
Keep container closed when not in use

Set time is the time required before joint can safely be handled. Cure time is the time required before joint can be pressure tested

1. Cut pipe square with saw or hand cutter. Remove all burrs
2. Check dry fit of pipe and fitting. Pipe should easily go 1/3 to 1/2 ways into fitting. If pipe bottoms into fitting it should be very snug
3. Pipe and Fitting should be free of dirt, grease and other foreign materials. If necessary clean pipe and fitting using Weld-All™ Pipe Cleaner. Primer is highly recommended for 3" and larger diameter installation. Apply liberal coat. Primer will start softening surface of pipe and fitting thus ensuring superior joint.
4. Use applicator supplied with the can or suitable applicator at least 1/2 the size of the pipe diameter
5. Apply Liberal coat of cement to the pipe (equal to depth of fitting) and adequate coat inside of fitting. Make sure there is no uncoated surface. Avoid puddling of cement, it may weaken the joint.
6. Immediately insert pipe into fitting with twisting motion. Cement should be wet. If it has dried recoat both parts. Use sufficient force to ensure pipe bottoms into fitting.
7. Hold joint together for 30-40 seconds to make sure pipe is not pushed out – longer time if temperature is low and for larger pipes.
8. Allow 15 minutes set time before handling the assembly and 2 hours cure time if temperature is below 16 degree Celsius or 60 degree Fahrenheit. Longer cure time may be required for larger pipe and or temperature is below 16 degree Celsius or 60 degree Fahrenheit

## **PRECAUTIONS:**

**EXTREMELY FLAMMABLE LIQUID, VAPOR MAY IRRITATE EYE OR SKIN, MAY CASUE FLASH FIRE, MAY BE HARMFUL OR FATAL IF SWALLOWED. DO NOT USE NEAR HEAT, SPARKS AND FLAMES. KEEP OUT OF REACH OF CHILDREN**

Ensure adequate ventilation to avoid vapor build up which may cause flash fire. Vapor build up may also cause dizziness, headache or eye watering. If symptoms are experienced use respiratory protection or leave area and provide more fresh air. Avoid contact with eyes, skin and clothing. Do not smoke and wear protective equipment while using

## **FIRST AID:**

**Inhalation:** If breathing is difficult vacate to fresh air. If breathing problems persist seek immediate medical attention.

**Eye Contact:** Flush eyes thoroughly with water for 15 minutes. Seek immediate medical attention.

**Ingestion:** If swallowed, give 1-2 glasses of water immediately, call physician, hospital or poison control center immediately. **DO NOT INDUCE VOMITING**

**SPILL:** Remove all source of ignition and ventilate area. Soak up spill with absorbent material. Dispose of absorbent material in accordance with regulations. Personnel cleaning the spill should wear appropriate protective equipment.

**WARRANTY:** Weld-All™ warrants that all of its new products shall be of good quality and free from defects. If any product becomes defective Weld-All™ will replace defective product at no charge. **WARRANTY IS LIMITED TO REPLACEMENT OF DEFECTIVE MERCHANDISE**

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