

## CSI 3-Part Specification for WELD-ON® 724™ Low VOC Cement for CPVC and PVC Plastic Pipe

*(Specifier Note: The purpose of this guide specification language is to assist the specifier in correctly specifying solvent cement for CPVC and PVC 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 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.
- 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 CEMENT

*(Specifier Note: Product Information is proprietary to Weld-On. Weld-On recommends the use of WELD-ON® P-70 primer.)*

### A. Basis of Design - WELD-ON CPVC 724™

#### 1. Characteristics:

- a. Color: **[Orange] [Gray]**
- b. Specific Gravity: 0.984 ± 0.040
- c. Meets 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 SOLVENT CEMENT APPLICATION

*(Specifier Note: Manufacturer recommends the use of appropriate primer, prior to application of solvent cement.)*

- A. Comply with standard practices indicated in ASTM D 2855.
- B. Apply heavy layer of solvent cement to pipe outside diameter surface.
- C. Immediately after application to outside diameter surface, apply medium layer of solvent cement to fitting socket.
- D. Assemble pipe and fitting while solvent cement is still wet.
- E. Hold joint together as recommended by manufacturer.
- F. Clean excess cement from pipe including bead around socket entrance.
- G. Avoid disturbing joint during curing.

DISCLAIMER: This guide specification language has been written as an aid to the qualified specifier and design professional. The use of this information requires the sole professional judgment and expertise of the design professional to adapt the information to the specific needs for the Owner and the Project, to coordinate with their Construction Document Process, and to meet all the applicable building codes, regulations and laws.