



PRODUCT BULLETIN ABS SOLVENT CEMENT

**PRODUCT HIGHLIGHTS: (PRODUCT CODE - AA6)**

- Medium-bodied Milky cement for use on all schedule and classes of ABS pipe and fittings up to 6" (150mm) diameter with interference fit.
- Lo-V.O.C. Solvent Cement meets California South Coast Air Quality Management District (SCAQMD) 1168/316A or BAAQMD Method 40 and various environmental requirements.
- Maximum VOC per SCAQMD 1168/316A or BAAQMD Method 40: 325 g/L

**GENERAL DESCRIPTION:**

ABS Solvent Cement Solvent cement by Bharat Pipe Industries is Milky, low VOC emission, medium bodied, medium setting, high strength cement for ABS pipe and fittings with interference fit for ABS pipe up to 6(150mm) dia.

**PHYSICAL/CHEMICAL PROPERTIES:**

Appearance: Milky Liquid  
 Viscosity: Min. 300° cps @ 73° F ± 2°  
 Relative Density:0.89  
 Shelf Life: 2 years from MFG Date

**APPLICATION:**

For all non-pressure applications.

**STANDARD TECHNICAL INFORMATION ON SOLVENT CEMENT:**

**Note: The above-mentioned performance of solvent cements is under lab conditions. There may be variance under field conditions based on weather, temperature, individual handling & pipe characteristics.**

**Average initial SET - under lab condition. Field conditions & timings may vary** initial set is the necessary time to allow before the joint can be carefully handled Allow 50% extra time during damp or humid weather.

Temperature	1/2" - 1 1/4"	1 1/2" - 2"	2 1/2" - 8"	10" - 15"	15" +
Below 5°C	10 minutes	15 minutes	12 hrs.	24 hrs.	48 hrs.
5-16°C	5 minutes	10 minutes	2 hrs.	8 hrs.	16 hrs.
16°C & Above	2 minutes	5 minutes	30 minutes	2 hrs.	4 hrs.

**Average no of joints per liter of solvent cement this is as per lab tests Field conditions may vary**

Pipe dia inch	No of joints
1/2"	300
3/4"	200
1"	125
1 1/2"	90
2"	60
3"	40
4"	30
6"	10
8"	5
10"	2-3
12"	1-2

**Joint cure schedule for testing at 15Kg pressure. 7 Kg for 10" and above** Joint cure time is necessary time to allow before the joint can be pressurized Allow 50% extra time during damp or humidweather.

Allow 2-3 times extra time for industrial applications

Temperature	1/2" - 1 1/4"	1 1/2" - 2"	2 1/2" - 8"	10" - 15"	15" +
Below 5°C	48 hrs.	96 hrs.	8 days	8 days	14 days
5-16°C	12 hrs.	24 hrs.	48 hrs.	96 hrs.	6 days
16°C & Above	6 hrs.	12 hrs.	24 hrs.	48 hrs.	72 hrs.

**AVAILABILITY:**

PRODUCT NUMBER	SIZE	(Inner carton) PACK	(Master carton) PACK	CARTON WEIGHT (KG)
AA604	4 oz./118 ml	24	96	16.00
AA608	8 oz./237 ml	24	48	12.00
AA616	16 oz./473 ml	24	24	15.20
AA632	32 oz./ 946 ml	12	12	12.50

PRODUCT NUMBER	SIZE	(Inner carton) PACK	(Master carton) PACK	CARTON WEIGHT (KG)
AA6100	100ml	24	96	16.00
AA6250	250ml	24	48	12.00
AA6500	500 ml	24	24	15.20
AA61LT	1000ml	12	12	12.50

**APPLICATION:**

Read all directions carefully before using this product. Do not breathe vapors. Use only in well ventilated areas. If forced air ventilation is used, be sure it does not cause a fire hazard from solvent vapors. If adequate ventilation cannot be provided, wear a NIOSH-approved respirator for organic solvents. Do not use or store near heat, sparks, or flames. Do not smoke, eat or drink when using. Do not take internally. Vapors may accumulate in low places and may ignite explosively. Store and use at temperature between 0oF to 110oF. At temperatures outside of this range, special care must be taken to prepare good joints and prevent exposures to solvents. Stir or shake before using; if jelly-like, don't use. Keep container closed when not in use. Avoid eye and skin contact-wear safety glasses with side shields and wear rubber gloves.

1. Square pipe ends and remove all burrs and dirt.
2. Check dry fit of pipe and fitting. Pipe should easily go 1/3 of the way into the fitting. If the pipe bottoms, it 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. Apply liberal coat of cement to pipe to the depth of the socket; leave no uncoated surface.
5. 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.
6. Assemble parts QUICKLY. Cement must be fluid. If cement surface has dried, recoat both parts.
7. Push pipe FULLY into fitting using a 1/4 turning motion until pipe bottoms.
8. Hold pipe and fitting together for 30 seconds to prevent pipe push -out-longer at low temperatures. Wipe off cuts.
9. Allow 15 minutes for good handling strength. For temperature above 60°F allow for 2-hour cure time before pressure testing up to 180 psi. Longer cure times may be required depending on pipe diameter, pressure and weather. DO NOT TEST WITH AIR.

This product is not for caustic or acidic chemical solutions. Consult Bharat Pipe Industries Technical department for more information.

**SHELF LIFE:**

2 years in tightly sealed containers from the date code of manufacture as stamped on the bottom of the container. Stability of the product is limited by the evaporation of the solvent when the container is opened. Evaporation of solvent will cause the cement to thicken and reduce its effectiveness. To be stored in cool, dry environment below 35°C.

**QUALITY ASSURANCE:**

ABS Solvent Cement by Bharat Pipe Industries is carefully evaluated to assure that consistent high quality is maintained. A batch identification code is stamped on each can and assure traceability of all materials and processes used in manufacturing this solvent cement.

**PRECAUTIONS:**

- Fire** Use dry chemical, foam, or carbon dioxide extinguisher. 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.
- Spill** Remove all sources of ignition and ventilate area. Personnel cleaning up 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. Dispose of in accordance with local regulations.
- DO NOT REUSE EMPTY CONTAINER. KEEP OUT OF REACH OF CHILDREN.**

**FIRST AID:**

- Ingestion:** If swallowed, **do not induce vomiting**. Drink Water and call a doctor or poison control immediately.  
**FIRST AID INSTRUCTIONS CALL +91 97697 19453**
- Inhalation:** If overcome with vapors, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call a physician.
- Eye Contact:** Flush with plenty of water for 15 minutes and call a physician.
- Skin Contact:** Wash skin with plenty of water and soap for at least 15 minutes. If irritation develops, get medical attention.

**SPECIAL PRECAUTION:**

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of granules or pellets of calcium hypochlorite with PVC and CPVC solvent cement and primers (including their vapors) may result in a violent chemical reaction if a water solution is not used. It is advisable to purify line by pumping water into the piping system- this solution will be nonvolatile. Furthermore, dry granules calcium hypochlorite should not be stored or used near solvent cements and primers.

**IMPORTANT NOTE:**

This product is intended for use by skilled individual at their own risk. These suggestions and data are based on information we believe to be reliable. Installer should verify for themselves that they can make satisfactory joints under varying conditions. Towards this end, it is highly desirable that they receive personal instruction from trained instructors or experienced installers. Contact Bharat Pipe Industries for additional information or instructions.

**WARRANTY:**

Bharat Pipe Industries warrants that all new Atoot products shall be good quality and free from defects in material and workmanship for shelf life as indicated on the product. If any Atoot product becomes defective, or fails to conform to our written limited warranty under normal use and storage conditions, then Atoot will, without charge, replace the non-conforming product. However, this limited warranty shall not extend to, nor shall Atoot be responsible for, damage or loss resulting from accident, misuse, negligent use, improper application, or incorporation of Atoot product in to other products. In addition, any repackaging of ATOOT products also shall void the limited warranty. Atoot shall not be responsible for, nor does this limited warranty extend to, consequential damage or incidental damage or expense, including without limitation, injury to persons or property or loss of use. Please refer to our standard ATOOT warranty for additional provisions.