



**PRODUCT BULLETIN- AC6  
ORANGE MEDIUM CPVC SOLVENT CEMENT**

**PRODUCT HIGHLIGHTS: (PRODUCT CODE - AC6)**

- Product comparable to Oatey Medium Orange.
- Premium, CPVC Solvent cement for residential and commercial hot and cold water systems.
- High performance medium set cement that delivers a strong permanent bond. Formatted for use without a primer if local codes permit.
- Medium bodied CPVC cement designed for copper tube size (CPVC) hot and cold potable water pipe and fittings up to 6" (150 mm).
- All Weather use. Recommended temperature while applying is 4 to 43 deg C

**GENERAL DESCRIPTION:**

Orange Medium CPVC Solvent cement by Bharat Pipe Industries is an orange, low VOC emission, medium bodied, medium setting, high strength cement for CPVC copper use size pipe and fittings with interference fit through 6 inch (150 mm) diameter. Formulated for use without primer if local codes permit.

**PHYSICAL/CHEMICAL PROPERTIES:**

Appearance                      Orange  
Resin                                CPVC  
Viscosity                        min. 500 cps @ 23deg C , 73o F +/-  
2oFMaximum VOC per SCAQMD 1168/316A or BAAQMD  
Method40: 490 g/LVOC

**STANDARD TECHNICAL INFORMATION ON SOLVENT CEMENT:**

**Note: The above mentioned performance of solvent cements are 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

**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 humid weather.

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

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

**AVAILABILITY:**

PRODUCT NUMBER	SIZE	(Inner carton) PACK	(Master carton) PACK	CARTON WEIGHT (KG)
AC602	2 oz./59 ml	48	96	12.00
AC604	4 oz./118 ml	24	96	16.00
AC608	8 oz./237 ml	24	48	12.00
AC616	16 oz./473 ml	24	24	15.20
AC632	32 oz./ 946 ml	12	12	12.50

PRODUCT NUMBER	SIZE	(Inner carton) PACK	(Master carton) PACK	CARTON WEIGHT (KG)
AC6050	50 ml	48	96	12.00
AC6100	100ml	24	96	16.00
AC6250	250ml	24	48	12.00
AC6500	500 ml	24	24	15.20
AC61LT	1000ml	12	12	12.50

**Also available in tubes from 10 ml to 100ml (Any Size)**

**APPLICATION:**

Orange Medium CPVC Solvent cement, by Bharat Pipe Industries, is formulated for use on cold and hot water CPVC piping systems up to 180oF (82oC) maximum in residential/commercial plumbing, recreational vehicles, mobile homes and in industrial systems. The solvent cement is applicable for use with copper tube sizes and pipe schedules.

Detailed directions on making solvent cemented joints are printed on the container label. Never use in a system using or being tested by compressed air or gases.

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.



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 1/4 turning motion until pipe bottoms.
9. Hold pipe and fitting together for 30 seconds to prevent pipe push-out-longer at cold.
10. Allow 5 minutes for good handling strength. For temperature above 60oF allow for 1 hour cure for cold water application and allow 6 hours cure for hot water applications 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.

#### STANDARDS:

- Meets ASTM F 493 and D 2846 Standards. Meets SCAQMD Rule1168/316A.
- Meets SCAQMD Rule 1168/316A.  
Meets NSF standards
- Compliant with LEED (Leadership in Energy and Environment Design).
- Compliant with ASTM F 493, ANSI Standard 14 and ANSI Standard 61 for use in potable drain, waste, vent and sewer applications.
- Meets CSA standard B 137.6 for hot and cold - water distribution systems.  
A one Step cement for use with CPVC pipe, tubing and fittings from 1/2 inch (20 mm) through 2 inch (63 mm)

#### 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:

Orange Medium CPVC 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 assures 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 7045430101**
- Inhalation:** If overcome with vapors, remove to fresh are. 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 15minutes. 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 Bharat Pipe Industries will without charge, replace the non conforming product. However, this limited warranty shall not extend to, nor shall Bharat Pipe Industries be responsible for, damage or loss resulting from accident, misuse, negligent use, improper application, or incorporation of Atoot product into other products. In addition any repackaging of Atoot products also shall void the limited warranty. Bharat Pipe Industries 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 Bharat Pipe Industries warranty for additional provisions.

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