

Typical Application

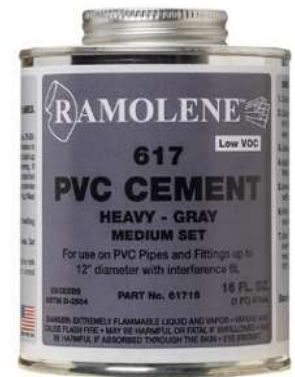
This Cement is for use on PVC pipes and fittings. This cement may be used for up to 12" pipes and fittings with interference fit for pressure applications such as potable water, irrigation and up to 14" pipes and fittings with interference fit for non-pressure applications such as drain, waste, vent, sewer, and conduit.

Product Description

Ramolene 617 is a LOW VOC, Gray, Heavy Bodied, High Strength, Medium Setting PVC Solvent Cement for all classes and schedules, except schedule 80. This cement is manufactured in the U.S.A.

Properties & Specifications

Color	Gray
Appearance	Liquid
Set Time	Medium to Slow
Cure Time	Consult ASTM Schedule
Performance	Meets ASTM D-2564 specifications
VOC emissions	386 g/L per SCAQMD Rule 1168, Test Method 316A
Shelf Life	3 years



This cement has passed the following tests performed according to ASTM Standard D-2564 at 73 °F (22.77 °C)

02 Hour Hydrostatic Burst Test	400 psi	(27.58 Bar)
02 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	Can Type
¼ Kg	¼ Pint	4 Fl Oz	118 mL	61704	24	Can with brush in cap
¼ Kg	½ Pint	8 Fl Oz	237 mL	61708	24	Can with brush in cap
½ Kg	1 Pint	16 Fl Oz	473 mL	61716	12	Can with brush in cap
1 Kg	1 Quart	32 Fl Oz	946 mL	61732	12	Can with brush in cap

Cure Time Guide

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

Temp. Range	Pipe Size ½" to 1 ¼"		Pipe Size 1 ½" to 3"		Pipe Size 3" to 6"		
	°F	up to 180 psi	181 psi - 370 psi	up to 180 psi	181 psi to 315 psi	up to 180 psi	181 psi to 315 psi
60 - 100		1 hour	6 hours	2 hours	12 hours	6 hours	24 hours
40 - 60		2 hours	12 hours	4 hours	24 hour	12 hours	48 hours
10 - 40		8 hours	12 hours	16 hours	96 hours	48 hours	8 days

Directions For Use

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

*Store in shaded and well-ventilated area below 110 °F / 43 °C.

* 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 ⅓ to ½ 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 Pipe Cleaner. Primer is highly recommended for 3" and larger diameter installation. Apply liberal coat. Primmer will start softening surface of pipe and fitting thus ensuring superior joint.
4. Use applicator supplied with the can or suitable applicator at least ½ 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 °C or 60 °F. Longer cure time may be required for larger pipe and or temperature is below 16 °C or 60 °F.

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 buildup 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 or milk 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.