
 Ramtech Overseas, Inc 5017 West Laurel Street, Tampa, FL 33607, USA	<b>PVC CEMENT CLEAR No. 616</b> <b>Medium Body – Fast Set</b> V.07.20	 <b>MADE IN U.S.A.</b>
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**DESCRIPTION:**

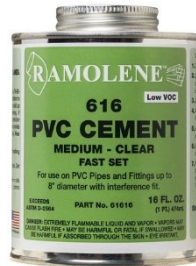
Ramolene™ 616 for PVC™ is a LOW VOC, Clear, Medium Bodied, High Strength, Fast Setting PVC Solvent Cement for all classes and schedules. This cement is manufactured in the U.S.A.

**APPLICATION:**

This Cement is for use on PVC pipes and fittings. This cement may be used for up to 8” pipes and fittings with interference fit for pressure applications such as potable water, irrigation and up to 10” pipes and fittings with interference fit for non-pressure applications such as drain, waste, vent, sewer, and conduit.

**PROPERTIES AND SPECIFICATIONS:**

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



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

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	
1/4 Pint / 4 Fluid Oz / 118 ml	61604	24	Can with brush in cap
1/2 Pint / 8 Fluid Oz / 237 ml	61608	24	Can with brush in cap
1 Pint / 16 Fluid Oz / 473 ml	61616	12	Can with brush in cap
1 Quart / 32 Fluid Oz / 946 ml	61632	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 - °F	Pipe size 1/2” to 1 ¼”		Pipe size 1 ½” 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
60 to 100	1 Hour	6 Hours	2 Hours	12 Hours	6 Hours	24 Hours
40 to 60	2 Hours	12 Hours	4 Hours	24 Hours	12 Hours	48 Hours
10 to 40	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 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 degrees Celsius or 60 degrees Fahrenheit. Longer cure time may be required for larger pipe and or temperature is below 16 degrees Celsius or 60 degrees 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 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.

**WARRANTY:** WARRANTY IS LIMITED TO REPLACEMENT OF DEFECTIVE MERCHANDISE.