

Carlon® Cement

(MSDS sheets available at www.carlon.com)



Medium Bodied Clear PVC Solvent Cement with dauber

Part No.	Size	Std. Ctn. Qty.
VC9964	1/2 Pint	10
VC9963	Pint	24
VC9962	Quart	12
VC9961P	Gallon	6

Recommended pipe application and sizes

Recommended for all grades and types of Carlon PVC conduit, duct, wireway and fittings, except Flex-Plus® Blue™ ENT (Electrical Nonmetallic Tubing.)
Up through 6" diameter.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
10°-30°F Not recommended 30°-50°F 5-6 minutes 50°-70°F 3-4 minutes 70°-90°F 1-2 minutes	40° to 100°F	2 hrs. 350 psi 16 hrs. 800 psi 72 hrs. 1,500 psi	500-900 cps



Medium Bodied Gray PVC Solvent Cement with dauber*

Part No.	Size	Std. Ctn. Qty.
VC9924-24	1/2 Pint	24
VC9923	Pint	24
VC9922	Quart	12
VC9941P	Gallon	6

Recommended for all grades and types of Carlon PVC conduit, duct, wireway and fittings, except Flex-Plus® Blue™ ENT (Electrical Nonmetallic Tubing.)
Up through 6" diameter.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
10°-30°F Not recommended 30°-50°F 5-6 minutes 50°-70°F 3-4 minutes 70°-90°F 1-2 minutes	40° to 100°F	2 hrs. 350 psi 16 hrs. 800 psi 72 hrs. 1,500 psi	500-900 cps



All-Weather "Quick-Set" Clear Solvent Cement with dauber*

Part No.	Size	Std. Ctn. Qty.
VC9984	1/2 Pint	10
VC9983	Pint	24
VC9982	Quart	12
VC9981P	Gallon	6

Recommended for all grades and types of Carlon PVC conduit, duct, wireway and fittings, except Flex-Plus® Blue™ ENT (Electrical Nonmetallic Tubing.)
Up through 6" diameter.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
10°-30°F 4-5 minutes 30°-50°F 3-4 minutes 50°-70°F 1-2 minutes 70°-90°F 1/2-1 1/2 minutes	-5° to 100°F	2 hrs. 350 psi 16 hrs. 800 psi 72 hrs. 1,500 psi	400-700 cps



All-Weather ENT Blue "Quick-Set" Solvent Cement with brush*

Part No.	Size	Std. Ctn. Qty.
VC9992	Quart	12

Required for use with Flex-Plus® Blue™ ENT (Electrical Nonmetallic Tubing), Riser-Gard®, P&C Flex®, and Carlon PVC fittings.
Up through 4" diameter.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
10°-30°F 4-5 minutes 30°-50°F 3-4 minutes 50°-70°F 1-2 minutes 70°-90°F 1/2-1 1/2 minutes	4° to 100°F	2 hrs. 350 psi 16 hrs. 800 psi 72 hrs. 1,500 psi	400-700 cps



Low VOC Gray PVC Solvent Cement with dauber*

Part No.	Size	Std. Ctn. Qty.
VC9LV4	1/2 Pint	10
VC9LV3	Pint	24
VC9LV2	Quart	12

Recommended for all grades and types of Carlon PVC conduit, duct, wireway and fittings, except Flex-Plus® Blue™ ENT (Electrical Nonmetallic Tubing.)
Up through 6" diameter.
VOC emission of 490 grams/liter per the Bay and South Coast test method.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
10°-30°F Not recommended 30°-50°F 5-6 minutes 50°-70°F 3-4 minutes 70°-90°F 1-2 minutes	40° to 100°F	2 hrs. 350 psi 16 hrs. 800 psi 72 hrs. 1,500 psi	500-900 cps



Clear Primer with dauber

Part No.	Size	Std. Ctn. Qty.
VC9903	Pint	24
VC9902	Quart	12
Purple:		
VC9932	Quart	12

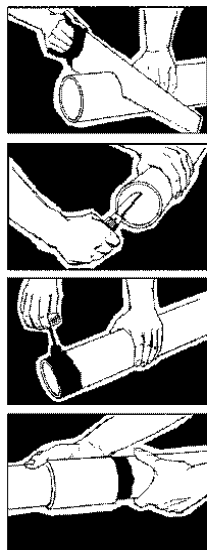
Recommended for use with Carlon cement and all types and sizes of Carlon WireSafe® wireway.

Set-up time (Evaporation Rate)	Recommended installation temperature	Lap Shear @ 73°F	Viscosity at 75° as manufactured
N/A	5° to 100°F	N/A	N/A

*Meets ASTM D2564

*No daubers for gallon cans

Cement Joints



Carlson nonmetallic products are joined by means of solvent cement joints. Sizes 1/2" through 1 1/2" should be cut square (using a fine tooth handsaw) and deburred. For sizes 2" through 6" a miter box or similar saw guide should be utilized to keep the material steady. After cutting and deburring, wipe ends clean of dust, dirt and shavings.

Joining process as follows: Be sure that conduit end is clean and dry. Apply coat of Carlson Solvent Cement (use dauber) to end of conduit, the length of the socket to be attached. Push conduit firmly into fitting

while rotating conduit slightly about one-quarter turn to spread cement evenly. Allow joint to set approximately 10 minutes.

Carlson recommends the use of Carlson cement for proper solvent cement joints. Since this cement is prepared particularly for our product compounds and tolerances, we cannot guarantee joints assembled with cement materials supplied by other manufacturers. Regular grade grey solvent cement will accommodate most application situations being of a general purpose nature. In situations requiring an extremely fast-setting joint, (low temperature or difficult installation conditions) Carlson All Weather Quick-Set Cement is recommended. Standard grade clear cement is recommended for noncritical utility applications where gap filling and leak testing are not required.

Average number of joints per can

Pipe size	1/2 Pint	Pint	Quart	Gallon
1/2	140	275	550	2,200
3/4	90	180	360	1,440
1	70	140	280	1,120
1 1/4	50	100	200	800
1 1/2	37	75	150	600
2	20	40	80	320
2 1/2	17	35	70	280
3	15	30	60	240
3 1/2	13	27	54	216
4	12	25	50	200
5	9	19	38	150
6	6	12	24	95

Average shelf-life of all Carlson cement is 24 months (unopened cans stored below 80°F.)

All Carlson cements are specially formulated to be used with Carlson PVC products, and do not require primers when parts are dean of dirt and moisture.



Cementing PVC Conduit:

1. Make square saw cut with fine tooth saw.
2. Deburr and round inside edge of the cut end.
3. Clean socket ID and spigot OD of dirt and moisture.
4. Apply a uniform coat of cement to spigot end and push onto socket bottom, rotating 1/4 turn.
5. Allow time to set before disturbing. This will depend upon temperature.

Cementing PVC Conduit for Submerged Areas Requiring Air or Water Tightness:

1. Follow the procedure to the left for cementing conduit.
2. Test workmanship by conducting a low pressure air (3.0 - 5.0 psi) test after system is installed and cemented joints are set.
3. Plug and block ends to prevent movement prior to pressurization.
4. Check for leaks with soap solution.
5. Even low pressure air can cause high thrust loads and caution must be observed.



Cementing ENT for Concrete-Tight Applications:

1. Use Carlson Socket tight fittings or couplings.
2. **Do not** use chemical primer or cleaner.
3. Apply a light uniform coat of cement, labeled for use with ENT.
4. **A brush** shall be used to apply the cement.
5. Brush excess cement out of ENT grooves
6. Promptly insert ENT into fitting while cement is wet, until the fitting stop is reached, and give 1/4 turn.
7. Do not disturb until the joint is set.