



PVC FITTINGS

EST. 1976



www.nacopvc.com

Effective Date: January 30, 2012

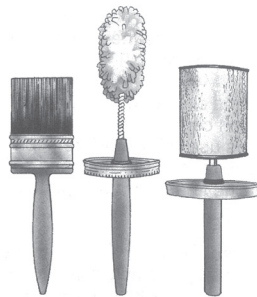
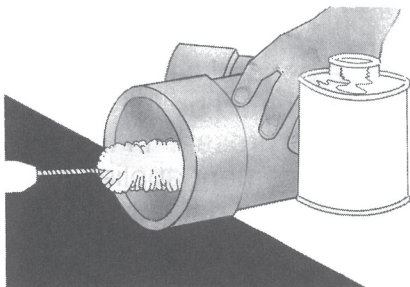


Solvent Cements

IPS Weld-On®

Section 29

NACO Industries certifies that our Solvent Cements provided by IPS-Weld On® meet or exceed applicable ASTM standards. For a list of these standards, please contact our corporate office.








NACO Industries
395 West 1400 North
Logan, UT 84341
Phone 435-753-8020
Toll Free 800-445-4151
Fax 435-752-7041
(Corporate)






Before installing any PVC piping or fitting product, you should consult a qualified Project Engineer with experience designing PVC piping, and/or drainage systems. NACO Industries does not assume the responsibility of the Engineer. DO NOT use NACO Industries' fittings to transport or store compressed air or gases, or test thermoplastic piping systems with compressed air or gases.

NACO Industries, a Division of Heritage Products Group, Inc.



IPS Weld-On Glue and Primer

Item:	Size:	Part Number:	Case Qty.	List Price:
PVC 717 Clear, Heavy Bodied, Medium Setting, Up to 12" All Classes and Schedules				
	Pint	65120037-	12	Call
	Quart	65120038-	12	Call
	Gallon	65120039-	6	Call
PVC 717 Gray, Heavy Bodied, Medium Setting, Up to 12" SCH40 & SCH80, Up to 18" Non-pressure Applications				
	Pint	65120006-	12	Call
	Quart	65120007-	12	Call
	Gallon	65120008-	6	Call
PVC 711 Gray, Heavy Bodied, Medium Setting, Up to 12" All Classes and Schedules				
	Pint	65120040-	12	Call
	Quart	65120041-	12	Call
	Gallon	65120042-	6	Call
PVC 719 Gray, Extra Heavy Bodied, Slow Setting, Up to 30" All Classes and Schedules				
	Quart	65120010-	12	Call
	Gallon	65120009-	6	Call
PVC 719 White, Extra Heavy Bodied, Slow Setting, Up to 30" All Classes and Schedules				
	Pint	65120012-	12	Call
	Quart	65120005-	12	Call
	Gallon	65120004-	6	Call

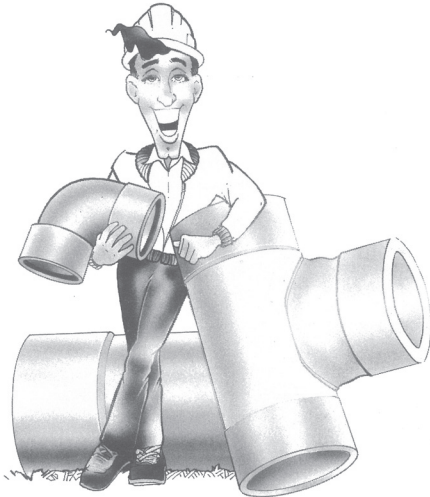
Item:	Size:	Part Number:	Case Qty.	List Price:
P-70 Low VOC Purple Primer for all PVC and CPVC				
	Pint	65121002-	12	Call
	Quart	65121003-	12	Call
	Gallon	65121004-	6	Call
P-70 Low VOC Clear Primer for all PVC and CPVC (Very Aggressive)				
	Pint	65121006-	12	Call
	Quart	65121007-	12	Call
	Gallon	65121008-	6	Call
C-65 Low VOC Clear Cleaner for PVC / CPVC / ABS / Styrene				
	Pint	65121010-	12	Call
	Quart	65121011-	12	Call
	Gallon	65121012-	6	Call
C-64 Low VOC Purple Primer-Cleaner for PVC & CPVC				
	Pint	65121013-	12	Call
	Quart	65121014-	12	Call
	Gallon	65121015-	6	Call
810 A&B White Two Component Reactive Adhesive for PVC, CPVC and Dissimilar Materials				
	4 oz.	65122000-	12	Call
	Pint	85122003-	12	Call
	Quart	65122001-	6	Call

IPS Weld-On® Solvent Cement and Primers. Read and follow all manufacturer's instructions. It is important to make sure you are using the right cement for the job, and the correct size applicator.

Sold In Case Quantities Only - \$250 Minimum Order On All Solvent Cements

Installation Guide for PVC Pipe and Fittings

System Design

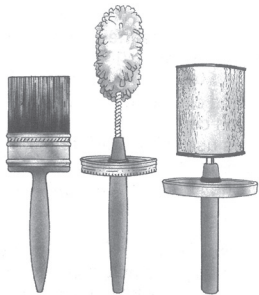
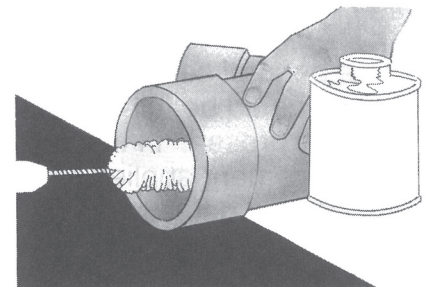


Before making any installation, **take some time to make sure your piping system has been engineered and designed properly. NACO Industries does not assume the responsibility of the Engineer.**

Make sure you have taken into consideration general design principles like friction loss, water velocity, adequate pump horsepower, air evacuation (pressure relief valves and air relief valves), elevation, water hammer, grade changes and temperature changes. It saves so much time, money and resources to do the job right the first time.

Solvent Weld Pipe and Fittings

When using solvent weld pipe and fittings, the objective is to create an actual chemical weld between the two pieces of plastic. The joints are not just “glued”; they actually become chemically welded.



Use a quality solvent cement and primer and read and follow all manufacturer’s instructions. It is important to make sure you are using the right cement for the job, and the correct size applicator.

Too thin a layer too slowly applied = “Dry Joint”

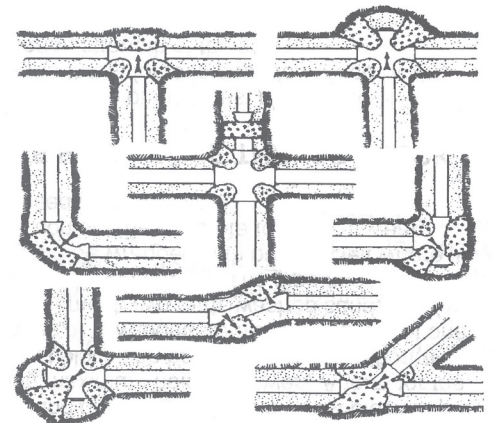
Cement Usage

Recommended Cement Use – Joints Per Quart of Solvent Cement

Size	4"	6"	8"	10"	12"	15"	18"	21"	24"	27"
Joints	30	20	10	6	4	3	1½	1	¾	½

Thrust Blocking

Thrust blocking must be used for all changes in direction, such as elbows and tees, and for changes in size when reducers are placed in line. The amount of force developed increases with the angle of deflection. The larger the reduction the more force developed. The amount of internal pressure, plus the forces created by the direction change must be restrained.





Water Hammer

When a pipe contains a column of moving liquid, there is considerable kinetic energy stored in the liquid by virtue of its mass and velocity. If the velocity is suddenly destroyed (by the quick closing of a valve) this energy cannot be absorbed, since the liquid is nearly incompressible and, therefore, appears as an instantaneous shock which may represent excessively high pressures, known as water hammer. Water hammer can cause damage, and failure to pipe, valves, and fittings within a piping system. It's important to take into consideration the avoidance of excessive water hammer during the engineering and design of your piping system.



Temperature Changes

When temperatures rise above 73° F, the tensile strength of thermoplastics decreases, thereby derating the pipe or fitting Maximum Internal Pressure. When temperatures fall below 73° F, the tensile strength of thermoplastics increases, however, the impact strength decreases.

Air Entrapment

Air trapped in the line reduces the capacity of the pipe to carry water. Compressed air in a pipeline can reach pressures far in excess of the static pressure of the line. The best way to control air in the line is to restrict air from entering the system, provide adequate air relief valves, and proper filling and testing of the piping system.

DO NOT USE WITH COMPRESSED AIR OR GASES

DO NOT use NACO Industries' fittings to transport or store compressed air or gases, or test thermoplastic piping systems with compressed air or gases. The use of compressed air or gases may result in explosive fragmentation of the piping system.



THE BEST TIME TO DO THE JOB RIGHT IS THE FIRST TIME !