



# ARCTIC™ 616L

## Low-VOC PVC Solvent Cement

[Description](#) | [Characteristics](#) | [Applications](#) | [Packaging](#) | [Instructions](#) | [Precautions](#) | [Specifications](#) | [Limited Warranty](#)

### DESCRIPTION:

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Arctic™ 616L is a premium polyvinyl chloride (PVC) solvent cement used for joining PVC pipe and socket-type fittings through 6" for Schedule 40 and 1-1/4" for Schedule 80. Max VOC per SCAQMD 1168/316A or BAAQMD method 40: 510 g/l.

Arctic™ is a clear, medium body cement that is specifically formulated to give optimum solvent welding penetration of pipe and fitting surfaces under low temperature conditions for maximum bond strength.

[Top of Page](#)

### CHARACTERISTICS:

- Specifically designed for use in cold weather
- NSF approved for potable water
- UPC (IAPMO) listed under File No. 1796
- Exceed ASTM D 2564 specifications
- Remains stable from 0 degree F to 120 degree F - can be used year-round
- Medium body - reduces product run-off and has excellent gap filling characteristics
- LEED Compliant

[Top of Page](#)

### APPLICATIONS:

Arctic™ 616L is formulated for use on all PVC pipe applications such as potable water, pressure pipe, gas, conduit, sewers, and drain, waste and vent (DWV). It is for use on PVC pipe through 6" Schedule 40 and 1 1/4" Schedule 80.

Special Note - All solvents evaporate slower at lower temperatures. Even though Arctic™ 616L will dry at temperatures below 40 degree F, the colder the temperature, the slower the drying rate. The PVC joint cure schedule for cold weather listed in ASTM D 2855 can be used as a guideline for drying times for Arctic™ 616L for

application at temperatures below 40 degree F. Extreme care should be exercised on all joints made in temperatures below 10 degree F.

[Top of Page](#)

### PACKAGING:

Code	Size	Qty. Per Case	Lbs. per Case	Cu. Ft Per Case
55900	1/4 pint dauber top (118 ml)	24 cans	10	.18
55909	1/2 pint dauber top (237 ml)	24 cans	15	.45
55919	Pint dauber top (473 ml)	12 cans	15	.43
55948	Quart dauber top (946 ml)	12 cans	28	.78
55953	Gallon can (3.8 L)	4 cans	34	.80

[Top of Page](#)

### INSTRUCTIONS:

1. Store between 0 degree F and 120 degree F. Do not thin or use if cement has become curdled, lumpy, thickened.
2. Wear non-permeable gloves during application to avoid skin contact.
3. Clean fitting socket and pipe and check for proper fit. Apply PRIMER to all PVC surfaces. While still wet, quickly begin solvent cement application.
4. Shake well before using and stir frequently while using. Apply with supplied dauber applicator. For pipe greater than 2" diameter, use natural bristle brush sized to 1/2 of the pipe diameter.
5. Apply thin coat evenly to socket. Quickly apply heavy coat to pipe end. While wet, quickly insert pipe into fitting with slight twisting movement until it bottoms out.
6. Hold pipe into fitting for at least 30 seconds to prevent pipe from backing out of tapered socket.
7. Wipe excess cement from joint with rag. Allow 15 minutes before handling. Avoid full-line pressure for 24 hours. Cure time varies with size, fit, temperature and humidity. **When using below freezing, allow extra drying time.**

For additional technical information, call Toll Free 1-800-231-3345.

[Top of Page](#)

### PRECAUTIONS:

FOR CHEMICAL EMERGENCY, SPILL, LEAK, FIRE, EXPOSURE OR ACCIDENT, CALL CHEMTREC - DAY OR NIGHT 1-800-424-9300

**D A N G E R!**

VAPORS EXTREMELY FLAMMABLE  
VAPORS ARE HEAVIER THAN AIR AND CAN COLLECT IN LOW AREAS

VAPORS MAY CAUSE FLASH FIRE

**CONTAINS: Methyl Ethyl Ketone, Tetrahydrofuran, Cyclohexanone and Acetone. PRECAUTIONS:** Vapors extremely flammable. Harmful if swallowed or inhaled. Causes eye and skin irritation. Keep away from heat, sparks, and flames until vapors are gone. Use only with good cross-ventilation. Wear adequate protective gear and clothing. Avoid breathing vapors and contact with skin, eyes and clothing. Long term repeated overexposures to solvents may cause damage to the brain, nervous system, reproductive system, respiratory system, mucous, liver, and kidneys. Wash after handling. **FIRST AID:** For any overexposure, get immediate medical attention after first aid is given. **Eyes** - Flush 15 minutes with clean water. **Skin** - Wash with soap and water. **Inhalation** - Remove to fresh air. **Ingestion** - DO NOT INDUCE VOMITING. Only if conscious, give large amounts of water. **FIRE AND SPILLS:** For fire, use water fog, CO<sub>2</sub>, foam, or dry chemicals. Clean up spills immediately with inert absorbents. **STORAGE AND HANDLING:** Store in cool, well-ventilated area. Keep container upright and tightly closed. Do not reuse empty container. **KEEP OUT OF REACH OF CHILDREN.**

For additional information, refer to Material Safety Data Sheet.

[Top of Page](#)

**SPECIFICATIONS:**

Wt/Gal @ 77 degree F	7.7+- .2 lbs/gal.
Flash Point SETA CC	3 degree F
Color	Clear
Shelf Life	2 years



Suggestions and recommendations covering the use of our products are based on our past experience and laboratory findings. However, as we have no control as to the methods and conditions of application, we only assume responsibility for the uniformity of our products within manufacturing tolerances.

[Top of Page](#)

**LIMITED WARRANTY:**

RectorSeal® makes the Limited Express Warranty that when the instructions for storage and handling of our products are followed we warrant our products to be free from defects. THIS LIMITED EXPRESS WARRANTY IS EXPRESSLY IN LIEU OF ANY OTHER EXPRESS OR IMPLIED WARRANTIES, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, AND OF ANY OTHER OBLIGATION ON THE PART OF RECTORSEAL®. The sole remedy for breach of the Limited Express Warranty shall be the refund of the purchase price. All other liability is negated and disclaimed, and RectorSeal® shall not be liable for incidental or consequential damages.

[Top of Page](#)

MANUFACTURED BY

## **RectorSeal®**

2601 Spenwick Drive • Houston, TX 77055 USA

713-263-8001 • Fax 713-263-7577

Toll-free 800-231-3345 • Fax 800-441-0051

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[Back to Solvent Cements](#)