

Selection, Design & Installation Basics
Solvent Cement Selection Chart



Spears Solvent Cement & Primer Selection Guide

Type	Body	Spears®/IPS Cross Reference		Color	Relative Set	Capacity	Features
		Spears®	IPS				
PVC	Regular	PVC-00	700	Clear	Fast	Schedule 40 - 4"	
		PVC-02	702	Clear	Fast	Schedule 40 - 4"	Dries Clearest, slightly thicker than PVC-00
	Medium	PVC-05	705 (Not in Gray)	Clear/Gray	Fast	All Classes & Schedule 40 - 6" Schedule 80 - 4"	Industrial Duty Primerless Capability ¹
		PVC-21	721	Blue	Fast	Schedule 40 - 6" Schedule 80 - 4"	Primerless Capability ¹
	Heavy	PVC-11	711	Gray	Medium	All Classes & Schedules - 12"	Industrial Duty
		PVC-17	717	Clear/Gray	Medium	All Classes & Schedules - 12" Non-pressure - 18"	Industrial Duty
	Extra Heavy	PVC-19	719	White/Gray	Slow	All Classes & Schedules Requiring High Gap Filling - 30"	Industrial Duty
	Specialty Cements	PVC-25	725	Aqua Blue	Very Fast	All Classes & Schedule 40 - 6" Schedule 80 - 4"	Wet-N-Dry Formulation Primerless Capability ¹
		PVC-26	747	Blue	Very Fast	All Classes & Schedule 40 - 6" Schedule 80 - 4"	POOL-PRO™ Formulation for Pool & Spa Primerless Capability ¹ . Fades to clear as it cures.
		PVC-27	727	Clear	Very Fast	All Classes & Schedule 40 - 6" Schedule 80 - 4"	Cold-N-Hot Formulation - 15°F to 100°F Primerless Capability ¹
		PVC-37	737	Blue	Very Fast	All Classes & Schedules - 6" Schedule 80 - 4"	Formulated for Wet Conditions Primerless Capability ¹
		PVC-50	750	Blue	Very Fast	Schedule 40 - 6" Schedule 80 - 4"	HOT PVC Formulation Primerless Capability ¹
		PVC-95	795	Clear/ Blue	Fast	All Classes & Schedule 40 - 6" Schedule 80 - 4"	Flexible PVC for Flex-Flex, Flex-Rigid Joints
	LX-5	N/A	Clear	Fast	Low Extractable PVC Systems - 6"	One Step ² Low Extractable, High Purity Cement	
CPVC	Specialty Cements	CPVC-24	724	Gray/ Orange	Medium	All Classes & Schedules PVC or CPVC - All Sizes	Most Versatile, Chemically Resistant Cement for both CPVC & PVC Systems - including Duct - Industrial Duty
		LW-5	N/A	Mustard	Medium	Lab Waste™ CPVC Drainage Systems - 24"	One Step ² Cement - Only LabWaste™ System Chemically Approved Cement
		FS-5	N/A	Red	Fast	CPVC Fire Sprinkler Systems - 3"	One-Step ² Cement for all CPVC Fire Sprinkler Systems
		CTS-5	FlowGuard Gold	Yellow	Fast	CTS CPVC Systems - 2"	One-Step ² Cement for all CTS CPVC Systems
ABS	Medium	ABS-71	771	Yellow/Milk	Fast	All ABS Classes & Schedules - 8"	
		ABS-73	773	Black	Fast	All ABS Classes & Schedules - 8"	
Transition & Multipurpose	Medium	ABS TO PVC-94	794	Green	Fast	All Classes & Schedules - 6" (Except Schedule 80)	For ABS-to-PVC Transition Joints
		MULTIPURPOSE-90	790	Clear	Fast	All Classes & Schedules - 6" Schedule 80 - 4"	For PVC and CPVC pressure ABS and Styrene low-pressure systems
Primers & Cleaners	Primer-75	P-75	Aqua Blue		All Classes, Schedules & Sizes PVC & CPVC	Formulated for Wet Conditions Industrial Duty	
	Primer-70	P-70	Purple/ Clear		All Classes, Schedules & Sizes PVC & CPVC	Industrial Duty	
	Primer-68	P-68	Purple/ Clear		All Classes, Schedules & Sizes PVC & CPVC		
	Cleaner-65	C-65	Clear		All Classes, Schedules & Sizes PVC & CPVC	For PVC, CPVC, ABS or Styrene	
	Primer Cleaner-64	PC-64	Purple		All Classes, Schedules & Sizes PVC & CPVC		

Notes

1= Primerless Capability indicates a cement can be used without primer in certain applications if local code permits. See specific cement information for further restrictions.
 2 = One Step designates a cement specifically designed for use without primer. CTS One Step acceptability depends on local code requirements.
 CTS = Copper Tube Size, ASTM D2846 Hot and Cold Water Distribution Systems.