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| <br>Ramtech Overseas, Inc<br>5017 West Laurel Street, Tampa, FL 33607, USA | <b>No. 614</b><br><b>CPVC CEMENT – ORANGE</b><br>Heavy Body – Medium Set | <br><b>MADE IN U.S.A.</b> |
|---|--|--|

**DESCRIPTION:**

Ramolene™ 614 for CPVC™ is a LOW VOC, Orange, Heavy Bodied, High Strength, Medium Setting CPVC Solvent Cement for all classes and schedules. This cement is manufactured in the U.S.A.

**APPLICATION:**

This Cement is for use on CPVC pipes and fittings. This cement may be used for up to 12” pipes and fittings with interference fit for pressure such applications as potable water, irrigation and up to 14” pipes and fittings with interference fit for non-pressure applications such as drain, waste, vent, sewer, and conduit. This cement can be used for HOT and COLD water applications and is approved for use on **Flow Guard Pipes and Fittings.**

**PROPERTIES AND SPECIFICATIONS:**

|               |                                 |
|---------------|---------------------------------|
| Color         | Orange                          |
| Appearance    | Liquid                          |
| Set Time/Fast | Medium                          |
| Cure Time     | Consult ASTM schedule           |
| Exceeds       | ASTM D-2846 F-493 specification |
| Shelf Life:   | 2 years                         |



This cement has passed the following tests performed according to ASTM Standard D-2846 and F-493

|                               |         |             |
|-------------------------------|---------|-------------|
| 2 hour Hydrostatic Burst Test | 400 psi | (27.58 Bar) |
| 2 Hour Lap Shear Test         | 250 psi | (17.24 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 | 61404   | 24           | Can with brush in cap |
| 1/2 Pint / 8 Fluid Oz / 237 ml | 61408   | 24           | Can with brush in cap |
| 1 Pint / 16 Fluid Oz / 474 ml  | 61416   | 12           | Can with brush in cap |
| 1 Quart / 32 Fluid Oz / 946 ml | 61432   | 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 ½” 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. Primer will start softening surface of pipe and fitting thus ensuring superior joint.
4. Use applicator supplied with the can or suitable applicator at least 1/2 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