



**GENERAL DESCRIPTION:** STRONG WELD 319 is an industrial grade, gray or white, low VOC emission, extra heavy bodied, slow setting, thixotropic (pastelike), high strength PVC solvent cement for all classes and schedules of pipe and fittings with interference fit through 30 inch (800 mm) diameter, including Schedule 80.

**APPLICATION:** STRONG WELD 319 is for use on all types of PVC plastic pipe applications, Type I and Type II. STRONG WELD 319 white is ideally suited for the fabrication of PVC fittings (particularly large diameter) as it has excellent gap filling properties. The slow set time also makes this cement outstanding for use with large diameter pipe in hot weather. STRONG WELD 319 gray is suitable for use with irrigation, conduit, industrial pipe and many other pressure and non-pressure large diameter pipe applications.

**AVAILABILITY:**

Gray cement is available in quart (946 ml) and gallon (3.785 l) metal cans. White cement is available in 10.3 oz. cartridge, pint (473 ml), quart (946 ml) and gallon (3.785 l) metal cans. For detailed information on containers and applicators, see our current Price List.

**STANDARDS AND CERTIFICATION LISTINGS:**

PW/DWW/SW



DWW/SW

- Meets ASTM D 2564 Standard.
- Meets SCAQMD Rule 1168/316A.
- Compliant with LEED® (Leadership in Energy and Environmental Design). When using this STRONG WELD Low VOC product, credit can be claimed for LEED Green Building Rating System - Indoor Environmental Quality.
- Listed by NSF International for compliance with ASTM F 656, NSF/ANSI Standard 14 and NSF/ANSI Standard 61 for use in potable water, drain, waste, vent and sewer applications.
- **Gray Cement Only** - Meets CSA standards B137.3 and B181.2 for use in pressure and non-pressure potable water, drain, waste, and vent applications.

**SPECIFICATIONS:**

COLOR:	Clear	Gray	White
RESIN:	PVC	PVC	PVC
SPECIFIC GRAVITY:	0.981 ± 0.040	0.981 ± 0.040	0.981 ± 0.040
BROOKFIELD VISCOSITY:	Minimum 2000 cP	Minimum 20,000 cP	Minimum 2,10,000 cP

**SHELF LIFE:**

3 years in tightly sealed containers. The date code of manufacture is stamped on the bottom of the container. Stability of the product is limited by the evaporation of the solvent when the container is opened. Evaporation of solvent will cause the cement to thicken and reduce its effectiveness. Adding of thinners to change viscosity is not recommended and may significantly change the properties of the cement.

**QUALITY ASSURANCE:**

STRONG WELD 319 is carefully evaluated to assure that consistent high quality is maintained. Fourier transform infrared spectroscopy, gas chromatography, and additional in depth testing ensures each batch is manufactured to exacting standards. A batch identification code is stamped on each can and assures traceability of all materials and processes used in manufacturing this solvent cement.

**SPECIAL PRECAUTION:**

STRONG WELD solvent cements must never be used in PVC or CPVC piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with flue gas ventilation systems.

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of granules or pellets of calcium hypochlorite with PVC or CPVC solvent cements and primers (including their vapors) may result in a violent chemical reaction if a water solution is not used. It is advisable to purify lines by pumping chlorinated water into the piping system – this solution will be nonvolatile. Furthermore, dry granular calcium hypochlorite should not be stored or used near solvent cements and primer





## PRODUCT BULLETIN

# 319 PVC

## INDUSTRIAL GRADE

Low VOC PVC SOLVENT CEMENT

This product is intended for use by skilled individuals at their own risk. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Detailed directions on making solvent cemented joints are printed on the container label. It is highly recommended that the installer review the instructions supplied by the pipe and fitting manufacturer.

***Refer to the current STRONG WELD 319 Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information***

### WARRANTY:

HP ADHESIVES LIMITED ("HPA"), warrants to all original purchasers of HPA products that all new HPA products shall be of good quality and free from defects in material and workmanship for the product's shelf life. If any HPA product becomes defective, or fails to conform to this written limited warranty under normal use and storage conditions, and if the original purchaser complies with the terms of this limited warranty, then HPA will, without charge, replace the nonconforming product.

This limited warranty shall extend to all products manufactured and sold by HPA. However, this limited warranty shall not extend to, nor shall HPA be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of HPA products into other products. In addition, any repackaging of HPA products also shall void the limited warranty provided herein.

Any defective HPA products shall be replaced pursuant to the terms of this limited warranty by returning the defective product, with transportation charges prepaid, to HPA at the following address:

HP ADHESIVES LIMITED  
11 Unique House, Chakala Road,  
Andheri (East), Mumbai  
400099 INDIA

Any implied warranty in connection with any HPA product hereby is limited in duration to the period of this limited warranty. HPA shall not be responsible for, nor does this limited warranty extend to, consequential damage, or incidental damage or expense, including without limitation, injury to persons or property or loss of use. This limited warranty is in lieu of all other express warranties of HPA, and HPA does not assume, nor does it authorize any person to assume on its behalf, any other obligation or liability.



+91-22-68196300



[sales@hpadhesives.com](mailto:sales@hpadhesives.com)



[www.hpadhesives.com](http://www.hpadhesives.com)



HP ADHESIVES LIMITED  
11, Unique House, Chakala Rd,  
Andheri (East), Mumbai - 400 099.