



GENERAL DESCRIPTION: STRONG WELD 394 Transition, is a green, low VOC emission, medium bodied, fast setting, high strength ABS to PVC transition solvent cement. It is specifically formulated for joining ABS to PVC transition joints only in non-pressure systems for all classes and schedules, except Schedule 80. It is used for pipe and fitting with an interference fit through 6 inch (160 mm) diameter. It is intentionally colored green so the proper use of this cement can be verified.

APPLICATION: STRONG WELD 394 Transition, can be used in sewer, drain, waste and vent systems, conduit, etc. Because of the large variety of ABS to PVC materials being used, suitability of this cement should be verified by users for specific combination of materials. Transition cement may not be approved for use inside a building - consult local code. Apply primer only to PVC material. **Do not** apply primer on the ABS side of the transition joint. **CAUTION:** Where the fitting is ABS, take special care to avoid puddling excess cement inside the fitting.

When joining similar piping materials (PVC to PVC, ABS to ABS) use cements specifically recommended for that purpose to obtain good compatibility, high joint strength and long-term durability of the system, as well as to maintain certification of the pipe installation per local code.

Detailed directions on making solvent cemented joints are printed on the container label. An installation DVD/CD covering solvent cementing is available. It not only describes the basic principles of solvent cementing, but also covers the handling, storage and use of our products. It is highly recommended that the installer review the instructions supplied by the pipe and fitting manufacturer.

NOTE: STRONG WELD solvent cements must never be used in a PVC system using or being tested by compressed air or gases; including air-over-water booster

AVAILABILITY: This product is available in ¼ pint (118 ml), ½ pint (237 ml), 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:



- Meets ASTM D 3138 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 D 3138 for non-pressure transition joints of ABS to PVC.
- Listed by IAPMO for compliance with ASTM D 3138 and applicable sections of the latest edition of the Uniform Plumbing Code® and the International Plumbing Code®. For use in a transition joint between ABS and PVC non-pressure installations. Not for use as an all purpose ABS-PVC cement, nor for use in joining either material to itself

SPECIFICATIONS:

COLOR:	Green
RESIN:	PVC
SPECIFIC GRAVITY:	0.927 ± 0.040
BROOKFIELD VISCOSITY:	Minimum 500 cP @ 73° ± 2°F (23° ± 1°C)

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 394 Transition, 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 primers.

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 394 Transition 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.

