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Standard Specification for SOLVENT CEMENTS FOR CELLULOSE ACETATE BUTYRATE (CAB) PLASTIC PIPE, TUBING, AND FITTINGS¹

This standard is issued under the fixed designation D 2560; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval.

1. Scope

1.1 This specification provides the general requirements for cellulose acetate butyrate (CAB) solvent cements to be used in joining cellulose acetate butyrate pipe, tubing, and fittings.

1.2 These solvent cements are suggested for use with CAB pipe or tubing, and fittings produced from Grade MH in Specification D 707, and for a Grade S not specifically covered by Specification D 707. For the purposes of this specification, Grade S of CAB shall meet the requirements of Grades MS, except flow temperature, which shall be $135 \pm 5^\circ\text{C}$ ($275 \pm 9^\circ\text{F}$). This does not exclude the possibility of using these solvent cements for other grades and formulations of CAB pipe and tubing compounds.

1.3 A recommended procedure for joining CAB pipe, tubing, and fittings with these solvent cements is given in Appendix X1.

1.4 The values given in parentheses are for information purposes only.

2. Applicable Documents

2.1 ASTM Standards:

D 618 Conditioning Plastics and Electrical Insulating Materials for Testing²

D 638 Test for Tensile Properties of Plastics²

D 707 Specification for Cellulose Acetate Butyrate Molding and Extrusion Compounds³

D 1084 Tests for Viscosity of Adhesives⁴

F 402 Practice for Safe Handling of Solvent Cements and Primers Used for Joining Thermoplastic Pipe and Fittings³

F 412 Definitions of Terms Relating to Plastic Piping Systems³

3. Definitions

3.1 The definitions in this specification are in accordance with Definitions F 412.

4. General Requirements

4.1 The CAB solvent cement shall be a solution of Grade MH cellulose acetate butyrate plastic as specified in Specification D 707 or Grade S described in 1.2 and one of the thinners described in 5.2.

4.2 Rework CAB materials, generated from the manufacturer's own pipe or tubing production, may be used to produce solvent cement by the same manufacturer, if blended back into the same grade of virgin CAB plastic, so long as the rework material is compatible with the virgin material and the cement produced meets the requirements of this specification.

4.3 The cement shall be free-flowing and shall not contain lumps, undissolved particles, or any foreign matter that will adversely affect the ultimate joint strength or chemical resistance of the cement.

4.4 The cement shall show no gelation. It shall show no stratification or separation that cannot be removed by stirring.

¹ This specification is under the jurisdiction of ASTM Committee F-17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.20 on Joining.

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² Annual Book of ASTM Standards, Part 35.

³ Annual Book of ASTM Standards, Part 34.

⁴ Annual Book of ASTM Standards, Part 22.