



**SOUTHWEST GAS CORPORATION**  
® ENGINEERING STAFF  
**MATERIAL SPECIFICATION**

<b>Section No:</b>	MS H-11
<b>Page No.:</b>	1 of 6
<b>Issue Date:</b>	03/01/16
<b>Superseded Date:</b>	02/23/15

*Prepared By:* Engineering Staff 

*Approved By:* Jerome T. Schmitz 

**GASKETS AND SEALANTS**

PVC Primer for ABS-to-PVC Solvent Weld Joint

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**1. SCOPE**

This specification covers PVC primer used for making joints with Acrylonitrile Butadiene Styrene (ABS) plastic pipe and Poly Vinyl Chloride (PVC) plastic fittings.

**2. APPLICABLE DOCUMENTS**

- 2.1 ASTM International (ASTM) D-1784, "Standard Specification for rigid Poly (Vinyl Chloride), (PVC) Compounds, and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds."
- 2.2 ASTM International (ASTM) D-2513, "Specification for Thermoplastic Gas Pressure Pipe, Tubing and Fittings."
- 2.3 ASTM International (ASTM) D-2564, "Specifications for Solvent Cements for Poly Vinyl Chloride (PVC) Plastic Pipe and Fittings."
- 2.4 ASTM International (ASTM) F-656, "Standard Specification for Primers for Use in Solvent Cement Joints of Poly Vinyl Chloride (PVC) Plastic Pipe and Fittings."
- 2.5 Southwest Gas Material Specification H-12, "ABS to PVC Solvent Cement."
- 2.6 Southwest Gas Material Specification B-13, "Pipe Fittings, Plastic Fittings."
- 2.7 United States Department of Transportation (DOT), Code of Federal Regulations (CFR), Title 49, Part 192, "Transportation of Natural and Other Gas by Pipeline; Minimum Safety Standards."

**NOTE:** Unless otherwise specified, the editions of the above documents incorporated by DOT 49 CFR 192 are applicable. Documents not incorporated by DOT 49 CFR 192 will be the most recent edition.

**3. TERMINOLOGY**

**3.1 General**

- 3.1.1 "Southwest Gas," "Southwest" or "SWG" wherever used in this specification and other related documents will refer exclusively to Southwest Gas Corporation.



**SOUTHWEST GAS CORPORATION**

® ENGINEERING STAFF

**MATERIAL SPECIFICATION**

<b>Section No:</b>	MS H-11
<b>Page No.:</b>	2 of 6
<b>Issue Date:</b>	03/01/16
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**GASKETS AND SEALANTS**

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**3. TERMINOLOGY** (Cont'd)

- 3.1.2 The terms “approved,” “as approved,” “satisfactory,” “as directed,” “or equal” or other similar terms wherever used in this specification and other related documents will mean “as determined by Southwest Gas,” unless specifically stated otherwise.
- 3.1.3 “Product Information Package” or “PIP” wherever used in this specification and other related documents will mean the required technical product information that a manufacturer must submit to SWG to determine if the product is suitable for use by SWG, unless specifically stated otherwise.

**4. MATERIALS AND MANUFACTURING**

- 4.1 The primer must be compatible with the ABS-to-PVC solvent cement and the PVC fittings made of classes 12454-B, 12454-C, 11443-B and 14333-D PVC plastic material.
- 4.2 The primer shall be a clear or purple colored, non-bodied, very fast-acting, water-thin solvent.
- 4.3 The primer shall meet the requirements of ASTM F-656.

**5. PERFORMANCE REQUIREMENTS**

- 5.1 The primer must be compatible with natural gas.
- 5.2 The PVC primer shall have physical properties as listed in the table below:

Physical Property	Requirement
Color	Clear or Purple
Specific Gravity	0.87 ± 0.010
Viscosity	Water thin
Shelf Life	3 years minimum in unopened cans

**TABLE H-11.1**



**SOUTHWEST GAS CORPORATION**

® ENGINEERING STAFF

**MATERIAL SPECIFICATION**

<b>Section No:</b>	MS H-11
<b>Page No.:</b>	3 of 6
<b>Issue Date:</b>	03/01/16
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---

**6. DIMENSIONS AND TOLERANCES**

The 3/4" dauber will be for use for up to 1-1/4" pipe and the 1-1/2" dauber will be for use on larger pipe.

**7. INSPECTION**

- 7.1 Successful review of the Product Information Package (PIP), as well as any future reference by SWG to the Seller's part number or internal code number in any future contract or purchase, will mean only that no conflict with the specification was found and will not relieve the Seller from meeting all the requirements of this specification.
- 7.2 SWG retains the option to inspect the manufacture and testing of any and all materials, products or systems supplied to this specification at the manufacturer's facility.
- 7.3 SWG will make appropriate inspections and tests of any and all materials, products or systems supplied to this specification. SWG will have the right, at their option, to reject any material which fails to conform to this specification. Any such rejection may take place at the manufacturer facility; the supplier's warehouse or any subsequent delivery location, before or after SWG assumes possession. Notice of the rejection will be made promptly to the supplier by SWG. The defective product will be replaced or returned for credit at the manufacturer's expense.
- 7.4 Any changes in manufacturing of previously approved materials, products or systems described in this material specification for sale to SWG, must be approved by SWG's Engineering Staff. **Failure to obtain Southwest approval may be cause for rejection and disqualification as an approved supplier.**



**SOUTHWEST GAS CORPORATION**

® ENGINEERING STAFF

## **MATERIAL SPECIFICATION**

<b>Section No:</b>	MS H-11
<b>Page No.:</b>	4 of 6
<b>Issue Date:</b>	03/01/16
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### **GASKETS AND SEALANTS**

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#### **8. CERTIFICATION**

The manufacturer's or supplier's certification shall be furnished to Southwest. This certification shall state that samples representing each lot have been manufactured, tested and inspected in accordance with this specification and that requirements have been met. When requested or specified in the purchase order or contract, a report of test results will be provided.

Upon the request of Southwest, the certification of an independent third party indicating conformance to the specification may be considered at Southwest's expense.

#### **9. SAFETY DATA SHEETS**

In accordance with law, the seller shall supply Safety Data Sheets for all applicable items supplied under this specification to the following:

- 1) The Receiving Location
- 2) Engineering Staff
- 3) Southwest Gas Corporation  
Corporate Safety  
Mail Station LVA-120  
P.O. Box 98510  
Las Vegas, NV 98193-8510

#### **10. PRODUCT MARKING**

- 10.1 All containers shall be marked with the manufacturer's name or trademark.
- 10.2 Each container shall be labeled with material safety information as required by the Federal Hazardous Substances Labeling Act.
- 10.3 Each container shall be clearly labeled so the contents are readily identifiable.

#### **11. PACKAGING AND PACKAGE MARKING**

All products covered by this specification will be packaged to prevent damage and/or leakage during shipping.



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<b>Section No:</b>	MS H-11
<b>Page No.:</b>	5 of 6
<b>Issue Date:</b>	03/01/16
<b>Superseded Date:</b>	02/23/15

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**12. STOCK CLASSIFICATION DESCRIPTION**

PRIMER, PVC, PINT SIZE CANS, WITH DAUBER, FOR SCHEDULE 40 PIPE, PURPLE.