



# PVC KIT

## THIXOTROPIC RIGID PVC CEMENT



### PRODUCT DESCRIPTION

Thixotropic rigid PVC cement.

### FIELD OF APPLICATION

For joining pipes, sockets and fittings with interference fit and loose fit (gap filling) in pressure and drainage systems. Extremely suitable for large diameters and at higher temperatures (> 35°C). Suitable for diameters ≤ 800 mm. Max. 16 bar (PN 16). Maximal tolerances: 0.8 mm diametrical clearance / 0.2 mm press fit. Suitable for e.g. pipe systems conforming to EN1329, 1452, 1453, 1455 and ISO15493 (PVC).

### PROPERTIES

- With brush
- With quick release cap
- Extended open time
- Thixotropic
- Gap filling

### QUALITY LABELS/STANDARDS

**Certificates:** CE: Adhesive for non-pressure thermoplastic piping systems in installations for the transport/disposal/storage of water (EN 14680).

CE: Adhesive for thermoplastic piping systems for fluids under pressure in installations for the transport/disposal/storage of water (EN 14814).

**Standards:** EN 14680: Meets requirements European standard 14680: Adhesive for non-pressure thermoplastic piping systems.

EN 14814: Meets requirements European standard 14814: Adhesive for thermoplastic piping systems for fluids under pressure.

### PREPARATION

**Working conditions:** Do not use in temperatures ≤ +5°C.

### APPLICATION

**Coverage:** Indication of the number of adhesive joints per 1 L:

Ø	32	40	50	63	75	90	110	125	160	200	250	315	400
#	650	290	160	100	90	70	40	30	20	12	8	5	3

### Directions for use:

1. Saw off pipes squarely, chamfer and deburr. 2. Clean adhesive surfaces with acetone and a clean, lint-free cloth. 3. Apply adhesive rapidly and evenly lengthways to both bonding surfaces (pipe thickly, sleeve thinly). 4. Assemble joint immediately. Remove excess adhesive. For the first 10 minutes, do not load the joint mechanically. Properly close the container immediately after use.

**Stains/residue:** Remove adhesive stains with acetone and a clean, lint-free cloth.

### CURE TIMES\*

Ø	16 – 63 mm		75 – 110 mm		125 – 315 mm		400 – 800 mm	
	10 BAR	16 BAR	10 BAR	16 BAR	10 BAR	16 BAR	10 BAR	16 BAR
5°C - 10°C	8 hours	16 hours	16 hours	32 hours	32 hours	64 hours	64 hours	128 hours
10°C - 25°C	4 hours	8 hours	8 hours	16 hours	16 hours	32 hours	32 hours	64 hours
>25°C	2 hours	4 hours	4 hours	8 hours	8 hours	16 hours	16 hours	32 hours

\* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

### TECHNICAL PROPERTIES

**Temperature resistance:** +60°C, peak load 95°C

**Chemicals resistance:** The chemical resistance of adhesive joints depends on the gap width, drying time, pressure, temperature, type and concentration of medium. The adhesive joint generally has the same chemical resistance as the material itself. Exceptions to this are a small number of very aggressive chemicals such as concentrated inorganic acids, caustic solutions and strong oxidants.

### TECHNICAL SPECIFICATIONS

**Chemical base:** Solution of PVC in a mixture of solvents

**Colour:** Yellow (transparent)

**Viscosity:** approx. 1.325 mPa.s., Thixotropic

**Solid matter:** approx. 22 %

**Density:** approx. 1.00 g/cm<sup>3</sup>

**Flash point:** K1 (<21°C)

### STORAGE CONDITIONS

At least 24 months in the unopened package and stored between +5°C and +25°C. Close the container properly and store in a dry, cool and frost-free location. Limited shelf life after opening.