

PVC WELD

A HIGH PRESSURE PVC CEMENT

TECHNICAL DATA SHEET

SMART ADVANTAGES

- SUITABLE FOR HIGH PRESSURE APPLICATIONS
- FAST SETTING FOR QUICK REPAIRS
- WATERPROOF

DESCRIPTION

Bostik PVC Weld is a brush grade solvent based welding adhesive formulated to provide a strong joint and seal, when joining rigid PVC pipes and fittings. Once assembled, the bond rapidly builds up strength, enabling units to be put into service with minimum delay. Contains solubilized PVC particles to aid in bond formation and gap filling, where pipes and fittings are not completely tight fitting. It meets the requirements of SABS 966-1:2000 Class 9 pipes and fittings (9 bar pressure) and is suitable for both low and high pressure applications.

APPLICATIONS

Suitable for all close fitting PVC pipes e.g. high pressure pipes such as irrigation and swimming pool pipes, outlet pipes, potable water pipes, gas pipes, sewage pipes, industrial pipes, cable conduits, PVC gutters, PVC and ABS connections.

ADHESION

Bostik PVC Weld adheres to rigid U-PVC and ABS.

LIMITATIONS

- Not suitable for soft and flexible PVC.
- Will not adhere to some plastics such as polyethylene, polypropylene.

SAFETY INSTRUCTIONS

Bostik PVC Weld is flammable. Contents may be under pressure. Always open such that the container lid points away from the face. Always work in a ventilated area. Do not breathe in vapours. Avoid exposing product to any ignition sources. Do not smoke when working with Bostik PVC Weld. It is advisable to wear gloves in order to avoid direct contact with the skin. If product comes into contact with skin or eyes, rinse thoroughly and immediately with water. Seek medical attention if irritation or discomfort persists. Keep out of reach of children! Refer to our Safety Data Sheets for further toxicological information and comprehensive handling instructions.

SURFACE PREPARATION

Surfaces must be clean, dry and free from all loose materials, dust, dirt, oil, rust and any other contaminants. Joints must be close fitting. Deburr both inner and outer surfaces to be bonded. Lightly abrade the surfaces to be bonded with sandpaper and degrease with a suitable solvent such as acetone or thinners. Poor surface preparation may result in bond failure.



HOW TO USE

1. Ensure that the surfaces are prepared as above.
2. Apply adhesive to both surfaces i.e. pipe and fitting.
3. Push the two parts to the full depth of the joint without twisting. Hold for 1 minute and clean off excess adhesive.
4. Allow 30 minutes before handling. Allow 4 hours before putting into service for low pressure applications, and 24 hours for high pressure applications.
5. Setting times may be slower in cold conditions.

CLEANING

Applicators can be cleaned with a suitable solvent such as acetone, immediately after use.

STORAGE STABILITY

Bostik Super Contact has a shelf life of at least 12 months if stored in a cool (below 25°C), dry place in its original container. If the material is kept beyond the recommended shelf life, it is not necessarily unusable, but a check should be performed to observe whether the product is still workable. Ensure that the container is tightly sealed while in storage to prevent solvent evaporation.

PRODUCT PACKAGING

- 50ml tube, 200ml tin, 500ml tin

PRODUCT CHARACTERISTICS	
Type	Solvent based synthetic resin adhesive
Appearance	Clear liquid
Density	Approximately 0.94 g/cm ³
Solids	Approximately 25%
Viscosity	Approximately 1500cps
Flash point (Pensky Martin closed cup) ASTM D93	<5°C

TYPICAL PERFORMANCE DATA	
Application temperature	5°C to 35 °C
Assembly time	5 minutes
Initial setting time (before handling)	30 minutes
Final set – low pressure applications	Minimum 4 hours
Final set – high pressure applications	Minimum 24 hours
Coverage	Approx. 6 joints per 100ml for 50mm pipe
Standards	SABS 966-1:2000 (class 9 pipes and fittings)
Tensile strength (PVC – PVC)	2.5 mPa
Hydrostatic pressure 42MPA	Intact after 34 hours at 20°C
Instant burst	53.9 Bar
Temperature resistance	0°C to 60°C
Water resistance	Excellent

DISCLAIMER

The above information is only offered as a guide to the use of this product. Furthermore, users should satisfy themselves that it is suitable for their needs. Since we have no control over the conditions under which it is used, we cannot accept responsibility for the problems caused by the use and/or application of this product.

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ASK A STICKY QUESTION...

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