

## PROFEC PVC GLUE



**PROFEC PVC GLUE** is a Heavy Body PVC Solvent Cement specially developed to joint U-PVC rigid pipelines and fittings.

### DESIGNED TO JOINT:

- Professional facilities.
- Water and other liquid supply.
- Facilities of irrigation systems
- PVC Pipelines for exhaust systems.
- Rigid PVC Pipelines for pressure systems.
- PVC cable conduits.
- PVC drains pipes.

### PROPERTIES / FEATURES:

- PVC Pipes solvent adhesive
- Very high strength
- Single component.
- Non ageing
- Resistant to shear strain of pressure pipes e.g. drinking water and gas pipes
- Ready to use
- Moderated speed drying, allowing small rectification during the installation.
- Adhesive should be applied on the dry surfaces. However, when these conditions can't be avoided, **PROFEC PVC GLUE** can be used under humid conditions.
- Very suitable for diameters  $\leq 250$  mm (10 in.)

### APPLICATION METHOD / DIRECTIONS FOR USE

1. Cut the pipe ends square and chamfer the edges in angle of 15°.
2. Clean and degrease the surfaces to be bonded (PVC pipe and fittings) with absorbent paper soaked with PROFEC CLEANER.
3. Apply with the brush a uniform coat of the PROFEC PVC GLUE, to both surfaces to be bonded, in axial direction to the end of the pipe.
4. Carry out the bond, before 3 subsequent minutes to the adhesive application (open time), pushing the pieces without turning. At temperatures above to 25°C, this open time will be reduced to 1 minute.
5. Maintain immobile the pieces bonded during some seconds, and remove the excess from adhesive with absorbent paper.
6. Wait 5 minutes before handling or to expose the bonded joint to mechanical stress. At temperatures of less than 10°C, this time should be extended to 15 minutes.
7. Do not apply pressures above to 1.5 atm to the piping system before 24 hours.
8. Close the container after use

**TECHNICAL DATA:**

Properties	Value	Unit	Method / Remarks
Chemical Base	Vinyl Polymers (Poly Vinyl Chlorine)		
Solvent	MEK, Cyclohexanone.		
Consistency	Translucent viscose liquid.		
Density	0.94 ±0.05	g/ml	20 °C, EN 542
Color, cured adhesive	Translucent		
Storage temperature range	+5 to +40	°C	
Shelf life	24	month	+5 to +40 °C and dry place.
	Handling		
Initial bond strength	> 1.75	MPa	after 1 hour (EN ISO 9311-2)
	> 2.75	MPa	After 2 hour (EN ISO 9311-2)
	> 8.0	MPa	After 72 hour (EN ISO 9311-2)
Pressure Resistance	> 70	Bar	After 1000 hour (EN ISO 9311-3)
Cure time for handling	5-15	min	20 °C
Fully cured after	48	h	23°C, 50% RH, 0.6 mm gap max
Viscosity	6000 ± 500	mPas	25 °C, Brookfield sp3/12 rpm
	Performance of cured material		
Hardness	90	Shore D	ISO 7619
Service temperature range	-15 to 70	°C	
Water resistance	Good		
Weathering resistance	Good		
UV resistance	Good		
Tensile strength	55	MPa	EN 12311-2
Elongation at break	75	%	EN 12311-2
Fire rating	Self-extinguishing		

## EMPLOYMENT CAUTIONS:

- This product is only for industrial and/or Professional use.
- Keep out of the reach of the children.
- Maintain container closed when is not in use, in order to avoid the evaporation of the adhesive's solvents.
- If contact with the eyes is produced, wash them immediately with abundant water, maintaining the well open eyelids. Ask for medical assistance.
- If there is a contact with the skin, it would be washed with water and soap.
- In the event of ingestion not to induce to the vomit, request medical care.

## STORAGE:

**PROFEC PVC GLUE** should not be stored at temperatures lower than 5°C since this leads to an increased viscosity and to a hardened structure. After conditioning at room temperature and good stirring of the adhesive, the viscosity and structure is again reduced.

Storage life: The storability at 20°C is at least 24 months from the date of filling Date.

## OTHER INFORMATION:

This adhesive fulfils the specifications related in the standards EN 14680 and EN 14814 according to EN ISO 9311 standard, a meets also ASTM-2564 requirements.

**PROFEC PVC GLUE** CE marking indicates that product meets requirements of Directive 89/106/EEC - construction products.



The information, and, in particular, the recommendations relating to the application and end-use of this product, are given in good faith based on own current knowledge and experience of the products when properly stored, handled and applied under normal conditions. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery.