

PVC FLEXIBLE

DESCRIPTION

Adhesive particularly suitable for pipe joints and fittings in rigid and flexible PVC pressure systems in accordance with EN 14814. Particularly suitable for joining pipes and fittings systems that meet the standards EN 1452 and EN 1329.

Adhesive approved (CE) for piping systems of thermoplastic materials for pressurized fluids to PN 16.

Suitable for potable water applications.

Special adhesive for installation applications in swimming pools and whirlpools.

TYPE

Based on a polymer resin of Poli Vinyl Chloride (PVC).

PROPERTIES

- Gel consistency.
- High thixotropy index – prevents it from dripping upon application
- High resin content gives a good filling capacity in diametrical gaps.
- Acts as a real chemical welding system for PVC, due to its composition.
- Easy to apply; it does not run or form “tears” inside the fixed pipes.
- The fixed joints present resistance and ageing characteristics comparable to those of rigid PVC.

APPLICATIONS

Specifically indicated for:

- Specially for swimming pools and sanitary fittings in rigid and flexible PVC installations.
- Bonding rigid PVC pipes and accessories in pressure systems up to 16 PN, according to EN 14814 “Adhesives for thermoplastic piping systems under pressure. Specifications”. Specifically indicated to bond thermoplastic piping systems under the specifications described in EN 1452 and EN 1329.
- Water supply, irrigation, industrial installations of pipes and drainage and storm conduits.

TECHNICAL CHARACTERISTICS

Properties of packaged cement:

Viscosity (Brookfield RVT, 20 rpm, Sp.5) at 23°C	Approx. 10.000 mPa s
Thixotropic index	Approx. 4,8
Solid content	Approx. 23,5 %
Relative density	Approx. 0.91 g/ml
Flammability	Highly flammable
Open time (at 23°C)	Max. 3 minutes
Gap Filling Capacity	+ 0.6 mm
Pressure Drying time (in normal conditions)	24 h
Shear strength (1 h drying time)	> 0,4 MPa
Shear strength (24 h drying time)	> 1,5 MPa

Shear strength (20 days + 4 days drying time)	> 7,0 MPa
Pressure resistance (20 °C)	51,2 bar
Pressure resistance (40 °C)	20,8 bar
Application temperature (see note in instructions for use)	-5 to +30°C
Service temperature	-5 to +50°C

INSTRUCTIONS FOR USE

Prepare the pipes by cutting them at a right angle, chamfer at 15° and deburr. Clean and degrease the pipe and socket with a cloth soaked in PVC CLEANER. Stir PVC FLEXIBLE before use. Apply PVC FLEXIBLE with a brush axially from the inside, outwards to form a thin layer in the socket and a thick layer on the pipe. Insert the two parts to the full depth of the joint without twisting, always within 3 minutes after applying the solvent cement. Hold for 30 seconds while the initial bond takes place. Clean off excess solvent cement with a paper towel and PVC CLEANER. Allow 10 minutes before handling. For temperatures lower than 10 °C, wait at least 15 minutes before handling.

PVC FLEXIBLE cures in 8 hours depending on weather conditions. It is recommended to wait 24 hours before performing the pressure test (1.5 x PN). If the pipes are to be used under pressure within the first 24 hours after bonding, a prior minimum waiting time of 1 hour for each bar of working pressure must be observed. The bonded pipes should be lowered into the trench after 10 to 12 hours.

Installation at low temperature (below 5 °C) requires utmost care. The pipe ends and sockets to be bonded must first be warmed to 25-30 °C by means of a suitable hot-air blower (explosion proof). The finished joint must be kept between 20 and 30 °C for 10 minutes to ensure proper curing. For drinking water applications wait at least 24 hours, curing at 23 °C.

For diameters from 110 to 250 mm:

- The application of the adhesive by two operators simultaneously is recommended.
- Cut pipe ends square and remove swarf and other residue from inside and outside diameter. Clean and degrease parts to be bonded with a cloth (or crepe paper) soaked in PVC CLEANER.
- Apply the adhesive generously and evenly over the entire surface. Do it quickly to limit drying of the adhesive.
- Immediately fit the two parts completely, pushing longitudinally without turning them.

Generally, the following cure and pressure conditions are recommended:

Systems with up to 10 bars of pressure and pipes of up to 90 mm	Application temperature + 5° C to +35°C	Drying time reduced to 1 hour
Waste Systems		
Other systems		Normal drying time 24 hours

– **CAPACITY**

The following table shows the quantities of solvent cement and cleaning solvent necessary for 100 bonds of the diameters indicated:

DIÁMETER	Adhesive (L)	Cleaner (L)	DIÁMETER	Adhesive (L)	Cleaner (L)
32	0.8	0.5	110	8.0	1.7
40	1.1	0.7	140	13.0	2.1
50	1.5	0.9	160	19.0	2.5
63	1.7	1.1	225	26.0	4.5
75	2.2	1.3	280	38.0	6.5
90	4.0	1.4	315	52.0	10.2

STORAGE

Stored in its original container and in a cool, dry place, this product maintains its properties according to the following chart.

CONTAINER	PREFERENTIAL PERIOD USE
Plastic bottle	2 years

Appropriate precautions must be taken due to it being a very flammable product; it must be stored far from flames, sparks, heat sources, and in non-smoking areas.

It is advisable that PVC FLEXIBLE not be stored at temperatures below 5 °C, since this will increase viscosity and affect the adhesive's applicability. It is necessary, in such cases, to condition the adhesive to the ambient temperature, and stir it to reduce viscosity.

PRESENTATION

Visit our web site www.unecol.com

CLEANING

The fresh product is eliminated with a cloth soaked in PVC CLEANER. PVC FLEXIBLE adhesive attacks rigid PVC, which is why all accidental contact of pieces with the product must be avoided.

SAFETY PRECAUTIONS

Consult the product's safety sheets for more information.

The above mentioned data are based on our better experience and knowledge, but should be understood as specifications. The end user is responsible for verifying the suitability of the information provided, according to the specific use of the product