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PVC PEGAFOR

DESCRIPTION

Special solvent cement for welding rigid PVC pipes and accessories pressure systems, according to EN 14814. Specifically indicated to bond materials under these regulations: EN 1452 and EN 1329.
Adhesive with marked CE for the field of thermoplastic system application with pressure under pressure (PN16), in installations for the transport / disposal / storage of water not intended for human consumption.
Suitable for potable water applications.

TYPE

Based on homopolymer resin Poli Vinyl Chloride (PVC) and Tetrahydrofurane stabilized (THF)

PROPERTIES

- High apparent viscosity and excellent fluidity.
- Highly thixotropic, which prevents dripping during application.
- Moderately fast initial curing, which allows minor rectifications during the installation and facilitates the bonding of large diameters.
- Acts as an authentic chemical VC solvent, due to its composition.
- Easy to use and does not drip or form “tears” on the inside of the tubes joined.
- The fixed joints present strength and ageing characteristics comparable to those of rigid PVC pipes.

APPLICATIONS

Solvent cement for:
- Connections of rigid PVC tubes and accessories in systems with pressure up to PN 16, in accordance with that established by regulation EN 14814: “Adhesives for thermoplastic piping systems for fluids under pressure. Specifications.” Especially suited for joining materials which comply with regulations EN 1452 and EN 1329.
- Water supply, irrigation, gas conduit, industrial facilities for piping drainage and rain water

TECHNICAL CHARACERISTICS

Properties of packaged cement:

Viscosity (Brookfield RVT, 20 rpm, Sp.5) at 23ºC	Approx. 9000 mPa.s
Thixotropy index	Approx. 3,8
Solid content	Approx. 21%
Density	Approx. 0,96 g/ml
Flammability	Highly flammable

Open time (at 23ºC)	Maximum 2 min.
Gap filling capacity	+ 0.6 mm
Drying time for pressure (under standard 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 º C)	51,2 bar
Pressure resistance (40 º C)	20,8 bar
Application temperature (see note in instruccions for use)	-5 to +30ºC
Temperature in use	-5 to +50ºC

INSTRUCTIONS FOR USE

Prepare the pipes by cutting them at a right angle, chamfer at 15º and deburr. Clean and degrease the pipe and socket with a cloth soaked in PVC CLEANER. Stir PVC PEGAFOR before use. Apply PVC PEGAFOR 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 2 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 5 minutes before handling. For temperatures lower than 10 ºC, wait at least 15 minutes before handling.

PVC PEGAFOR 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 ºC) requires utmost care. The pipe ends and sockets to be bonded must first be warmed to 25-30 ºC by means of a suitable hot-air blower (explosion proof). The finished joint must be kept between 20 and 30 ºC for 10 minutes to ensure proper curing.

- **CAPACITY**

These tables show the quantities of solvent cement and cleaning solvent required to bond 100 joints of the following diameters:

DIAMETER	Adhesive (L)	Cleaner (L)	DIAMETER	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	SHELF LIFE
Metal can	2 years
Metal tube	2 year

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 PEGAFOR not be stored at temperatures below 5 ºC, 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 PEGAFOR 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.