

# PVC PIPE CEMENT

## TYPE P (PRESSURE)

3 January 2018

### YOUR SMART ADVANTAGES

- WaterMark certified as per the Plumbing Code of Australia
- Conforms to Type P requirements specified in AS/NZS 3879
- Suitable for water potable applications – meets AS/NZS 4020
- Natural bristle brush included in the lid for easy application (in containers 1L and under)
- Colour coded packaging for easy product selection
- Ready for use – no mixing required
- Good application viscosity; easily applied with minimal dripping

### USES

- Generally recommended for jointing pipes 100mm or less in diameter
- Jointing PVC-U pipes to PVC-U fittings in pressure plumbing applications, i.e. irrigation and reticulation systems
- Bonding PVC-U sheets

### PRODUCT CHARACTERISTICS

Colour	Green or Clear
Viscosity	Medium bodied
Composition	Solvent
Application temperature	10 to 30°C
Pressure Rating*	Joint withstands pressure of 4.5MPa (650psi) for 1000 hours

### Product codes

125mL Green	30840490
250mL Green	30840474
500mL Green	30840475
500mL Clear	30840492
4L Clear	30840495

\*Clause 8.3.1 – *Pressure Joints (Type P)* of AS/NZS 3879 states “The joint shall withstand (without any leakage, weeping or cracking) a hydrostatic pressure test for 1000 hours at the specified test pressure”

**Note:** All containers 1 litre and less have an applicator brush included in the cap.

### DIRECTIONS FOR USE

Read and understand the Safety Data Sheet before using this product. SDS can be acquired by visiting [www.bostik.com.au](http://www.bostik.com.au) or by scanning the relevant QR code on pack.

### BEFORE APPLICATION

- 1) Verify that the cement is suitable for the pipe and fitting materials being used.
- 2) Check temperatures where application will take place:
  - a) Cements take longer to set in cold weather. Allow extra time for curing. Do not try to speed up the cure by artificial means – this could cause bubbling and porosity in the cement film.
  - b) Solvents evaporate faster in warm and windy weather. Work quickly to avoid the cement drying before the joint is assembled. Avoid working in direct sunlight and on warm pipes. It is recommended that storage of materials and application should be in shaded areas. Ideal application temperatures are between 10°C and 30°C out of direct sunlight.
- 3) Shake the cement bottle well before use.
- 4) Ensure appropriate personal protective safety equipment is worn when using the solvent cement/priming fluid.
- 5) **DO NOT** mix any additives to the priming fluid or pipe cement.
- 6) Do not use gelled or lumpy cement. It should be the consistency of syrup.
- 7) Coloured cements and priming fluids will leave a permanent stain. Avoid spills. The stain may fade over time or after prolonged exposure to direct sunlight.

### APPLICATION

1. Jointing procedure must be in compliance with the most current edition of AS/NZS 2032: Installation of PVC pipe systems.
2. Cut the end of the pipe square and remove all burrs and sharp edges from the inside and outside of the pipe.
3. Check the dry fit of the pipe and fitting before priming fluid/cement application. Check and ensure for proper interference fit.

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4. With the pipe fully engaged in the fitting, mark the pipe with a witness mark at a distance equal to full fitting depth. Use a pencil to mark the pipe. Do not score the pipe. The priming fluid and cement must be coated slightly beyond the witness mark on the pipe.
5. Ensure the pipes and fittings are dry and clean. Wipe any moisture and dirt off the outside surface of the pipe and inside surface of the fitting with a CLEAN rag. Do not use oily/dirty rags.
6. Thoroughly prime the inside of the fitting and external surface of the pipe with Bostik PVC Priming Fluid. Do not use dirty rags. Ensure 100% of the joint areas are covered with priming fluid. Ensure the application of the cement can occur immediately after primer application.
7. First, immediately apply an even coat of the pipe cement to the inside of the fitting then coat the external area of the pipe. Ensure 100% of the joint areas are covered with cement.
8. While the cement is still wet, immediately insert the pipe into the fitting ensuring to meet the witness mark. If the cement has dried do not continue and re-coat both the pipe and fitting. A dry joint will fail.
9. Firmly hold the assembled joint together for at least 1 minute to prevent the pipe from kicking out. Without disturbing the joint carefully wipe any excess cement from the joint and allow the assembly to sit undisturbed for 5 minutes.
10. Allow 24 hours before putting the joint into service.

## **Bonding of PVC-U sheet**

1. Ensure PVC-U sheets are clean, dry and free from burrs.
2. Clean and prime both sheets with Bostik PVC Priming Fluid.
3. Apply cement in a thin even coat to both surfaces and whilst still wet, position together.
4. Weigh down or clamp until initial bonding takes place - approx 10 minutes (depending on weather conditions). While clamped wipe off any excess cement from the edges of the sheets before it dries.
5. Allow 24 hours to set before applying any stress or strain on the bond.

## **LIMITATIONS**

- At temperatures greater than 30°C, rapid evaporation of solvent can occur before the solvents can penetrate the pipe surfaces. This may prevent a satisfactory bond and lead to a dry joint resulting in a failed bond. Always re-coat the pipe and fitting if the adhesive dries during application.
- When not in use ensure the lid is tightly secured on cement and priming fluid bottles. Evaporation of the solvent will affect the performance of the product.
- This product is not suitable for use in hot water systems.
- Application to larger diameter pipes may require a larger brush than that supplied. If a small brush is used on large diameter pipes and fittings, application time and full coverage of the pipe and fitting can take too long resulting in dry joints.

## **STORAGE AND SHELF LIFE**

This product has a shelf life of 2 years from the date of manufacture when stored in the original, unopened container at normal room conditions.

Ensure the lid is tightly secured on cement and priming fluid bottles when not in use to prevent solvent escaping.

## **ANCILLARY MATERIALS**

Bostik PVC Priming Fluid must always be used for cleaning and priming substrates prior to application of Bostik PVC Pipe Cement.

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## VOC INFORMATION

### **GBCA Technical Clarification Statement PVC Pipe Cements IEQ-13, Clarification No. 43 – Published October 2009**

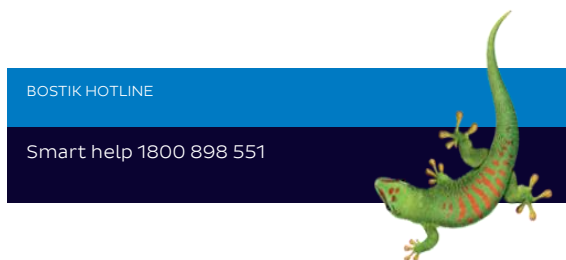
Pipe cements are not relevant to the VOC credit as they have little influence on indoor air quality. Plumbing pipes are usually installed some time prior to building occupation and any residual of solvent will be negligible by the time the building is sealed and occupied.

In addition, plumbing pipes are not a major component of an individual fit out or building, plumbing cements are minor in quantity in the indoor fit out when compared to adhesives used in countless other indoor applications.

Refer to Green Building Council Australia website for further details [www.gcba.org.au](http://www.gcba.org.au)

## HEALTH AND SAFETY

Always read the Technical Data Sheet and Safety Data Sheet (SDS) before handling or use. Full product safety information required for safe use is not included in this data sheet. SDS available by request or at [www.bostik.com.au](http://www.bostik.com.au)



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