



technical data sheet

PLUMB-WELD

PVC Pipe Cement Type "N" (Blue and Clear)

DESCRIPTION

Bostik PVC Pipe Cement Type N is a synthetic resin-based adhesive that meets the requirements of AS/NZS 3879 and AS4020, making it suitable for potable water applications. It has been specifically formulated for adhering **rigid unplasticized** PVC to itself, both in pipe and sheet form.

Bostik PVC Pipe Cement Type N has proven reliability and consistency and has been used by the Australian plumbing industry for over 20 years. It's the ideal adhesive for commercial and residential sewerage work.

Bostik PVC Pipe Cement Type N, with its short open time (fast drying) properties, is best suited for pipes 100mm (4 inch) or less in diameter and best results are obtained when bonding at temperatures between 10°C - 30°C. Bostik slow setting PVC cement is recommended for higher ambient temperature conditions or larger diameter pipes.

The product is ready for use and **must not be** diluted.

Product consistency has been designed to give less wastage by reducing run off and dripping. The convenient brush in the cap supplied with the product allows easy application onto pipe joints.

FEATURES & BENEFITS

- Meets the stringent requirements of AS/NZS 3879:1995 for performance
- Conforms to AS4020 for Water Potability
- Colour Coded Packages (easy product selection)
- Ready for use.
- Fast drying and setting.
- Low odour formula.
- Ideal viscosity (easily applied, minimal dripping)
- Convenient range (job sized containers)

TYPICAL TECHNICAL DATA

Viscosity	Low -Medium Bodied
Solids Content	Approx. 22%
Colour	Blue or Clear
Coverage	Approximately 8m ² /Lt
Maximum Operational Temp. T°/C	60°C

AS/NZS 3879:1995 Type N Requirements

Drying Time	Strength		
20 mins	0.1 MPa	100 kPa	14.5 psi
1 Day	1MPa	1000 kPa	145 psi
60 Days	4 MPa	4000 kPa	580 psi

APPLICATION INSTRUCTIONS:

Before Beginning

1. Verify the cement is suitable for pipes and fittings being used.
2. Check temperature where the cementing will take place:
 - 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 porosity and bubbling in the cement film.
 - Solvents evaporate faster in warm weather. Work quickly to avoid the cement setting up before the joint is assembled. Avoid working in direct sunlight. Observe application temperatures between 10 °C and 30°C.
3. Keep the lid on cements and priming fluid when not in use. Evaporation of the solvent will affect the cement.
4. Stir or shake cement before using.
5. Ensure appropriate safety equipment is worn when using the solvent cement.
6. **DO NOT** mix Priming Fluid with solvent cement.
7. Do not use thickened or lumpy cement. It should be the consistency of syrup.
8. Maximum temperature allowable for PVC is 60°C
9. All coloured cements and primers will leave a permanent stain. There is no known cleaning agent.

Jointing of Pipe

1. Joining procedure should be as laid down in AS2032-1977.
2. Ensure pipe end to be joined is square and free from burrs
3. Clean both spigot and socket with rag moistened with **Bostik Priming Fluid**. It is vital both surfaces are clean and dry.
4. Apply Plumb-Weld pipe cement in full even coats to both surfaces; first inside the socket, then to external surface of pipe end.
5. Immediately assemble, pushing pipe firmly home to full depth of the socket whilst adhesive is still wet.
6. Firmly hold assembled joint for a least 30 seconds. Do not disturb for 5 minutes and allow 24 hours before applying pressure.

Adhering of Sheet in Small Pieces or Assemblies

1. Ensure sheets are clean and free from burrs.
2. Clean and prime sheet with Bostik 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.
5. Wipe off excess cement.
6. Allow 24 hours to set before applying any stress or strain.

NOTE:

Care is required when using above 30°C as premature drying may prevent satisfactory bond. In this instance a second coat is recommended to give more open time. No additives of any kind shall be added to this PVC pipe cement. Unsuitable for hot water systems.

LIMITATIONS

- For larger pipes or hot windy conditions, use **Bostik Slow Setting PVC cement**. At working temperatures greater than 30°C, rapid evaporation of solvent can occur which may prevent satisfactory bonding.
- Not for use on plasticised PVC articles or other plastic jointing used in plumbing industry - eg Polyethylene and ABS
- For pressure applications, use **Bostik Plumb-Weld Type P Green Cement**.

PACKAGING

125ml, 250ml, 500ml 1 Litre and 4 litres.

Note: All containers 1 Litre and less have an applicator brush included in the cap

ITEM NO.	STOCK SIZE
078328	125 mls Blue
078336	250 mls Blue
078344	500 mls Blue
078352	1 Litre Blue
078360	4 Litre Blue
078247	250 mls Clear
078255	500 mls Clear
078271	4 Litres Clear

SAFETY INFORMATION

Avoid contact with skin and eyes, and avoid breathing vapours. Highly Flammable. Store in a cool dry area. Use only in well ventilated areas away from sources of ignition (heat, sparks or flames). Refer to the Material Safety Data Sheet for further information on website www.bostikfindley.com.au

STORAGE

Shelf life is 2 years when stored in a cool, dry area, below 30°C in original container from the date of manufacture.

ANCILLARY MATERIALS

Bostik Plumb-Weld PVC Priming Fluid (Red or Clear)
Use for cleaning and priming substrates only

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FOR FURTHER INFORMATION



BOSTIK AUSTRALIA PTY LTD
 Phone: +61-3-9279 9333
 Fax: +61-3-9279 9240

BOSTIK NZ LIMITED
 Phone: +64-4-567 5119
 Fax: +64-4-567-5412

BOSTIK SINGAPORE PTE LTD
 Phone: +65-863 4088
 Fax: +65-863 4077

BOSTIK (MALAYSIA) SDN BHD
 Phone: +606 764 3246
 Fax: +606 764 3248

SYDNEY
 Phone: 02 8825 3488
 Fax: 02 8825 3411

ADELAIDE
 Phone: 08 8244 0511
 Fax: 08 8244 0522

PERTH
 Phone: 08 9258 6218
 Fax: 08 9258 7687

BRISBANE
 Phone: 07 3260 2206
 Fax: 07 3260 2123

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