

PLUMB-WELD

PVC Pipe Cement Type "P" (Green)

DESCRIPTION

Plumb-Weld PVC Pipe Cement Type P is a synthetic resin-based adhesive specifically formulated for adhering **rigid** unplasticized PVC to itself, both in pipe and sheet form. This product has been developed from Bostik's proven type "N" PVC Pipe Cement range to meet **pressure** applications. It is designed for irrigation and reticulation usage.

Plumb-Weld PVC Pipe Cement Type P meets the requirements of AS/NZS 3879:1995 and has also been approved to be suitable for potable water applications.

Product consistency has been designed to give greater welding strength, better gap filling properties and 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 pressure applications
- Conforms to AS4020 for Water Potability
- Green Colour Coded Packages (Easy product selection)
- Ready for use.
- Early strong welding power
- Good gap filling properties.
- Ideal viscosity (Easily applied, minimal dripping)
- Convenient range (Job sized containers)

TYPICAL TECHNICAL DATA

Viscosity	Medium Bodied
Solids Content	Approx. 20%
Colour	Green
Coverage	Approximately 8m ² /Lt
Chemical Resistance	Refer to attached table
Maximum Operational Temp. T°/C	60°C

AS/NZS 3879:1995 Type P Requirements			
Drying Time	Strength		
20 mins	0.5 MPa	500 kPa	72psi
1 Day	3 Mpa	3000 kPa	435 psi
60 Days	8 Mpa	8000 kPa	1160psi

APPLICATION INSTRUCTIONS:

Before Beginning

1. Verify the cement is suitable for the application.
2. Check temperature where the cementing will take place:
 - Cements take longer to set up 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. Cut pipe end square and remove all burrs.
3. For correct joint assembly, mark pipe at a distance equal to full socket depth. Test joint for dry fit. With pressure pipe joints, interference fit must be reached before the mark.
4. Priming fluids shall be used to prepare the jointing surface prior to solvent cement application. Use a clean cloth freshly moistened with Plumb-Weld PVC Priming Fluid to clean pipe end and inside of socket.
5. Apply Plumb-Weld pipe cement in full even coats to both surfaces; first inside the socket, then to external surface of pipe end.
6. Immediately assemble, pushing pipe firmly home to full depth of the socket whilst adhesive is still wet. For large diameter joints (100mm and above), recommend either use one coat and immediately assemble or apply a second coat of PVC cement.
7. 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 sheet with Bostik priming Fluid.
3. Apply cement in thin even coat at rate of 8m²/Lt to both surfaces and while 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.

STORAGE

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

PACKAGING

125ml, 250ml, 500ml and 4 litres.
All containers 500ml and less have an applicator brush included in the cap

ITEM NO.	STOCK SIZE
223832	125ml Green
223840	250ml Green
223859	500ml Green
223875	4lt Green

CHEMICAL RESISTANCE OF uPVC PIPE

CHEMICAL	RESISTANCE	
	20°C	60°C
Acetic Acid (20%)	S	S
Acetic Acid (80%)	S	D
Acetone	U	U
Ammonia Gas (ρ 0.880 kg/m ³)	S	S
Ammonia Gas (dry)	S	S
Benzene	U	U
Benzyl Alcohol	U	U
Bleach (12.5% active chlorine)	S	S
Brine	S	S
Butanol	S	S
Butyl Acetate	U	U
Carbon Dioxide (wet or dry)	S	S
Castor Oil	S	S
Chlorine Gas (Dry)	S	D
Chlorine Gas (Wet)	U	U
Chlorine (Liquid)	U	U
Chromic Acid (10%)	S	S
Chromic Acid (30%, 50%)	U	U
Cod liver Oil	S	S
Copper sulphate soln.	S	S
Cotton seed Oil	S	S
Cresylic Acid (50%)	S	S
Cresylic Acid (100%)	D	U
Crude Oil	S	D
Decalin	U	U
Detergents (normal dilution)	S	S
Diesel Oil – Gas & Derivatives	S	S
Diethylene Glycol	S	S
Ethanol (40%, 100%)	S	D
Ethyl Acetate	U	U
Ethylene Glycol	S	S
Ferric Chloride	S	S
Fluorine gas (wet & dry)	S	U
Formaldehyde (40%)	S	S
Formic Acid (50%)	S	U
Gallic Acid	S	S
Glycerol (glycerine)	S	S

S = Satisfactory D = Limited Resistance / Some attack
U = Unsuitable

The information given in the following table is intended as a guide only.
Please consult pipe manufacturers for more specific information or
Bostik Findley.

The representations and recommendations regarding the products are based on tests that we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.

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CHEMICAL	RESISTANCE	
	20°C	60°C
Hydrochloric Acid	S	S
Hydrofluoric Acid (50%)	U	U
Hydrogen Peroxide (50%)	S	S
Hydrogen Sulphide (wet aq. Soln)	S	S
Iso-octane	S	U
Kerosene	S	S
Linseed Oil	S	S
Lubricating Oil	S	S
Methanol	S	S
Mineral Oils	S	D
Mixed Acids (dilute) (H ₂ SO ₄ , HNO ₃)	D	U
Nitric Acid (10%)	S	D
Nitric Acid (68%)	D	D
Nitric Acid (90%)	U	U
Paraffin Oil	S	S
Perchloric Acid	S	U
Petrol	U	U
Phosphoric Acid (50%, 85%, fuming)	S	S
Potassium Permanganate (25%)	S	D
Propylene Oxide	U	U
Rapeseed Oil (canola)	S	S
Silver Cyanide	S	S
Sodium Hydroxide (aq. Soln.)	S	S
Sodium Hypochlorite	S	D
Sulphur Dioxide (dry)	S	S
Sulphur Dioxide (wet)	S	D
Sulphuric Acid (10%)	S	S
Sulphuric Acid (75%)	D	U
Sulphuric Acid (95%)	U	U
Tetrahydrofuran (THF)	U	U
Tetralin	U	U
Toluene	U	U
Turpentine	S	S
Vinegar	S	S
White Spirits	S	U
Wine & Spirits	S	S
Xylene	U	U

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 available on website www.bostikfindley.com.au.

ANCILLARY MATERIALS

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

FOR FURTHER INFORMATION

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