



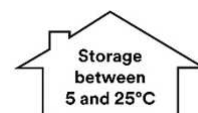
Product code : 38023A

## EMFICOL PVC / PVC

### DESCRIPTION

EMFICOL PVC / PVC is a fluid adhesive based on vinyl polychloride resin (PVC) without THF (tetrahydrofuran).

Due to its composition, EMFICOL PVC / PVC acts as a real chemical PVC welder and thus allows assemblies with strength- and ageing characteristics comparable to those of rigid PVC. It has CE marking for following application: Adhesive for non-pressure thermoplastics piping systems in PVC-U according to European Standard EN 14680.



### AREAS OF APPLICATIONS

EMFICOL PVC / PVC is specially adapted for the assembly of rigid PVC pipes, accessories and fittings (nestable) for pressure-free sewage drainage systems.

EMFICOL PVC / PVC is also suitable for the bonding of rainwater gutters and downspouts as well as panels, profiles, cable sheaths, trims and other accessories in PVC.

Its initial setting allows slight corrections during installation and facilitates large diameter bondings.

### TECHNICAL DATA

Color	Colorless translucent
Viscosity at 20°C	Brookfield RVT 3 / 20 rpm: approx. 7,000 mPa.s
Density at 20°C	Approx. 0.92
Application temperature	-5 to +30°C
Open time at 23°C	2 to 3 min
Shear resistance (NF EN 14680)	> 0,4 MPa (1h of drying) > 1,5 MPa (24h of drying) > 7,0 MPa (20 + 4 days of drying)
Final setting time	24 hours

### INSTRUCTIONS FOR USE

#### Substrates preparation:

The substrates must be clean, even, dry, dust free and not have any traces of grease or other contaminants that could harm bonding.

Before bonding the pipes, it is necessary to prepare them by cutting them at right angles and beveling their edges at 15°.

If the substrates need to be cleaned, use EMFINET 683, methylethylketone (MEK) or acetone.

Note: when using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

#### Bonding:

EMFICOL PVC / PVC is to apply in double-gluing technique with the brush integrated in the metal box (or directly from the tube in case of metal tube packaging).

Apply the adhesive without excess, preferably from the inside of the pipe to the pipe end and distribute a uniform layer on both parts to be assembled. The setting time being relatively fast, immediately insert the pipe end into the socket by pushing, without twisting. Immediately remove excess adhesive with a clean cloth. Avoid handling parts for 5 minutes after assembly.

Be careful not to exceed open time, otherwise defective bonding may happen.

The adhesive cures in 8 hours (depending on temperature), but it is recommended to wait 24 hours before use.

#### Cleaning:

Tools can be cleaned with methylethylketone (MEK) or acetone before the adhesive has completely cured. After curing, abrasion is necessary.

### CONSUMPTION

Approximate number of bondings achievable with a 500 ml box depending on the diameter of the pipe :

Diameter of the pipe (mm)	32	40	50	63	75	90	110	140	160	225	280	315
Number of bondings	62	45	33	29	23	12	6	4	3	2	1,3	1

For information purpose, dependent on the bonding conditions (surface's state, substrates, etc.)

### STORAGE AND SHELF LIFE

24 months in closed original packaging stored at a temperature between 5 and 25°C.

An increase in viscosity at low temperatures can affect the applicability of the adhesive: to lower its viscosity, it is recommended to stir it at room temperature before application.

### PACKAGING

125 ml metal tubes (30 per carton).

Metal boxes with integrated brush: 250 ml (36 per carton), 500 ml (24 per carton) et 1 l (12 per carton).

Contact us for other packaging options.

### SAFETY

Read material safety data sheet before use.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.