



# UNECOL PVC ASTM HEAVY LOW VOC

## **DESCRIPTION**

Special solvent cement for welding rigid PVC pipes and accessories up to 12" diameter type 40 and type 80. Suitable for use in drinking water installations. Meets the requirements of ASTM D-2564 "Standard Specification for Solvent Cements for Poly (Vinyl Chloride) (PVC) Plastic Piping Systems".

Solvent cement low in Volatile Organic Compounds (VOC / VOC). In accordance with the requirements set by South Coast Air Quality Management District Rule 1168 / 316A (SCAQMD 1168 / 316A), which have been adopted by LEED® (Leadership in Energy and Environmental Design) for use in the construction of environmentally sustainable buildings.

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## **TYPE**

Based on a polyvinyl chloride resin (PVC) and solvent system designed to meet SCAQMD 1168 / 316A maintaining the required performance by the ASTM D2564 standard.

## **APPLICATIONS**

Solvent cement for:

- Joining PVC pipes and fittings up to 12" diameter type 40 and type 80
- Water supply, irrigation, gas conduits, industrial pipe applications, sewers and drainage, waste and ventilation systems.

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## **TECHNICAL CHARACTERISTICS**

Properties of packed adhesive:

Viscosity	Min. 1600 cps
Appearance	Clear liquid
Solid content	18.5%
Resin content	> 10%
Shear strength (2 hours drying ASTM std.)	> 1.7 MPa (250 psi)
Shear strength (16 hours drying ASTM std.)	> 3.4 MPa (500 psi)
Shear strength (72 hours drying ASTM std.)	> 6.2 MPa (900 psi)
Resistance to hydrostatic pressure (2 hours curing)	> 2.8 MPa

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## **METHOD OF APPLICATION**

First, prepare the pipes, cutting them at right angles. Subsequently, clean and degrease the pipe and coupling with a cloth soaked in PVC CLEANER. Apply UNECOL PVC ASTM with a suitable applicator axially from inside to outside in a thin layer first to the coupling and afterwards to the pipe. If the surface of the solvent has dried, apply more to both sides. Insert the two parts immediately and fully, without twisting. Leave to dry for 30 s until UNECOL PVC ASTM develops the initial welding. Remove excess solvent cement with a cloth dampened with PVC cleaner. Do not handle the welded parts for the next 15 minutes.

UNECOL PVC ASTM can be tested under pressure (12 bar) after 2 hours of drying at a temperature above 15 ° C. The cure time should increase at temperatures below 15 ° C or if the diameter of the installation is greater than 3 ". If possible, it is recommended to wait 24 hours before submitting the installation to pressure and / or drinking water installations. Pipes should not be buried before 10 or 12 hours after welding.



Installations at low temperatures (below 5 ° C) require a different method: The ends of the pipe and fittings to be welded must be heated to 25 to 30 ° C with a hot air gun (suitable for work in flammable environments). The welded parts should be held together for about 10 minutes between 20 and 30 ° C to ensure proper curing.

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## **STORAGE**

This product, stored in the original container in a cool, dry place, maintains its properties for at least 3 years. Being a flammable product, the necessary precautions must be taken. The product should be stored away from flames, sparks and sources of heat in no smoking areas.

It is not advisable to store UNECOL PVC ASTM at temperatures below 5 ° C, as this causes an increase in viscosity, which affects the application of the adhesive. In such cases, the solvent cement should be restored to room temperature and stirred to reduce the viscosity again.

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## **PRESENTATION**

Visit our web site [www.unecol.com](http://www.unecol.com)

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## **CLEANING**

Fresh product can be removed with a cloth soaked in PVC CLEANER. UNECOL PVC ASTM solvent cement attacks rigid PVC therefore, all accidental contact with parts to be assembled should be avoided.

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## **SECURITY AND HYGENE**

For further information see our safety data sheet.

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The above mentioned data are based on our better experience and knowledge, but should be understood as specifications. The end user is responsible for verifying the suitability of the information provided, according to the specific use of the product

Date of revision: 2016-04-28