

TECHNICAL DATA SHEET

PeViCol

Special adhesive for joining PVC plastic

Product description

PeViCol is a patented special adhesive for joining PVC plastic material, PVC pipes and fittings, where the request is a long open time and good filling properties.

PeViCol is a thixotropic product, produced on the basis of NMP (N-Methyl-Pyrrolidone), which can be mixed with water in all conditions. PeViCol is cured by means of both humidity of the atmosphere and water, which accelerate the curing process.

PeViCol is tested and certified in accordance with the following standards: DIN 16970 – ASTM D 2564-80 pkt. 6.3.3. – NS 2944 pkt. 6.4. - BS 4346: part 3 (1982) - BS 6920 (potable water).

PeViCol can only be applied to gluing PVC plastic material.

Application

PeViCol can be applied to gluing PVC plastic to installations for water and to chemically loaded installations, similarly to the way PVC is applicable.

PeViCol can be applied to hard PVC plastic material without problems. By application to soft PVC plastic (hoses and special thin fittings), it is important to ensure a fast hardening time; this is achieved by applying water by flushing through, dipping them into the water or spraying with water. If this is not done, the NMP may dissolve the plastic and cause deformation, which consequently lead to inferior quality of gluing. In case of doubt it is recommended to make a gluing test, before you start up using the PeViCol.

PeViCol is delivered ready for use, and must not be mixed with other adhesives or solvents.

PeViCol must not be mixed with, or have contact with water before gluing, as this will cause the adhesive to be complete neutralize (cured).

Technical data

Form	Liquid
Colour	Transparent
Viscosity (Brookfield)	15.000-20.000 mPa.s (RVT sp 6 / 20 rpm at 23° C)
Solids content	>18 %
Specific gravity	1,12 g/ml
Boiling point	202° C
Freezing point	- 24° C

Flash point 95° C

Self ignition point 346° C

Working conditions (general)

Working temperature 0° to + 80° C (optimum temperatures +10° to +40° C)

Relative air humidity (RH) 30 - 80 % RH (optimum air humidity 50 – 70 % RH)

Glue consumption Depending on piping diameter and tolerances. The gap between pipe and fitting shall be complete filled out.

Curing process
1 hour after gluing glue can withstand a pressure of 2 bar
2 hours after gluing glue can withstand a pressure of 3 bar
3 hours after gluing glue can withstand a pressure of 4 bar

The pressure may afterwards be increased with 1 bar each hour, until the maximum operating pressure for the pipe is reached.

Note! This applies to a pipe diameter up to 65 mm. If a larger pipe diameter is glued, a curing time of at least 24 hours is recommended, before the system is pressure tested.

Cleaning
On PVC plastic, wet PeViCol is removed by dry absorbent paper.
On the skin, wet PeViCol is removed / neutralized by water.

Storage
PeViCol should be stored in tightly sealed packages in a cool place protected from sunlight. Should not be stored at temperatures higher than 30° C. Higher temperatures than 30° C may reduce the shelf life of the glue and change its color from bright yellow to brown.

Shelf life
PeViCol has as a minimum a shelf life on 1 year from the production date in unopened packaging.

Packaging
125 g plastic bottle; 570 g plastic bottle; 5,5 kg plastic container; 215 kg steel drum.

User instructions
See separate detailed "Directions for using and fitting of PeViCol", which is enclosed the packaging by sale.

Safety precautions
The Safety Data Sheet for PeViCol should be observed thoroughly before start of using the adhesive.

Our technical staffs are always happy to provide advice and guidance regarding use of our adhesive products. The above data is only advisory, as actual use of the products is outside our control.

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