

Adhesive for rigid PVC pipes

# UZIN 777

Strong contact adhesive in organic solvents for rigid PVC pipes

## Applications:

High viscosity adhesive in organic solvents for powerful and fast bonding of pipes and parts of rigid PVC-U (Unplasticized Polyvinyl Chloride). It bonds by eroding surfaces, it has excellent resistance to temperature variations (-10°C to 90°C), to chemicals (alkalis, acids, and solvents).

Suitable for:

- ▶ Longitudinal pipes and fittings made of rigid PVC for common hydraulic/plumping uses and for joints and cap nuts under pressure (approximately up to 16 atm) e.g. for irrigation-, water supplying and sewerage systems.
- ▶ Accessories made of ABS plastic (Acrylonitrile Butadiene Styrene)

## Product properties / advantages:

Ready for use, high viscosity contact adhesive in organic solvents, with wide range of technical advantages. Its high flammability and the emission of large quantities of solvent vapors make usage restrictions and protective measures necessary.

- ▶ Meets thermal and stability requirements of sanitary and industrial use.
- ▶ Fills joints up to 1mm
- ▶ Resistance to pressure up to 16 atm
- ▶ Resistant to temperatures -10°C to 90°C
- ▶ Suitable for drinking water pipes
- ▶ Strong adhesion
- ▶ Easy application
- ▶ Very fast drying

## Technical Data:

Packaging:	Aluminum tubes, tin cans
Sizes:	100gr, 250ml, 500ml and 1kg
Storage:	min 12 months
Hazard characteristics:	see "Protection of the Workplace and Environment"
Color:	Transparent
Consumption/Coverage:	100 - 250 g/m <sup>2</sup> (Double sided application)
Working temperatures:	minimum 10°C
Open time:	5-10 minutes*
Contact time:	1-2 hours*
Strain/Loading	4-5 hours*
Final Strengths:	After 24-48 hours*

\* At 20°C and 65% relative humidity.

*Note: Review carefully the hazard and safety information (see "Protection of the Workplace and the Environment").*

## Substrate preparation:

The bonding surfaces must be leveled, dry, clean, and free from dust and other substances that could impair adhesion.

Study carefully technical data and safety data sheets of UZIN Hellas products.

## Application:

- ▶ Shake well before use, remove any "skin formations" and then apply a thin, uniform layer of adhesive on each surface to be bonded e.g., first apply on the tube's exterior surface and then to the inside surface of the sleeve. Apply by means of contained (250ml/500ml packaging) brush or by similar tools e.g., sponge.
- ▶ Press down immediately to the parts to be bonded and keep them tightly for 1 minute. Don't move bonded parts for 5 minutes in order to be perfectly stabilized.
- ▶ If the ambient temperature is less than 5°C, then hold both parts at least for 15 minutes. Clean the excess of left over adhesive with tissue paper, to avoid sticking aimlessly other pieces together.
- ▶ Chamfer by 15° the cut pipes, to increase the cohesion.
- ▶ In several cases where temperature is below dew point or at frost, heat up the end pieces of pipes and sockets. PCV-U plastics become inelastic in these conditions and heating (at +25 to 30°C) by means of air pistol is imperative, in order to regain their elasticity.

## Use and pressure test!

Allow the tubes to obtain their final strengths and resistance to chemicals for 24-48 hours, before the final pressure tests. The pressure should be applied to the pipe system gradually at a ratio of 1 hour waiting time for every atm of pressure e.g. 7atm corresponding to 6 hours progressive waiting time.

Pipes could be filled with soil at least 12 hours after adhesion.

2-3 hours after adhesion and before starting, pipelines must be carefully flushed to remove possible residual hazardous solvent vapors.

Final strengths are completed after 72 hours, depending on the materials used and the applied conditions.

## Consumption:

Depends on the application.

## Important Notes:

- ▶ Shelf life minimum 12 months in original packaging, when stored in a cool, dry place. Seal tightly opened containers and use the remaining content as soon as possible.
- ▶ Place all containers stored at highly cold conditions in a warm place before use to be acclimatized properly and shake repeatedly well. Cold conditions increase the product's viscosity.
- ▶ Optimum working conditions are 15 to 25°C. Generally, the temperature should be 10°C and relative humidity below 75%.
- ▶ The above-mentioned instructions are therefore only comments for supporting competent personnel in their work. Installation of pressure pipes and couplings made of PVC-C requires expertise in the processing of the materials and full observations of the installation instructions of the pipe and fitting manufacturers.

## Protection of the Workplace and the Environment:

High solvent content. Highly flammable. Irritant. Avoid skin contact with liquid products. Solvents in this product may form an explosive air-vapor-mixture. Therefore, provide good ventilation during and after use. No smoking, no open flames. Do not inhale vapors. Switch off all electric devices like doorbells, refrigerators, electric stoves, etc. Use barrier cream and protective gloves. Observe safety information on product label as well as safety data sheet. **Information for people with allergies are available on poison control center +30 210 7793777 (Greece).**

## Disposal:

Where possible, collect all product waste and re-use. Do not allow drains, water courses or landfill. Empty, scraped-out and drip-free metal containers are recyclable. Containers with unhardened residues and collected unhardened product residues are Special Waste. Hardened product residues, as well as containers with hardened residues are classed as Construction Waste.