

## PRODUCT DATA

Date: June 2013

Information Sheet No.: TDS01448-02

# EVO-STIK 3019

## SOLVENTED ADHESIVE

**EVO-STIK 3019** is a thixotropic solvent cement conforming to BSI specification BS EN 14680 for non pressure pipe. The product is independently tested to the standard by BSI and carries both Kitemark and CE marking. Its thixotropic properties allow a high coating weight to be applied, thus providing good adhesion and sealing action even where there are gaps (up to 0.8mm) between the surfaces to be bonded.

### RECOMMENDED USE

**EVO-STIK 3019** was designed for the spigot & socket bonding of non-pressure thermoplastic pipe systems such as PVC and ABS.

### BONDING INSTRUCTIONS

#### SURFACE PREPARATION

- Cut the pipe clean and square
- Remove any burrs and file a lead chamfer of approx. 3mm at 15°
- Roughen the mating surfaces with a medium grade emery cloth
- Clean the abraded surfaces using **EVO-STIK Cleaner 1**

#### APPLICATION

- **EVO-STIK 3019** must not be stirred
- Using a clean, flat brush apply an even layer of cement to both surfaces

### BONDING

- Immediately push the spigot into the socket
- Hold the joint in position for 10 to 15 seconds and wipe off excess cement
- Joints should not be disturbed for 10 minutes, after which they may be handled with care. Allow 24 hours for full cure at normal ambient conditions

### TYPICAL CHARACTERISTICS

|                   |                                 |
|-------------------|---------------------------------|
| Physical Form:    | Thixotropic paste               |
| Colour:           | Clear/white                     |
| Chemical Type:    | PVC polymer                     |
| Solvent:          | Ketone/speciality solvent blend |
| Solids Content:   | Approx. 21%                     |
| Specific Gravity: | Approx. 0.9                     |
| Flammability:     | Highly flammable                |

**CONSTRUCTION PRODUCT REGULATION  
DECLARATION OF PERFORMANCE**

**No: TDS 01448-02**

**Product Description:** Bostik 3019 Solvented Pipe Cement  
**Product Code:** 5000403113142, 5000403113159  
**Intended Use:** For use in the spigot & socket bonding of non-pressure thermoplastic pipe systems in PVCu and ABS  
**Manufacturer:** Bostik Ltd  
**Contact Address:** Ulverscroft Road  
Leicester  
LE4 6BW  
**System of Assessment:** System 4  
**Harmonised Standard:** BS EN 14680:2006

BSI 0086 performed the initial inspection of the manufacturing plant and of factory production control and the continuous surveillance, assessment and evaluation of factory production control under system 4 and issued the certificate of conformity of the factory production control.

**Declared Performance:**

| Essential Characteristics                                 | Performance                           | Harmonised Technical Specification |
|---|---------------------------------------|------------------------------------|
| Resistance to pull-out (shear strength)                   | ≥3.0 MPa (N/mm <sup>2</sup> ) at 480h | EN 14680:2006 Clause 4.2           |
| Tightness of bonded joints (Durability)                   | No leakage                            | EN 14680:2006 Clause 4.3           |
| High temperature resistance of bonded joints (Durability) | No leakage                            | EN 14680:2006 Clause 4.3           |

The performance of the product Bostik 3019 PVC Pipe Cement 5000403113142, 5000403113159 is in conformity with the declared performance shown in the table above.

This declaration of performance is issued under the sole responsibility of Bostik Ltd.

**Signed for and on behalf of Bostik Ltd by:**

**Name:** Alison Jamieson

**Function:** S.H.E.Q. Manager

**Signature:**



**Date:** June 2013

## PACKAGING

Please contact customer services for details of current packs

## STORAGE

Store in a dry flameproof area between 5 and 25°C.

## SHELF LIFE

12 months in its original container stored under the above conditions.

## MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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