



NON-PRESSURE PIPE CEMENT

SOLVENT BASED ADHESIVE

KEY FEATURES

- Bonds PVC & ABS
- Kite marked
- CE marked

DESCRIPTION

Bostik Non-Pressure Pipe Cement 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. The product is also approved by the Water Regulatory Advisory Service Scheme to BS EN 6920-1 for use with potable water. 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

Bostik Non-Pressure Pipe Cement was designed for the spigot & socket bonding of non-pressure thermoplastic pipe systems such as PVC-u, PVC-c and ABS.

IMPORTANT

Before embarking on any work involving **Bostik Non-Pressure Pipe Cement** the safety data sheet should be carefully studied by those carrying out the work.

TYPICAL CHARACTERISTICS

Physical form	Thixotropic paste
Colour	Natural
Chemical type	PVC polymer
Solvent	Ketone / Speciality solvent blend
Solids content [%]	Approx. 21
Specific gravity	Approx. 0.9
Flammability	Highly flammable

METHOD OF USE

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 **Bostik Cleaner 1**.

APPLICATION & BONDING

- **Bostik Non-Pressure Pipe Cement** must not be stirred, decanted or diluted.
- Using a clean, flat brush apply an even layer of cement to both surfaces.
- Replace lid immediately after use.

BONDING

- Immediately push the spigot into the socket without twisting.
- Hold the joint in position for 20 to 30 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 and 20 days before using with potable water.

BSI STANDARDS



Conforms to **BS EN 14680:2006** see attached DOP.

WRAS approved to **BS EN 6920-1** for use with potable water.

PACKAGING

For current pack sizes please contact the Customer Service Department.

STORAGE

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

SHELF LIFE

12 months from the date of manufacture shown on the container, stored closed in original packaging under the above conditions.

CONSTRUCTION PRODUCT REGULATION DECLARATION OF PERFORMANCE

No: TDS 01729-06

Product Description :	Bostik Non-Pressure Solvented Pipe Cement
Product Codes :	5000403113342 5000403113197
Intended Use :	For use in the spigot & socket bonding of non-pressure thermoplastic pipe systems in PVC-u, PVC-c 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 ²) 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 Non-Pressure Pipe Cement 5000403113342, 5000403113197 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: March 2014

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SMART HELP

Please contact your local representative



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