



ONE-COMPONENT, PVC ADHESIVE FOR BONDING PLASTIC PIPES WHICH ARE NOT UNDER PRESSURE.



### PRODUCT DESCRIPTION

PVC 650 is a one-component, colorless sealant and adhesive made from poly-vinyl acetate synthetic resin dissolved in solvent. PVC 650 has just the right viscosity and consistency for applying the adhesive in any position without it running. It is supplied ready-mixed and sets and hardens rapidly. The hardened film of adhesive remains as rigid as the pipes to be bonded and is resistant to temperatures of up to +60°C, with peaks of up to +90°C. PVC 650 is certified according to EN 14680 as adhesives for non-pressure thermoplastic piping systems.

### FIELD OF APPLICATION

- Bonding PVC pipes for drainage systems and piping in general with no internal pressure.
- Adhesive for bonding pipes in civil and industrial drain systems and assembling sleeves, siphons and fittings in hydraulic systems with no internal pressure.
- Bonding plastic pipes and guttering.
- May also be used for bonding corrugated pipes for electrical and plumbing systems

### SUITABLE SUBSTRATES

- Plastic

### LIMITATIONS

- Do not use on surfaces with traces of oil, grease or stripping compound.
- Do not use at temperatures lower than +5°C.
- Not suitable for compressive stress, tensile stress or continuous or snap shear stresses.

### APPLICATION PROCEDURE

#### A) Preparation of substrate

Surfaces must be perfectly dry, clean and de-greased before bonding them together. If necessary, clean surfaces with a cloth dipped in acetone to remove all traces of substances that could impede bonding. The ends of the pipes must have no burrs and the internal pipe must have a bevelled edge to help spread the adhesive in an even layer during assembly.

#### B) Preparing the product

Ready to be used.

#### C) Applying the product

Spread a thin, even layer of adhesive on both pipes to be bonded. The bonding surface between the internal and external pipe is proportional to the diameters of the pipes to be bonded: as a general guide, the internal sleeve must enter the external sleeve by between 20 mm and 120

mm. Immediately bond the two elements together by inserting one inside the other so that the adhesive is spread evenly over the entire contact surface. Immediately after assembling the two parts, remove any excess adhesive with a clean cloth or a suitable tool or utensil. The bonded component may be handled after 10 minutes and completely hardens after 48 hours.

### COVERAGE / CONSUMPTION

The consumption of PVC 650 depends on the application. Typical consumption is between 100 and 120 ml/mL.

### PACKAGING

PVC 650 is supplied in:  
– 280ml cartridge.

### SHELF LIFE-STORAGE

Original sealed packaging of this product is guaranteed to be of first quality for 18 months if stored in a dry area and temperatures between +5°C and +35°C.

### PACKAGING

PVC 650 is flammable. It is recommended to keep it away from naked flames and sparks, to avoid smoking, to prevent the build-up of electrostatic charges and to work in well ventilated areas. During use wear protective gloves and goggles and take the usual precautions for the handling of chemicals. If the product comes in contact with the eyes or skin, wash immediately with plenty of water and seek medical attention. Furthermore, is hazardous for aquatic life, do not dispose of the product in the environment. For further and complete information about the safe use of our product please refer to the latest version of our Safety Data Sheet. PRODUCT FOR PROFESSIONAL USE.

## TECHNICAL DATA

Product identity	
Consistency	thixotropic paste
Color	Transparent and White
Density (kg/m <sup>3</sup> )	800
Viscosity (mPa.s)	800,000
Dry solids content (%)	30
Application data (at +23°C and 50% R.H.)	
Dilution	Ready to used
Skin formation time	3 minutes
Complete drying	24 minutes
Adjusting time	10 minutes
Service temperature range	-40°C to +100°C
Application temperature	+5°C to +35°C
Consumption	100-120 ml/mL
Water resistance	excellent
Atmospheric agent resistance	excellent



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