

## 42A PVC Adhesive

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### Technical data

Basis	styrene acrylate
Consistency	Gel
Curing system	Physical drying and crystallisation
Density	Ca. 0,95 g/ml
Viscosity (Brookfield)	Ca. 10.000 mPa.s
Application temperature	5 °C → 25 °C
Consumption*	500-1000 g/m <sup>2</sup>

\* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. \*\* This information relates to fully cured product.

### Product description

42A PVC Adhesive is a ready to use gel type solvent based adhesive with filling characteristics based on vinylchloride.

### Properties

- Fast drying
- High adhesive strength
- Maximum 0,8 mm tolerance in splits.
- Max. fitting tolerance of 0,2 mm.
- Highly flammable
- Temperature resistance 80°C in normal applications.
- Withstands temperatures of maximum 50°C when applied on pressure systems.
- The adhesive layer has the same characteristics as the PVC material

### Applications

- Bonding of pipes, fittings and other materials from hard PVC (both for pressure pipes and drainage).
- Bonding of PVC pipes and -materials in sanitary applications.

### Packaging

Colour: transparent  
Packaging: 50 ml tube, 80 ml tin, 250 ml tin, 1 L can

### Shelf life

At least 24 months in unopened packaging in a dry storage place at temperatures between +5°C and +25°C.

### Substrates

Substrates: PVC

Nature: rigid, clean, dry, free of dust and grease.

Surface preparation: Clean with PVC

Degreaser 92A

We recommend a preliminary adhesion test on every surface.

### Application method

Application method: Clean material with PVC Degreaser 92A Apply 42A PVC Adhesive with brush quickly and evenly lengthwise on both parts to be bonded. Bring the parts together immediately without twisting and press firmly. Remove excessive adhesive with Adhesive Remover 90A Do not apply mechanical stress to the adhesive bond the first 10 minutes. During pressure tests respect a drying time of approximately 1 hour at 1 bar (below 10 °C different drying times).

Cleaning: With Adhesive Cleaner 90A. Cured 42A PVC Adhesive can only be removed mechanically.

Repair: With the same material.

### Health- and Safety Recommendations

Take the usual labour hygiene into account. Use only in well-ventilated areas. In case of insufficient ventilation it is appropriate to wear respiratory protection. Consult label and material safety data sheet for more information.

Remark: This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

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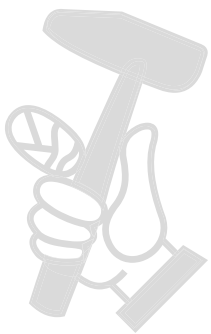
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### Remarks

- Do not join two parts with a turning movement in order to protect the waterproofness of the PVC tubes. Wait at least 6 hours before using pipes again (24 hours for pipes under pressure).

### Standards and certificates

Tested and approved according to EN14680 in order to comply with the statutory CE marking.



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