



BOND-RITE 60

Heavy Duty Cement For uPVC Pipe & Fittings

Description

BOND-RITE 60 is a clear, thixotropic, fast curing, high strength, PVC solvent cement designed for use on PVC pressure pipe and fittings. It has excellent gap filling properties and specially recommended where a sizeable gap exist between the pipe and fitting.

Application

BOND-RITE 60 is for use on all types of rigid polyvinyl chloride (PVC) pipe sizes up to 12" Type 1, Grade 1, 2, and 3, Type II, Grade 1 including schedule 80. The Water Quality Centre (UK) approves it for use with potable water pressure system. Application also includes conduit, gas and drain waste and vent (DWV).

BOND-RITE 60 solvent cement should be used as received in its original containers. Adding thinner to change viscosity is not recommended.

Bonding Instructions

A. Surface Preparation

Pipe and fittings to be bonded must be clean and dry, free from oil, dirt, moisture and grease. Pipe and fittings should be clean of any foreign material using clean rag. Glossy surface of pipe should be removed. Any water present in joint can interfere with bonding and should be removed for a suitable application.

B. Pipes & Sockets

- (i) Cut pipe squarely, remove swarf from inner surfaces and lightly chamfer the outer edges. Lightly abrade the pipe and socket with emery cloth and then degrease with fresh absorbent paper soaked in NAPCO PC-101 cleaner.

Technical Data Sheet

- (ii) Apply an even and generous coat of Bond-Rite 60 to the pipe in a lengthwise direction and then a similar but lighter coat to the fitting.
- (iii) Immediately push the pipe and fitting together to the full depth without twisting. Hold in place for 30 seconds and clean off excess cement. Allow at least 15 minutes before handling and a further 24 hours before putting the unit into service.

Specification

STANDARDS

BOND-RITE 60, in addition to meeting all the requirements of BS 4346 Part 3:1982 and confirm to ASTM D2564 requirements.

BOND-RITE 60 is tested by the water Quality Centre (UK) according to BS: 6920 water bylaws scheme/WRC Test of effect on water quality.

PHYSICAL PROPERTIES

Colour	: Clear
Resin	: Virgin PVC
Brookfield Viscosity	: 1500 ± 500 Cps
Solvent	: Mixture of Tetrahydrofuran and Cyclohexanone
Flammability	: Highly Flammable
Flash Point	: Group -18 to -7°C

BOND STRENGTH

The development of bond strength is very rapid in the first few hours. It continues to increase for a period of 12 months and then starts to level off.

Water Resistance	: Good
Solvent Resistance	: Not resistance to esters, ketones and chlorinated hydrocarbons.

Storage and Transportation

Store in a dry flame proof area between 5 to 25°C, subject to the High Flammable Liquids and Liquid Petroleum Gases Regulation 1972.

SHELF LIFE

When stored, unopened, in a cool place out of direct sunlight, has a shelf life of 12 months.

PACKING

250 ml, 500 ml, 1000 ml, 1US Gallon

Safety Precautions

BOND-RITE 60 is flammable and should not be used or stored near heat or open flames. It should be used only with adequate ventilation. Avoid frequent contact with skin. In case of eye contact, flush repeatedly with water for 15 minutes and contact a physician. If swallowed do not induce vomiting. Call a physician immediately.

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping system.

KEEP OUT OF REACH OF CHILDREN.

For detailed safety and handling advice, refer to BASA booklet 'SAFE HANDLING OF ADHESIVES AND SEALANTS IN INDUSTRY' with particular reference to section headed 'Solvent borne adhesives, sealants, primer, thinners and cleaners.'



Date of Issue : May 2005

All information and/or specification given herein are true and reliable, but it is given only for the guidance of our customers. We guarantee the quality of the product but cannot guarantee the result as the product is used in conditions beyond our control. Users are advised to confirm the suitability of the product by their own tests. Our warranty is limited to the replacement of defective NAPCO products.

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