

Description

Tangit® is a solvent borne PVC weld cement.

Application

Tangit® can be used to join PVC and ABS pipes for pressure applications. The bond is flexible, waterproof and resistant to heat, pressure and can be used for electrical conduits, gas piping and water pipes.

Technical data

viscosity:	approx. 2 000 mPa.s
gap filling properties:	approx. 0.1 mm to 1.0 mm
final bond strength:	achieved after 24 hours
temperature resistance:	-30 °C to +60 °C

Directions for use

- The surfaces to be bonded must be clean, free of dust and grease. The surfaces can be lightly roughed with sandpaper. Tangit Cleaner can be used to degrease the surface.
- Stir the adhesive well. Apply a uniform coating using a brush. First to the inside of the socket and then to the pipe.
- Join immediately. (Do not allow a skin to form).
- Hold together for 10 seconds and wipe off the excess adhesive.
- If joining a continuous pipe, wait 5 minutes before continuing with the next joint.
- Flush pipe after 24 hours to remove excess adhesive and solvent vapours.
- Wait 24 hours before subjecting the pipe to pressure.

Clean up

Spillage's can be cleaned with Tangit Cleaner.

Storage

Store in a cool, dry place. Strict batch rotation must be observed.

Shelf life

The life of an unopened container, stored correctly, is 12 months (tubes) and 24 months (tins). Exposure to high temperatures shortens the shelf life.

Health and Safety data

- Keep lid closed at all times. Do not smoke or work near machinery that produce sparks. The solvent vapours are flammable. Work in a well ventilated area.
- Wash hands after working with Tangit®. Wear gloves in cases of prolonged exposure. Clean hands with solvent before the adhesive cures. Wash hands with soapy water before eating or drinking.

Pack sizes available

50ml and 100ml tubes	1 L tin with brush
250ml and 500ml tins with brush	500ml tin Tangit Cleaner

Tangit® Pipe Weld Application Instructions

- All pressure 0 – 16 Bar
- All temperature: -30 degrees Celsius to +60 degrees Celsius
- SABS 1655 (RSA) approved
- Gap-filling: Up to 1mm to ensure a solid weld
- Flexible: Resistant to temperature expansion as well as ground and wall movements

Joining:

Ambient Temperature	Open Time
20 degrees Celsius	4 min
25 degrees Celsius	3 min
30 degrees Celsius	2 min
40 degrees Celsius	1 min
More than 40 degrees Celsius	Less than 1 min

Open time depends on the ambient temperature and on the thickness of the adhesive film. The times showed here are all related to Tangit® PVC-U adhesive and an adhesive film thickness of 1mm.

Waiting Time/Loading:

Do not move pipes for at least 5 minutes after joining. At temperatures below +10 degrees Celsius the waiting time should be increased to at least 15 minutes. The joined pipes can be lowered into the ground after 10 to 12 hours.

Pressure Test:

Wait for 24 hours after completing the last bond before filling the pipelines and testing under pressure at 1.5xPN. As a rule of the thumb, if the pipeline is to be operated at working pressure (repair), the waiting time is 1 hour per 1 bar of working pressure. Pipelines that are not to be used immediately should be rinsed thoroughly with water and remain filled with water until required, where possible.

Safety Measures:

Both Tangit and Tangit Cleaner are flammable. Solvent fumes are heavier than air and can form explosive mixtures. For this reason ensure sufficient ventilation during processing, drying and also after joining.

For detailed instructions on solvent welding, contact Henkel SA (Pty) Ltd – Toll free on 0800 138181

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