

All Pressure

For bonding of thermoplastic PVC-U

CHARACTERISTICS

- High pressure max. 16 bar
- KIWA en KOMO certified
- Chemical resistant
- Gap filling and thixotropic
- Insensitive to bacteria
- 24 months Shelf life
- CE Marking and DoP (00131)



APPLICATION FIELD

Tangit All Pressure Hard-PVC glue is suitable for bonding pipe systems, sleeves and fittings made of PVC-U, where there is a high pressure (max. 16 bar) and/or chemical load. Gap filling up to + 0.6 mm. Tangit All Pressure meets the standards: DIN 16970, CSTB 15/81-57, KIWA (up to 90 mm outer diameter) and KOMO (from 40 mm to 160 mm outer diameter). Suitable for use in the distribution of cold water in drinking water pipes, indoor sewers, industrial installations for the transport of liquid or gaseous substances, drainage pipes for the discharge of wastewater or rainwater, etc. Insensitive to bacteria. Always use Tangit Cleaner for cleaning of the PVC-U pipes to be glued and for cleaning brushes. Tangit All Pressure is developed for bonding thermoplastic pressurized PVC-U piping systems according to EN1452 and EN ISO15493.

Tangit All Pressure complies with the requirement of EN14814, Adhesives for thermoplastic piping systems for fluids under pressure and EN14680, Adhesives for non-pressure thermoplastic piping systems.

INSTRUCTIONS FOR USE

Deburring and chamfer the pipe (15 °). Then deburring the inside. Remove heavy dirt adherent to the surfaces to be bonded (pipe end outside, socket inside). Then measure the fitting insertion depth (= bond length) and mark it on the pipe end so that the application of the required amount of adhesive and the complete insertion of the pipe can be checked. Final cleaning is done using Tangit Cleaner PVC-U/C/ABS. Spray the cleaner onto white tissue paper and thoroughly clean the dry surfaces to be bonded so that they are free of dirt and grease. Use a new piece of tissue paper for each cleaning operation. The cleaned surfaces must be dry before applying the adhesive. Any ice must be removed by careful heating.

Pipe outer diameter -d (mm)	Pipe socket	Fitting
Up tot 16	=2	= 2
20 – 50	3 - 5	= 3
63 – 110	6 – 10	= 5
125 – 200	11 – 18	= 5
225 – 315	20 – 26	= 5

Insertion depth in mm

Outside pipe diam. -d (mm)	Socket connection	Insertion depth
16	34	14
20	35	16
25	35	19
32	35	22
40	44	26
50	55	31
63	69	38
75	77	44
90	87	51
110	101	61
140	121	76
160	135	86
225	180	119
280	217	146
315	240	164

APPLICATION

Before start of operation, pipelines must be thoroughly flushed in order to remove residual solvent vapours. Tangit All Pressure is ready for use and must under no circumstances be diluted. Tangit All Pressure and Tangit Cleaner affect PVC-U. Pipes and fittings should therefore not be exposed to spilled adhesive/cleaner. Tightly close containers no longer in use in order to avoid solvent evaporation and thickening. Remove the skin of dried-up adhesive. Strip off thickened adhesive adherent to the brush with dry tissue paper. Cleaned brushes must be dry prior to further use.

Stir Tangit All Pressure well before use. The adhesive should flow slowly off a stick held at an angle, forming a trail. In an axial direction apply a uniform coat of adhesive - first to the inside of the socket, then to the pipe. Apply thinly inside the socket in order to avoid the detrimental formation of beads inside the pipe, but apply generously to the pipe end.

Tangit All Pressure is able to bridge gaps (caused by pipe tolerances) of up to +0.6 mm.

Recommended brush size:

DN 32	8mm Round brush
DN 40-63	1" Flat brush
DN 75-160	2" Flat brush
DN 225-280	2.5" Flat brush
Above DN 300	3" Flat brush

Immediately insert the pipe into the socket to stop resp. to full depth, without twisting or jamming. Hold fast for several seconds until the adhesive begins to dry. From d160 upwards, insertion is facilitated by using a pipe joiner. Remove any excess adhesive with tissue paper immediately after joining. As the adhesive cures rapidly, the components must be completely joined within 4 minutes after application. Since the application of Tangit in tubes is more time consuming, this procedure should not be applied with pipes exceeding d90. From d90 upwards, the adhesive should be applied to pipe and socket simultaneously by two persons.

The open time of Tangit All Pressure i.e. the time from the start of adhesive application until joining the parts, depends on ambient temperature and/or film thickness of the applied adhesive. With a film thickness of 1 mm, the parts should be joined within the following times:

Temperature °C	Open time minutes
20	4
25	3
30	2
40	1
>40	<1

During the first 5 minutes after bonding, the pipes must not be moved. At temperatures below +10°C, this time must be extended to at least 15 minutes. The bonded pipes should be lowered into the trench after 10 to 12 hours. Wait 24 hours after the last bonding before filling the pipes or performing leak tests (up to a test pressure of 1.5 x PN). If the pipeline is to be charged with the operating pressure, a minimum waiting time of 1 hour per bar must be observed. If lines are not to be operated immediately, it is recommended to flush them thoroughly. Leave them filled with water and flush them periodical.

CONSUMPTION

For the production of one bonded joint the following approximate amounts of adhesive and cleaner are required:

Pipe dimension d (mm)	20	32	50	63	75	90	110	140	160	200	225	315
Tangit All Pressure (g)	3	5	9	15	20	36	60	90	120	200	300	500
Tangit Cleaner (ml)	3	5	9	11	13	14	17	21	25	45	65	102

Please note: The adhesive amounts indicated above are maximum values based on laboratory experience.

The actual consumption in a given application depends on working method, pipe gap and temperature.

TECHNICAL DATA

Composition	Solvent-containing adhesive based on Tetrahydrofuran (THF stabilized).
Density	0,96 g/cm ³
Viscosity	1800 - 3500 mPas (Epprecht Viscometer, 23°C)
Open time	Approx. 4 minutes (Henkel method)
Heat resistance	Corresponds to that of PVC-U (± 60°C)
Application temperature	+5°C - +35°C
Final Strength	24 hours



OTHER

Packaging	<ul style="list-style-type: none">• Box of 12 tubes of 125 g• Box of 12 cans of 250 ml with brush• Box of 12 cans of 500 ml with brush• Box of 6 cans of 1l with brush• Box of 6 cans of 1l• Can of 4,5 kg• Drum of 170 kg
Shelflife	Can be stored for 24 months in unopened packaging if stored cool and frost-free at +20°C. See production date on the front of the tin or on the fold of the tube.

HEALTH AND SAFETY

Before using the product, please see related Material Safety Data Sheet.

Tangit adhesives and Tangit cleaner are flammable. Solvent vapours are heavier than air. They may accumulate at ground level and form explosive mixtures. Therefore, ensure sufficient airing and ventilation during application and drying. No smoking and no welding in the working area and in the rooms adjacent to it! No open light or fire, avoid any sparking or static charge! Accumulated solvent vapours and explosive mixtures must be removed prior to welding. Fill the pipes with water, flush and purge them well. Do not close / seal the pipes while drying. Prolonged inhalation of solvent vapours may be injurious to health. In order to minimize exposure to solvent vapours, keep used tissue paper in closed containers (e.g. buckets with lids). As precaution, protective gloves should be worn to avoid skin contact and maximum cleanliness should be observed (repeatedly wash hands during work and use a greasy skin cream or emulsion).

In case of contact with the eyes, rinse thoroughly with water and obtain medical advice. Immediately take off any clothing stained with adhesive.

Never use PVC piping systems with compressed air or gas!

For further information refer to the leaflets and accident prevention regulations of the employers' liability insurance associations and the safety data sheets. Detailed information on safety requirements and workplace hygiene in connection with Tangit can be found in the leaflet "Working with Tangit".

DISPOSAL

Product remains must be disposed of as special waste. Only recycle well-emptied containers with dried-up adhesive residues and free of solvent vapours. The respective codes of the European Waste Catalogue (EWC) can be enquired from the manufacturer.

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