



HCR-36

FAST, LIQUID RIGID PVC CEMENT



PRODUCT DESCRIPTION

Fast, liquid rigid PVC cement.

FIELD OF APPLICATION

For joining pipes, sockets and fittings with interference fit in pressure and drainage systems. Also suitable for PVC-C (max. 60°C). Ideal for connections demanding a high chemical resistance, such as concentrated inorganic acids such as sulphuric, nitric and hydrochloric acid, among others. Suitable for diameters ≤160 mm. Max. 10 bar (PN 10). Maximum tolerance 0.5 mm diametrical clearance / 0.2 mm press fit. Suitable for e.g. pipe systems conforming to EN 1329, 1453, 1455 and ISO 15493 (PVC/PVC-C). Use in combination with Griffon HCR-36 Cleaner and Cleaner Cloth.

Indication of chemicals for which HCR-36 should be applied:

Sulphuric acid: concentrations > 70%

Hydrochloric acid: concentrations > 25%

Nitric acid: concentrations > 20%

Alkalis (caustic soda): concentrations > 35%

Hydrofluoric acid: any concentration

Sodium hypochlorite: active chlorine content > 7.5%

PROPERTIES

- Very high chemical resistance
- Fast
- Liquid

PREPARATION

Working conditions: Do not use in temperatures ≤ +5°C.

APPLICATION

Coverage: Indication of the number of adhesive joints per 1 L:

Ø	20	32	40	50	75	90	125	160
#	1300	650	290	160	90	70	30	20

Directions for use:

1. Saw off pipes squarely, chamfer and deburr. 2. Stir well before use. 3. Clean adhesive surfaces with Griffon HCR-36 Cleaner and Cleaner Cloth. 4. Apply adhesive rapidly and evenly lengthways to both bonding surfaces (pipe thickly, sleeve thinly). In a diametrical clearance (max. 0.5 mm), apply a second, and optionally, a third adhesive layer, with a drying time of about 30 sec. between the application of the adhesive layers. Prevent the previous adhesive layer to be removed. 5. Assemble joint immediately. Remove excess adhesive. Do not load the joint mechanically for the first 10 minutes. Properly close the container immediately after use.

Stains/residue: Remove adhesive stains with Griffon HCR-36 Cleaner and Cleaner Cloth.

Points of attention: Open tin carefully, it may be under pressure due to temperature fluctuations.

CURE TIMES*

Drying/Curing time: approx. Minimal 24 hours

* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

TECHNICAL PROPERTIES

Temperature resistance: +60°C, peak load 95°C

Chemicals resistance: Resists very well to powerful anorganic acids such as sulphuric acid, hydrochloric acid and nitric acid.

TECHNICAL SPECIFICATIONS

Chemical base: Solution of PVC-C in a mixture of solvents

Colour: Yellow (transparent)

Viscosity: approx. 220 mPa.s., Liquid

Solid matter: approx. 11 %

Density: approx. 1.35 g/cm³

Flash point: K1 (<21°C)

STORAGE CONDITIONS

At least 12 months in the unopened package and stored between +5°C and +25°C. Close the container properly and store in a dry, cool and frost-free location. Limited shelf life after opening.