

HCR-36

LOW-VISCOSITY, RIGID PVC CEMENT



APPLICATION

Coverage: Indication of the number of connections per 1 L:

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

Directions for use:

1. Cut pipes square, chamfer edges and remove burrs. 2. Clean and degrease surfaces to be glued with Griffon HCR-36 Cleaner 3. Apply cement quickly and evenly lengthwise on both surfaces to be joined (pipe thick, socket thin). With diametrical clearance (max. 0.5 mm) apply a second and, if necessary, a third layer of cement, with a drying time of approx. 30 sec. between application of layers. Avoid removing previous layer 4. Join parts immediately. Joint may be adjusted for a few seconds. Remove excess cement. Do not mechanically submit joint to a load for first 10 minutes. Close packaging carefully immediately after use.

Stains/residue: Remove cement stains with Griffon HCR-36 Cleaner.

Points of attention: Open with due caution, as tin may be under pressure due to temperature fluctuations.

CURE TIMES

Dry/Cure time: approx. At least 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. 250 mPa.s.

Solid contents: approx. 11 %

Density: approx. 1.34 g/cm³

Flash point: K1 (<21°C)

STORAGE CONDITIONS

At least 12 months, if stored in a well-closed packaging in a dry place at a temperature between +5°C and +25°C. Limited shelf life after opening.

PRODUCT DESCRIPTION

Low-viscosity, 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). Especially for connections demanding a high chemical resistance, such as highly anorganic acids like sulphuric acid, hydrochloric acid and nitric acid. Suitable for diameters ≤ 160 mm. Max. 10 bar (PN 10). Maximum tolerance: 0.5 mm diametrical clearance / 0.2 mm press fit. To be used in combination with HCR-36 Cleaner. Suitable for pipe systems in accordance with e.g. EN 1329, 1453, 1455 and ISO15493 (PVC/PVC-C).

Indication of chemicals which require use of HRC-36:

Sulphuric acid: concentrations > 70%

Hydrochloric acid: concentrations > 25%

Nitric acid: concentrations > 20%

Lyes (caustic soda): concentrations > 35%

Fluoric acid: any concentration

Sodium hypochlorite: active chlorine content > 7.5%

PROPERTIES

- Very high chemical resistance
- Low-viscosity
- Fast

PREPARATION

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

Our advice is based on extensive research and practical experience. However, in view of the large variety of materials and the conditions under which our products are applied, we assume no responsibility for the results obtained and/or any damage caused by the use of the product. Nevertheless, our Service Department is always at your disposal for any advice needed.