

# HCR-36

## LOW-VISCOSITY, RIGID PVC CEMENT



### 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.

### 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/cm<sup>3</sup>

**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.