

Application of SabaPVC S3

Attention

If you are working with solvent-based products, please ensure for sufficient ventilation and avoid fire and sparks.

1. Preparation



- cut off the pipe at a right angle, bevel (15°) and deburr
- mark the push-in depth of the pipe
- clean with Sabaclean PVC & ABS until surface tarnishes
- remove any moisture with clean paper or a non-fluffy cloth

2. Adhesive application



- apply adhesive evenly to pipe and fitting
- apply thin layer of adhesive around the inside of the fitting
- apply thick layer lengthwise along the pipe
- avoid excess adhesive residue in the pipe

3. Mounting and finishing



- immediately connect pipe to the fitting, in a straight way and without turning, then hold together for a few seconds
- remove excess adhesive immediately
- do **not** move the bonded pipes for 5 minutes after bonding, or for 15 minutes in temperatures below 10 °C. Pipes with a diameter larger than 63 mm should **not** be moved for 30 minutes.

SABA Dinxperlo BV

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Our recommendations and instructions for use are based on the current state of know-how and technique. Clients and users must evaluate our products themselves in terms of their desired application and requirements. We are not liable if our products are used without due consideration of our recommendations and/or operating instructions. Furthermore, SABA' Dinxperlo BV's General Terms and Conditions apply to our recommendations and instructions for use and to the supply of our products.

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Prevent heavy mechanical stress like moving the pipes or closing the trench within 10-12 hours. Before putting pressure on the construction, please consider the adhesive's drying time (see table below):

diameter (mm)	temperature (°C)	drying time		
		bar <10 (hours)	bar 10-15 (hours)	bar 16-25 (hours)
16 - 75	> 15	2	8	12
	5 - 15	4	12	24
90 - 160	> 15	4	24	48
	5 - 15	8	36	72
200 - 400	> 15	8	36	72
	5 - 15	16	48	96

General issues

- follow the pipe and fitting instructions from the supplier
- blow pipes that will not immediately be used through or fill with water
- do not dilute SABA PVC adhesives
- do not use any thickened adhesive
- remove spilled adhesive or cleaner immediately
- close cans immediately after use
- wind will reduce the open time

Coverage per bond and brush advice*

pipe diameter (mm)	push in length (mm)	SabaPVC S3 (connections per litre)	brush type (cm)
16	14	1900	round 0,75
20	16	1335	round 0,75
25	19	900	flat 2,50
32	22	600	flat 2,50
40	26	365	flat 2,50
50	31	195	flat 2,50
63	38	125	flat 5,00
75	44	90	flat 5,00
90	51	70	flat 5,00
110	61	40	flat 5,00
125	69	30	flat 5,00
140	76	25	flat 5,00
160	86	20	flat 6,00
200	107	10	flat 6,00
225	120	9	flat 6,00
250	132	7	flat 6,00
280	147	5	flat 7,50
315	165	4	flat 7,50
400	208	2	flat 7,50

*These values are based on average quantities used in practice. In reality, the quantity is dependent on the specific conditions as the kind of application, the viscosity of the adhesive, diametrical clearance and temperature.

Safety recommendations

For additional safety information please refer to the relevant SABA safety information sheet.

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