

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.

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		
		0 bar / no pressure (hours)	bar <10 (hours)	bar 10-15 (hours)
16 - 63	> 15	-	2	4
	5 - 15	-	4	8
75 - 90	> 15	-	4	8
	5 - 15	-	8	16
16 - 160	> 15	1	-	-
	5-15	2	-	-

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 2810 (connections per litre)	brush type (cm)
16	14	2000	round 0,75
20	16	1500	round 0,75
25	19	1000	flat 2,50
32	22	700	flat 2,50
40	26	500	flat 2,50
50	31	300	flat 2,50
63	38	240	flat 5,00
75	44	190	flat 5,00
90	51	150	flat 5,00
110	61	100	flat 5,00
125	69	60	flat 5,00
140	76	50	flat 5,00
160	86	40	flat 6,00

*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.