

Test Your Joint

Pressure testing can be done once all joints are fully cured and anchored properly.

Such tests should be carried out in accordance with pressure test procedures in your contract documents, council codes of practice or as outlined in the NZS 4404:2010 Land Development and Subdivision Infrastructure Standard.

Health & Safety

Always use disposable polyethylene gloves when applying Pureseal PVC Priming Fluid and Pureseal PVC Pipe Cement products. They may be harmful if swallowed and may cause skin or eye irritation.

Ensure there is good ventilation (especially in confined spaces) or use suitable breathing equipment to avoid inhaling toxic solvent vapours. These products are highly flammable. Keep away from ignition sources and store in a cool, dry place away from direct sunlight. Ensure product lids are firmly sealed.

Do not introduce additives of any kind to the priming fluid or solvent cement. These products have an expiration date. Discard product if it has expired, or if the texture has changed as it may no longer be effective.

For comprehensive Safety Data Sheet information, visit our website.



Industry Guidelines

For further information, Soudal recommends reading the following publications:

- Plastic Industry Pipe Association (PIPA) guidelines for solvent cement jointing of PVC pipe.
- AS/NZS 2032 installation of PVC pipe systems (Aust/NZ standard).

Estimated Useage

The following table outlines the number of joints that can be cemented using Pureseal's PVC products.

NOMINAL DIAMETER DN	CLEANER PRIMER (500ml)	SOLVENT CEMENT (500ml)
15	1050	300
20	625	175
25	450	130
32	325	95
40	250	70
50	150	42
65	125	35
80	100	30
100	70	25
125	55	20
150	45	15
200	27	8
225	20	14
300	6	12
375	4	7

The directives and data contained in this documentation is provided in good faith and accurately reflect Soudal's knowledge when its products are properly stored, handled and applied under normal conditions in accordance with Soudal's recommendations. In practice, the diversity of the materials, substrates, environments, site conditions, product storage, handling and application are such that no warranty can be given in respect to the merchantability or fit for purpose, of any product. All users must determine the product suitability for their purposes through testing. This technical data sheet and product properties may change without notice so users, suppliers and retailers of Soudal products should always check that the data sheets they have are the latest. To the maximum extent permitted by law, Soudal disclaims all warranties in relation to either the manufacture, storage and end use of the product. All orders are accepted subject to our current terms of trade. If any clarification is required, please contact Soudal Technical Services or email info@soudal.co.nz.

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HOW TO USE

PVC

PIPE CEMENT

Fuse together PVC or ABS pipes and fittings to achieve a strong chemical weld and avoid leaks and ruptures using Soudal's easy-to-use products and applicators.

Pureseal PVC Pipe Cement Type N is suitable for low or no-pressure plumbing applications such as drainage, waste and stormwater systems. Pureseal PVC Pipe Cement Type P is ideal for high-pressure applications such as water mains, hot water cylinder lines, irrigation systems, industrial piping, swimming pools, spas, effluent pond pumps and agitators.

Always use Pureseal PVC Priming Fluid first to prepare and clean the inner surfaces of PVC or ABS pipes and fittings before you apply pipe cement. Your joint connection will then be as strong and durable as possible.

The Pureseal Advantage

Soudal's world-leading manufacturing process delivers exactly what trade professionals need while minimising harmful chemicals. The result is Pureseal PVC priming and cement products you can trust.



How does Solvent Cement Welding work?

PVC pipe cement softens, swells and dissolves the surface of PVC pipes and fittings. When applied on two surfaces that are then brought together, it will bond into one sold material as it cures. Strength develops as the solvents evaporate, creating a leak-free joint.

Follow the steps in this 'how to' guide to achieve the best result.

STEP 1 PREPARE THE PIPE

Cut the pipe square and check the pipe spigot and socket are not damaged. Remove any burrs, sharp edges and pipe shavings to avoid displacing any cement when you bring pipes and fittings together. Failure to correctly deburr may prevent full pipe penetration and/or cause solvent cement to pile up and create problems at the back of the joint.

STEP 2 DRY FIT THE JOINT

Check the spigot and socket for an interference fit. This dry fit must reach between one and two thirds of the socket depth.

STEP 3 CHOOSE AN APPLICA-

Pureseal PVC Priming Fluid comes with a dauber applicator (except 5L), while Pureseal's PVC Pipe Cements (Type N & P) come with a brush (except 5L). Check if these are the right size for the pipe and fittings you are joining together. Your brush should be large enough to apply the solvent cement within 30 seconds. Ideally your applicator width should be about 50% of the pipe diameter. Use disposable brushes for pipes larger than 100mm in diameter. Pour the product into a larger container if you need to use a bigger brush.

STEP 4 PRIME BOTH SURFACES

Pureseal PVC Priming Fluid MUST be used to clean and prime all surfaces without exception. This will soften the surface of the PVC so the solvent cement can bond correctly. Do not use sandpaper as this will introduce surface contaminants and reduce the bond strength. Clean and dry the pipe connection surfaces. Any moisture may lead to joint failure. Apply priming fluid using the supplied dauber or with a lint-free natural fibre cloth. Wear correct PPE including gloves.

STEP 5 APPLY SOLVENT

Read all health and safety warnings and first aid notices on the product label. Make sure your solvent cement is in good condition (not globular or tacky) and runs freely from the brush. Discard if necessary and use fresh stock. Apply an even coat of Pureseal PVC Pipe Cement to the internal surface of the socket first.

Be careful that excess cement doesn't pool at the back of the socket as this could weaken the pipe. Then apply an even layer to the spigot down to the witness mark (solvents will evaporate faster from the exposed spigot so this should be coated last). Ensure the entire surface is thoroughly wet with fluid cement before assembly. Any dry patches may hinder insertion and will not bond correctly. Always re-coat pipes and fittings if the product begins to dry before assembly. Dispose of any un-used product. Do not return it to the storage can.

STEP 6 ASSEMBLE AND HOLD

The new joint must be assembled while both surfaces are still wet and the cement is fluid (i.e. within one minute). Push the spigot into the socket. Do this in a single movement – if you stop half way through, it will begin setting immediately. The final 10% penetration is vital to the interference fit, so push the assembly home firmly. Make sure the spigot stays off the ground to avoid contamination with any soil or sand. Hold the joint completely still for at least 30 seconds. Any movement will reduce the finished strength. You may need mechanical force for larger joints so have pipe pullers or polyester straps etc ready in advance if required.

STEP 7 WIPE OF EXCESS

A consistent bead of solvent cement must be visible at the joint mouth. With a clean rag, wipe away any excess product on the joint exterior for a tidy finish.

STEP 8 DO NOT DISTURB

Keep the joint still for at least five minutes. Handle carefully for at least one hour after jointing.

STEP 9 CURING

Joint curing time will depend on temperature and humidity levels. It will typically take 24 hours to cure at 16˚C or warmer. Allow up to 48 hours to cure if 15˚C or colder. If 30˚C or hotter, the solvent will evaporate too fast without penetrating the pipe surfaces and the bond will fail. Do not fill the pipe with water for at least one hour after making the last joint. Do not pressurise the line until new joints are fully cured.

