

STEP-BY-STEP PLAN PERFECT CONNECTION



In addition to high-quality products, the correct process of application is also essential in order to create a perfect connection. Below you will find a complete step-by-step plan in which the application instructions for joining a PVC pipe system are described.



STEP 1

Saw off pipes at a right angle, chamfer (15°) and deburr.

For chamfering pipes with a diameter ≤ 63 mm, use the special Griffon chamfer tool. For removing burrs use the special Griffon deburring tool.

Mark insertion depth on the pipe and mark the correct assembly position of the fitting.

STEP 2

Clean adhesive surfaces with Griffon Cleaner and Cleaner Cloth (non-pilling cloth).

Using Griffon Cleaner ensures that the surface is free of dirt and grease and will also prepare it for optimum adhesion. Allow the surfaces to dry well in order to prevent condensation.

STEP 3

Apply cement rapidly and evenly all around (4-6x) to both surfaces (pipe thickly, fitting thinly). Avoid using an excess of cement.

Do not use PVC cements at temperatures below 5°C. At temperatures higher than 25°C, the application process must be carried out faster due to the faster evaporation of the solvents.

STEP 4

Join parts immediately. Remove excess cement using Griffon Cleaner Cloth. Excess cement may have an unfavourable effect on the pipe and weaken it.

For the first 10 minutes, do not load the joint mechanically. Take into account the drying times. Properly close the packaging immediately after use.

FOR PERFECT CONNECTIONS IN PVC PRESSURE SYSTEMS



THE SUPERIOR THF-FREE PVC CEMENT FOR PERFECT CONNECTIONS IN PVC PRESSURE SYSTEMS





PERFECT CONNECTIONS

Griffon offers a range of high-quality PVC cements specifically developed for connections in high-end PVC pressure systems. These cements each have unique and specific properties and provide the best solution for each application.

Griffon is expanding this range of PVC cements with the innovative UNI-100® XT: a new generation, THF-free, rigid PVC cement that is more user and environmentally friendly. UNI-100® XT is a thixotropic rigid PVC cement for joining pipes, sockets and fittings with press and loose fit in pressure and drainage systems. As a result of the unique THF-free formula, there are small (noticeable) differences between the UNI-100® XT and the trusted UNI-100®. Both PVC cements ensure the same end result: strong and durable connections in PVC pipe systems. The high quality and durability of both cements has been independently confirmed by various European certification institutes.

Both the UNI-100® and the new UNI-100® XT are available in a plastic bottle with a special brush integrated in the cap.

DURABLE PLASTIC BOTTLE

- Always easy to open and close
- Large cap fits comfortably in your hand
- Quick-release cap
- Does not rust or dent

SPECIAL BRUSH INTEGRATED IN THE CAP

- Apply cement fast and easily
- Ensures equal application of the cement
- Size of the brush is tailored to the pipe diameter



THF-free	yes
colour after drying	transparent (light yellow)
odour nuisance during application	medium
removing cement residue ¹	very easy
equal visible cement joint after drying	yes ²
viscosity	thixotropic, gap-filling
pressure resistance	16 bar (PN16)
diametrical clearance / press fit	0,6 mm / 0,2 mm
temperature resistance	60°C (pressure), peak load 95°C
chemical resistance	equal to PVC itself ³
maximum pipe diameter	400 mm
open time (20°C ambient temperature)	approx. 3 minutes
fixture time (hand tightness) ⁴	approx. 15 seconds

Curing times⁵

Ø	16 - 63 mm			75 - 110 mm			125 - 400 mm		
	Temp.	5 bar	10 bar	16 bar	5 bar	10 bar	16 bar	5 bar	10 bar
+5°C - +10°C	6 hours	12 hours	24 hours	12 hours	24 hours	48 hours	36 hours	72 hours	
> +10°C	2 hours	4 hours	8 hours	4 hours	8 hours	16 hours	12 hours	24 hours	

THF-free	no
colour after drying	transparent (yellow)
odour nuisance during application	high
removing cement residue ¹	easy
equal visible cement joint after drying	yes
viscosity	thixotropic, gap-filling
pressure resistance	16 bar (PN16)
diametrical clearance / press fit	0,6 mm / 0,2 mm
temperature resistance	60°C (pressure), peak load 95°C
chemical resistance	equal to PVC itself ³
maximum pipe diameter	315 mm
open time (20°C ambient temperature)	approx. 2 minutes
fixture time (hand tightness) ⁴	approx. 10 seconds

Curing times⁵

Ø	16 - 63 mm		75 - 110 mm		125 - 315 mm		
	Temp.	10 bar	16 bar	10 bar	16 bar	10 bar	16 bar
+5°C - +10°C	4 hours	8 hours	8 hours	16 hours	16 hours	32 hours	
> +10°C	2 hours	4 hours	4 hours	8 hours	8 hours	16 hours	

¹ Cement residues on PVC and hands (avoid this by wearing gloves) may continue to emit a mild odour for some time as a result of evaporation.
² Due to the evaporation of the solvent, thicker cement joints may show tiny air bubbles in the hardened cement on the outside of the joint. These tiny air bubbles do not affect the quality and strength of the joint.
³ Exceptions to this are a small number of very aggressive chemicals, such as concentrated inorganic acids, caustic solutions and strong oxidants.
⁴ In case of pipes: 50 mm, fit 0,1 mm and 20°C. Fixture time may vary depending on pipe diameter, fit, quantity of product applied, humidity level and ambient temperature, among other things.
⁵ Curing times may vary depending on a.o. surface, quantity of product applied, humidity level and ambient temperature.