


**SOLVENT CEMENT FOR POLYVINYL CHLORIDE (PVC) PIPES AND FITTINGS**
**1. Solvent cement for polyvinyl chloride (PVC) pipes and fittings (as per SLS 935)**

Parameter	Requirement	Test method								
1.1 Application properties	<ul style="list-style-type: none"><li>It shall be free-flowing and shall not contain lumps, undissolved partials, or any foreign matters that will adversely affect the joint strength.</li><li>it shall be capable of easy application.</li><li>If water is being carried in the pipes, the solvent cement shall not impart any odor, taste or colour and toxic constituents.</li></ul>	Visual inspection								
1.2 Bond strength	<table><tr><th>Curing time h</th><th>Bond strength MPa (Minimum)</th></tr><tr><td>2</td><td>1.5</td></tr><tr><td>16</td><td>2.8</td></tr><tr><td>72</td><td>5.5</td></tr></table>	Curing time h	Bond strength MPa (Minimum)	2	1.5	16	2.8	72	5.5	App. A of SLS 935
Curing time h	Bond strength MPa (Minimum)									
2	1.5									
16	2.8									
72	5.5									
1.3 Hydrostatic burst strength MPa	≤ 2.8 after two hours	App. B of SLS 935								
1.4 Film properties	<ul style="list-style-type: none"><li>The film shall even, continuous, and free of lumps and foreign matters.</li><li>The film shall sufficiently be flexible to be wrapped around a 25 mm diameter mandrel, without developing cracks or splints</li><li>thickness of the film shall not less than 0.2 mm at any point.</li><li>It shall hold in a vertical position for 5 minutes without flow or drip.</li></ul>	App. C of SLS 935								
1.5 Storage stability	The requirement 1.1 to 1.4 shall be satisfied when stored for a minimum period of 12 months.	App. A, B and C								
1.6 Self life	The requirement 1.1 to 1.4 shall be satisfied when stored for a minimum period of 24 months.									
1.7 Packing	packed in an impermeable, non-reactive, container fitted with a replaceable, air-tight lid. Lid shall be screw-cap type.									

Parameter	Requirement	Test method
<b>1.8 Markings</b>		
<b>a) Name of the products</b>	"Solvent cement"	
<b>b) Name and address of the manufacturer</b>	NEMSU HOLDINGS (PVT) LTD Idigolla watta, Panawala Road, Kongasdeniya, Nittabuwa, Sri Lanka.	
<b>c) Brand Name</b>	--	
<b>d) Trademark</b>		
<b>e) Batch or code number</b>		
<b>f) Date of manufacture</b>	YYYY-MM-DD	
<b>g) Self life</b>	"Two years"	
<b>h) Direction of use including information on the time period to be allowed between making the joint and application of any force on it</b>	<ul style="list-style-type: none"> <li>* Keep away from fire, dust, and water,</li> <li>* Avoid contact skin and eyes,</li> <li>* Replace lid immediately after use,</li> <li>* Do not dilute.</li> </ul> Clean both surfaces which are to be joined. Apply thin layer of solvent cement with the brush on both surfaces and insert the plain end fully into the socket. For best results, allow the join to dry for 24 hours before use.	<b>Visual inspection</b>
<b>i) The word</b>	"Replace lid immediately after use. Do not dilute."	
<b>j) Product certification mark</b>	SLS 935	