

GEBSOPLAST HT PLUS

FUNCTIONALITY

Liquid Glue for assembling PVC-C (C-PVC) pipe components, flexible PVC, rigid PVC (U-PVC), ABS and white PVC.

- Assembly of PVC and C-PVC pipes and connectors intended for carrying hot or cold drinking water (water for human consumption) under pressure.
- Assembly of piping elements for the swimming pool: gluing of pipes on ABS wall crosspieces, gluing of flexible PVC pipes on rigid PVC,...
- Adhesive for the assembly of C-PVC pipes and fittings : pressure, outlet, high temperature.
- Resist to very hot wash water (evacuation of dishwasher and washing machine).
- Resist to swimming pool treatment products (chlorine, bromine,...) .
- Resist to most chemicals, compatible with glued substrates,
- Adhesives for pressureless thermoplastic pipes in installations for the transport, evacuation and water storage,
- Suitable for irrigation network.

Labels and Accreditation

CE marking: DoP No 21048204-1

Drinking water compatibility: compliance with French positive lists in force

Does not contain THF (tetrahydrofuran), neither CMR components

Technical characteristics

Specifications	Characteristics
Appearance	Gel
Color	Green
Medium viscosity at 20°C	9500 mPa.s
Temperature resistance	95 °C continuous / 110 °C at peak
Solid content	24+/-2%
Shear strength at 20°C	≥ 0.4 MPa after 1h ≥ 1.5 MPa after 24h ≥ 10.0 MPa after 24 days (EN 14814)
Pressure resistance	On PVC and C-PVC : resistance to 48 bars at 20°C Resistance at 8.0 bars ≥ 1000h at 80°C (EN 14814)

Drying time to be respected	Observance of the hardening and drying times is essential to guarantee gluing of pipes.			
		Repair: Ø ≤ 110 mm	Assembly: Ø < 250* mm Repair: 110 mm < Ø < 250* mm	
	DO NOT HANDLE	WATER UNDER PRESSURE	DRAIN SYSTEMS	WATER UNDER PRESSURE
10 min	Essential 1h	Essential 1h	Essential 24h	
For circuits intended to carry water for human consumption, rinse the installation for at least 30 minutes before putting into use. * For diameters higher than 110 mm, refer to the particular case in the instructions for use.				

Application

Assemblies using the adhesive GEBSOPLAST HT PLUS should be performed in the following conditions: (Extracts from DTU 60-31, -32, -33 CH 3.21).

Application temperature must be between +5°C and +35°C.

Preparation

- Check that the end of the male tube or union is chamfered. If the tube is cut on site use a file or some other process to make a new chamfer with the same profile.
- To ensure that the male end goes fully home in the socket, measure the depth of the socket and mark it with a soft pencil or felt marker on the male end of the tube or union.
- In order to remove the surface film from the components, abrade by rotating fine abrasive paper on the parts to be assembled (male end and socket). Use of a file, rasp or saw blade is strictly forbidden for this operation.

Instructions for use

- Clean the two parts to be assembled with a clean cloth soaked in DECAPANT GEBSOPLAST. Take care not to wipe off the depth marking during this operation.
- Apply generously the glue with the brush-cap on the male part and female part, finishing with lengthwise movements.
- As the adhesive dries quite quickly fit the two parts together fully immediately, by pushing lengthwise without twisting as far as the mark made initially.
- A minimum drying time (10 min) must always be allowed before handling the assembly to prevent any relative movement between the parts.
- To avoid excessive evaporation of volatile solvents, take care to close the containers holding the adhesive and the cleaner between operations.
- In case of hot and cold water sanitary installation, and before the commissioning, rinse the system for at least 30 minutes.

Particular case of diameters between 110 and 250 mm

- The connecting must be made for 2 persons minimum.
- Abrade and bevel pipes and connectors with a grinder.
- Clean the two parts to be assembled with a clean cloth soaked in PVC pipe cleaner
- Apply a generous coat of adhesive and spread it. Make this operation quickly to limit the drying of the glue.
- The two parts must be fitted together fully immediately, pushing lengthwise without turning.
- It is necessary in any case to respect a minimal drying time of 10 minutes before handle the installation, to avoid any relative movement of parts between them.

Consumption

Number of possible connections per 100 ml:

Ø Dn in mm	32	40	50	63	80	90	100	110	125	140
Number	45	22	18	9	5,5	5	4,5	3,5	3	2

Material cleaning

If necessary, the brush can be cleaned with DECAPANT GEBSOPLAST. But this product should never be used to dilute the glue.

Precautions for use

The Safety data sheet is available by Internet on www.quickfds.com or on <http://www.geb.fr/fiches.php> .

Comments

- Application must be carried out in a place protected from the rain. In addition, it is essential to make sure that splashes (rain or other) cannot enter the can as this will destroy the adhesive remaining in the can. Similarly, it is essential to make sure that the parts for assembly, and the brush, are not wet before the adhesive is applied.
- In general, the glue joint is considered to have the same chemical resistance as the bonded material, with the exception of a limited number of very aggressive chemicals.
- Close the packaging after use in order to avoid pollution.

Storage

Store at a temperature of between +5°C and +35°C.

The expiry date on the packaging is for unopened product, store at 20°C in normal hygrometry conditions.

The information contained on the technical datasheet is provided in all good faith and results from measurements made in our laboratory. Given the number of materials, differences in quality and diversity of working methods, we recommend that users perform tests prior to application under actual conditions of use.

This document may be amended in keeping with product development and the state of our knowledge without prior notice and therefore it is recommended to check on <http://www.geb.fr/fiches.php> that you have the latest version before use.