

Special Properties:

Specific Weight:
Density 0.96 g/ml

Raw Material Basis:
PVC-U, Tetrahydrofuran (stabilized),
Methylethylketone, Cyclohexanone,
N-Methylpyrrolidone

Viscosity:
1800–3500 mPas (Epprecht-Viscosity
Meter; Measuring body 3 at 23 °C**)

Temperature Resistance:
Corresponds to that of PVC-U

Resistance Ability:
The bonds are waterproof. The chemical
resistance of the bonds, especially in the
presence of inorganic acids, is depen-
dent on the pipe tolerances, setting time,
pressure, temperature, acid type and
acid concentration.

Use Tangit 95 °C for pipes subject to
heavy temperature and pressure loads.
(Follow instructions in Tangit 95 °C tech-
nical data sheet)

**Tangit meets the requirements
stipulated in the following standards:**

- DIN 16970
with KRV regulation
R 1.1.7 Germany
- ISO 19 E – 20 E – 21 E International
- BS 4346 Part 3 Great Britain
- KIWA specification
NEN 7106 Netherlands
- ASTM D 2564 USA
- CSTB Specification France

In accordance with these standards, the
durability of Tangit cemented joints is as
good as that of the PVC material.

Tools required

Tissue paper
Paint-brush
File
Pipe profiler
Scraper
Soft pencil
Ruler
Pipe joiner (DN 150 upwards)
Paint-brush holder or lid and, to clean the
pipe: Tangit Cleanser H

Brush sizes:

up to 25 mm DN 8 mm round brush
32 to 50 mm DN 1 inch flat brush
65 to 150 mm DN 2 inch flat brush
200 to 250 mm DN 2 1/2 inch flat brush
over 300 mm DN 3 inch flat brush
(DN = Diameter Nominal)

Consumption:

To make 100 bonds, use the following
amounts of adhesive and cleanser:

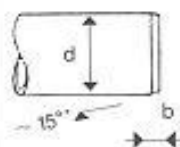
Pipe Outside Diameter DN	da/mm	Tangit- Cleanser H kg	Tangit- Adhesive kg
25	32	approx. 0.5	approx. 0.8
32	40	approx. 0.7	approx. 1.1
40	50	approx. 0.9	approx. 1.5
50	63	approx. 1.1	approx. 1.7
65	75	approx. 1.3	approx. 2.2
80	90	approx. 1.4	approx. 4.0
100	110	approx. 1.7	approx. 8.0
125	140	approx. 2.1	approx. 13.0
150	180	approx. 2.5	approx. 19.0
200	225	approx. 4.5	approx. 26.0
250	280	approx. 6.5	approx. 38.0
300	315	approx. 10.2	approx. 52.0

Technical Instructions:

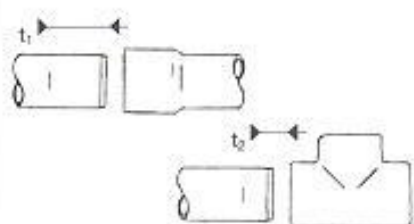
Preparation of the surface to be glued:
If the pipe and socket do not look like
those in the accompanying diagrams, cut
the pipe ends square and deburr both
inner and outer edges.



Cut the pipe square



Chamfer the outside
edge
(approx. 15 degrees to
pipe axis) and deburr
the inside.



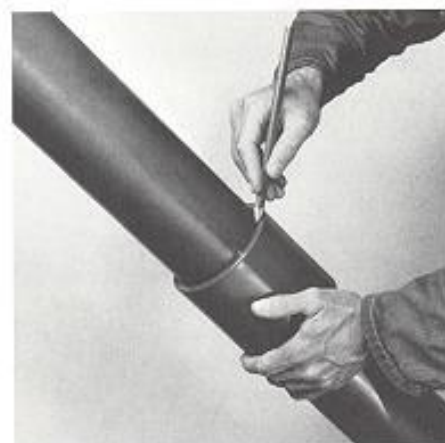
Pipe Outer Diameter (mm)	Measure for b (mm)	
	Adhesion of sleeve	fitting
to 16	~ 2	~ 2
20– 50	3– 5	~ 3
63–110	6–10	
125–200	11–18	~ 5
225–315	20–26	

Pipe Outside Diameter d (mm)	Insertion Depth (mm)	
	Sleeve bonding t ₁	Fitting bonding b ₂
16	34	14
20	35	16
25	35	19
32	35	22
40	44	26
50	55	31
63	69	38
75	77	44
90	87	51
110	101	61
140	121	76
160	135	86
225	180	119
280	217	—
315	240	—

*1) 0.2518 rad



First clean the mating surface (outside of
pipe end, inside of socket). Then mark
the insertion depth on the end of the pipe
to enable application of the necessary
adhesive and full depth insertion of the
pipe to be checked. With conical fittings,
measure the length to be bonded and
mark pipe end.



Then clean thoroughly with Tangit
Cleanser H. Spray Tangit Cleanser H
onto a piece of soft paper, e.g. tissue
paper, and thoroughly clean the mating
surfaces of all grease and dirt. Use
a new piece of tissue paper for each
cleaning operation. Any ice should be
removed by careful heating.

Joint bonding

Tangit is ready for immediate use. Stir
well before use. If a stick coated with
adhesive is held at an angle, the ad-
hesive should run off slowly, forming
a trail. Apply a full, uniform coating of
adhesive in an axial direction — first to
the socket then to the pipe. In the socket,
spread Tangit thinly to prevent subse-
quent beading in the pipe; apply gene-
rously to the pipe end.

Between applications, seal the Tangit
container with the brush holder or lid,
otherwise the adhesive will dry out as
a result of solvent evaporation and will
become unusable.

Immediately push together the pipe and socket without turning, to reach the stop or to the full depth of the socket, then hold in position for a few seconds until the adhesive has set. With size DN 150 upwards, this fitting action will be easier if a pipe joiner is used. Immediately after joining, remove any surplus cement with soft paper.

Given the speed with which the adhesive sets, the two parts must be brought together within 4 minutes from the beginning of adhesive application.

Because of the time needed to cement the parts when using Tangit supplied in tubes, the pipes to be joined should not be bigger than DN 80.



For dimensions exceeding DN 80, two people should work simultaneously on applying the cement to the pipe and socket.

The open time of Tangit, which is the time from the beginning of adhesive application until the joining of the parts, is dependent on the temperature and on the thickness of the adhesive layer. With an adhesive layer of 1 mm and at the temperatures given below, the parts should be joined within the following times:

20 °C =	4 min.
25 °C =	3 min.
30 °C =	2 min.
40 °C =	1 min.
> 40 °C =	< 1 min.

For the first 5 minutes after cementing, avoid moving the pipes. At temperatures of less than 10 °C, this time should be extended to 15 minutes. Cement jointed pipes may be put into the ground after approximately 10–12 hours.

Pipes should not be filled or pressure tested to a proof pressure of $1.5 \times PN^*$ until 24 hours after the last cement joint is made. If the pipe is to be subjected to working pressure, a minimum waiting period of 1 hour per bar must be observed.

Before using the pipes in normal operation, thoroughly flush them through with water to remove any solvent vapor.

Where pipes are not required for immediate service, it is advisable to flush through thoroughly and possibly allow to stand filled with water.

Special remarks

Tangit Cement and Tangit Cleanser H attack rigid PVC. Pipes and fittings should therefore be kept away from any spillage of Cement/Cleanser H and the soft paper used for cleaning. Any containers not in use should be properly sealed to prevent solvent evaporation and resultant thickening. Remove the skin on the surface of the cement. Any thickened cement remaining on brushes should be removed with dry soft paper. Brushes may be cleaned with Tangit Cleanser H.

Special care is required when using Tangit at low temperatures.

At temperatures of less than +5 °C, pipes and fittings have a tendency towards increased sensitivity to impact (embrittlement) – hence under the long term effect of solvent vapours as in pipe sealing, there is a possibility of damage being caused to the system during the drying phase. At temperatures of less than +5 °C, therefore, particular pipe fitting techniques are required. Fitting pressure pipes and joints in rigid PVC requires specialist knowledge of the treatment of these materials. The details given here are, therefore, intended merely as explanatory information to assist trained personnel in their work. Always follow the instructions given by the pipe and fittings manufacturers. Store Tangit and Tangit Cleanser H in a cool place.

Safety precautions

Tangit and Tangit Cleanser H contain volatile solvents. When working in enclosed spaces, rooms should be well ventilated, as the inhalation of large amounts of solvent can damage one's health. To minimize quantities of solvent in the atmosphere, any used cleaning paper should be kept in sealed containers, e.g. buckets with lids, throughout the working period. Direct contact between the adhesive and the skin should be avoided. Recommended precautions

are the wearing of gloves, maximum cleanliness (washing the hands frequently) and the use of greasy hand-protective creams or emulsions.

Tangit Cement and Tangit Cleanser H are flammable. Before starting work, all exposed fires and potential sources of sparks should be removed. There should of course be no smoking and no welding in the working area. Electric fires and similar appliances should be disconnected at all times when working with Tangit. Care should also be taken to ensure that Tangit and Tangit Cleanser H are not poured into waste water systems. The solvent vapours are heavier than air. Solvent/air mixtures are explosive.

Before carrying out any welding work, solvent vapours must, therefore, be removed from pipe systems, workrooms and ducting. Pipes should be filled with water and flushed, or alternatively, to remove potentially flammable mixtures, pipes should be thoroughly purged. If possible, the pipe should be left unsealed throughout the drying phase.

These details are for guidance only. Since we have no influence over the specific working conditions or the wide range of different materials used, no claims for damages can be entertained on the basis of this information. In cases of doubt, we recommend that users carry out their own comprehensive tests. Depending on the composition of the material and the type of manufacture, PVC pipes may be of varying suitability for cement jointing. It is, therefore, strongly recommended that a bonding test be carried out on a sample of the pipe to be jointed before fitting. Our guarantee is limited to the constant high quality of our products.

Supplied in:

tubes, contents 125 g
tins, contents 250 g
tins, contents 500 g
tins, contents 1 kg

Tangit Cleanser H

Supplied in tins, contents 800 g

TANGIT

X_n = harmful F = highly flammable
contains Tetrahydrofuran, Butanone, Cyclohexanone

Warning

- Harmful by inhalation and in contact with skin
- Irritating to eyes and respiratory system

Safety advice

- Keep out of reach of children
- Keep away from sources of ignition – no smoking
- Avoid contact with eyes
- Do not empty into drains
- Keep container closed in a cool, well-ventilated place.

* PN = Pressure Nominal



PVC Rohrkleber und Reiniger „TANGIT“ Solvent Cement and Cleanser Brand „Tangit“ for PVC Pipes

- Art. N 9010 0125** Tangit Kleber 125 gr (12 Tuben/1 Karton)
Tangit Glue 125 grms (12 Tubes/1 Carton)
- Art. N 9020 0250** Tangit Kleber 250 gr (12 Dosen/1 Karton)
Tangit Glue 250 grms (12 Tins/1 Carton)
- Art. N 9030 0500** Tangit Kleber 500 gr (12 Dosen/1 Karton)
Tangit Glue 500 grms (12 Tins/1 Carton)
- Art. N 9040 1000** Tangit Kleber 1000 gr (6 Dosen/1 Karton)
Tangit Glue 1000 grms (6 Tins/1 Carton)
- Art. N 9050 0800** Tangit Reiniger 800 gr (12 Dosen/1 Karton)
Tangit Cleanser 800 grms (12 Tins/1 Carton)



Dosen mit integriertem Pinsel im Deckel Tins with Integrated Brush in the Cover

- Art. N 902P 0250** Tangit Kleber 250 ml (12 Dosen/1 Karton)
Tangit Glue 250 ml (12 Tins/1 Carton)
- Art. N 903P 0500** Tangit Kleber 500 ml (12 Dosen/1 Karton)
Tangit Glue 500 ml (12 Tins/1 Carton)
- Art. N 904P 1000** Tangit Kleber 1000 ml (6 Dosen/1 Karton)
Tangit Glue 1000 ml (6 Tins/1 Carton)



HSH PTFE Teflon Gewindedichtband HSH Brand PTFE Teflon Thread Seal Tape

- Art. H 2100 1212** 12 m lang x 12 mm breit x 0,08 mm stark
12 m long x 12 mm wide x 0,08 mm thick
- Art. H 2100 1012** 10 m lang x 12 mm breit x 0,08 mm stark
10 m long x 12 mm wide x 0,08 mm thick
- Art. H 2100 0812** 8 m lang x 12 mm breit x 0,08 mm stark
8 m long x 12 mm wide x 0,08 mm thick

Also other Sizes available
Made of 100% Teflon* PTFE

*Teflon is a registered Trademark of DuPont/Switzerland



Product Information



Tangit – the reliable, durable piping cement for pressure pipes in rigid PVC

Tangit is a special rigid PVC adhesive for joints resistant to shear strain e.g. in pipes, sheets and profiles.

Tangit can be used to join:

- pressure pipes
- gas pipes
- cable conduits
- industrial pipework
- sewage pipes

with a gap-filling tolerance of up to 1 mm – in line with the relevant standards.

It may be used for pressure-resistant pipe joints in diameters of up to 500–600 mm.

Tangit cemented joints exhibit the same properties as the PVC material itself, in terms of strength and chemical resistance, except with respect to concentrated inorganic acids. The joints are pressure-resistant. Tangit's gap-filling properties conform to the relevant standards, to a maximum of 1 mm.

