



R306 RIGID PVC ADHESIVE

1 – DESCRIPTION

Akfix R306 adhesive containing stabilized Tetrahydrofurane is suitable for joints, resistant to shear strain of pressure pipes (e. g. drinking water and gas pipes) with uPVC fittings, and gluing cable conduits, drain pipes etc in accordance with the recommendations of the Plastic Pipe Association.

2 – PROPERTIES

- High pressure resistance (16 bars)
- Water Resistant
- Chemical Resistant especially to inorganic acids
- Fast curing, maximum leak protection
- Excellent gap-filling properties
- Easy bonding even on large surfaces
- Hot and cold water pipes (60°C)
- Resistant to bacteria
- The products conforms to following standards;
 - DIN 16970
 - BS 4346
 - ASTM-D 2564
 - NEN 7106

3 - APPLICATIONS

Specifically indicated for:

- Bonding cement uPVC pipes and accessories in pressure systems up to 16 PN.
- Bonding pipes and accessories in waste systems according to the following:
 - PVC-U plastics piping systems for soil and waste discharge (low and high temperature)
 - ABS plastics piping systems for soil and waste discharge (low and high temperature)
 - PVC-C plastics piping systems for soil and waste discharge (low and high temperature)

4 - INSTRUCTIONS

Please follow the below instructions to prepare surfaces that Rigid uPVC Adhesive is applied. Otherwise, robust and stable bonding cannot be obtained.

- Cut the pipe at right angle
- Whittle both pipe parts (inside for one part and outside for the other part) to form uniform and smooth assembly
- The surfaces of the materials to be bonded should be dry and free of grease and dust
- Please use uPVC Cleaner and let the surface dry before adhesive application
- Stir and apply Rigid uPVC Adhesive lengthwise on both sides with a paint brush
- Assemble the pipe and socket without twisting within the open time and hold fast for several seconds.
- Do not expose to mechanical stress for 5 min.
- Wait 24 hours before filling the pipeline and applying a pressure test.



Outside Diameter (mm)	Assembly Depth (mm)
16	14
20	16
25	19
32	22
40	26
50	31
63	38
75	44
90	51
110	61
140	76
160	86
225	119

Consumption Amount of Rigid uPVC Adhesive for 100 Joints		
Nominal Diameter (mm)	Outside Diameter (mm)	Adhesive (Kg)
25	32	0,8
32	40	1,1
40	50	1,5
50	63	1,7
65	75	2,2
80	90	4,0
100	110	8,0
125	140	13,0
150	160	19,0
200	225	26,0
250	280	38,0
300	315	52,0

5- PACKAGING

Product	Volume	Package
R306	50 gr	25
R306	125 gr	25
R306	250 ml	24
R306	500 ml	12
R306	1000 ml	6



6- STORAGE AND SHELF LIFE

This product should be stored in its original packaging in a cool, dry place, protected from frost, sparks and flame. Do not drill before use. Close packaging after use. Keep away from children. Stable for at least 24 months for can and 12 months for tube in its packaging to temperatures of 15 ° C to + 25 ° C.

7- RESTRICTIONS

- Highly flammable.
- Irritant.
- Keep away from high temperatures, naked flame and sources of ignition.
- Only work in well-ventilated areas.

8- TECHNICAL PROPERTIES

Base	: PVC-U polymer resin, organic solvents and thixotropic agents.
Color	: Transparent
Viscosity	: 7000-15000 cP
Density	: 0.96 gr/ml
Flammability	: Highly flammable
Open time	: 20°C = 4 min 25°C = 3 min 30°C = 2 min 40°C = 1 min >40°C = <1 min
Maximum Gap Filling Capacity	: Up to + 0,6 mm
Temperature Resistance	: Up to +60°C