



BOSTIK PIPE CEMENT TYPE N

Non-Pressure PVC Pipe Cement

TECHNICAL DATA SHEET. September 2025 – Version 2

SMART ADVANTAGES

- Natural bristle brush applicator for easy application
- Ready for use, no mixing required
- Good application viscosity, easily applied with minimal dripping

DESCRIPTION

Bostik PVC Pipe Cement (Type N) is specially formulated welding cement for jointing unplasticized PVC (PVC-U) pipes and fittings in pressure piping systems.

- Conforms to Type N requirements specified in AS/NZS3879
- Suitable for use in contact with drinking water applications meets AS/NZS4020

FUNCTIONAL CHARACTERISTICS

- Generally recommended for jointing pipes 100mm or less in diameter
- Jointing PVC-U pipes to PVC-U fittings in non-pressure plumbing applications
- Jointing PVC-U pipes to ABS fittings in non-pressure plumbing applications
- Commercial and domestic drainage applications: storm water and sewerage drainage systems
- Jointing PVC-U conduits in electrical applications
- Bonding PVC-U sheets

TECHNICAL CHARACTERISTICS

Properties	Value
Colour	Clear
Viscosity	Thin liquid
Application temperature	5°C and 30°C
Initial setting time	Approx. 10 min
Setting Time	Allow 24 hours before applying any pressure to the welded joint.

INSTALLATION

PREPARATION

- Verify that the cement is suitable for the pipe and fitting materials being used.
- Check temperature where the application will take place:
 - Cements take longer to set in cold weather. Allow extra time for curing. Do not try to speed up the cure by artificial means – this could cause bubbling and porosity in the cement film.
 - Solvents evaporate faster in warm and windy weather. Work quickly to avoid the cement drying before the joint is assembled. Avoid working in direct sunlight and on warm pipes. It is recommended that storage of materials and application should be in shaded areas. Ideal application temperatures are between 5°C and 30°C out of direct sunlight.
- Shake the cement bottle well before use.
- Ensure appropriate personal protective safety equipment is worn when using the solvent cement/priming fluid.
- DO NOT mix any additives to the priming fluid or pipe cement.
- Do not use gelled or lumpy cement. It should be the consistency of syrup.
- Coloured cements and priming fluids will leave a permanent stain. Avoid spills. There is no known cleaning agent. The stain may fade over time or after exposure to direct sunlight.

PRIMING

Bostik PVC Priming Fluid Red must always be used for cleaning and priming substrates prior to application of Bostik PVC Pipe Cement.

APPLICATION

Jointing of pipe

- Jointing procedure must be in compliance with the most current edition of AS/NZS 2032: Installation of PVC pipe systems.
- Cut the end of the pipe square and remove all burrs and sharp edges from the inside and outside of the pipe.
- Check the dry fit of the pipe and fitting before priming fluid/cement application. Check and ensure for proper interference fit.

- With the pipe fully engaged in the fitting, mark the pipe with a witness mark at a distance equal to full fitting depth. Use a pencil to mark the pipe. Do not score the pipe. The priming fluid and cement must be coated slightly beyond the witness mark on the pipe.
- Ensure the pipes and fittings are dry and clean. Wipe any moisture and dirt off the outside surface of the pipe and inside surface of the fitting with a CLEAN rag. Do not use oily/dirty rags.
- Thoroughly prime the inside of the fitting and external surface of the pipe with Bostik PVC Priming Fluid. Do not use dirty rags. Ensure 100% of the joint areas are covered with priming fluid. Ensure the application of the cement can occur immediately after primer application.
- First, immediately apply an even coat of the pipe cement to the inside of the fitting then coat the external area of the pipe. Ensure 100% of the joint areas are covered with cement.
- While the cement is still wet, immediately insert the pipe into the fitting ensuring to meet the witness mark. If the cement has dried do not continue and recoat both the pipe and fitting. A dry joint will fail.
- Firmly hold the assembled joint together for at least 1 minute to prevent the pipe from kicking out. Without disturbing the joint carefully wipe any excess cement from the joint and allow the assembly to sit undisturbed for 5 minutes.
- Allow a minimum of 24 hours before putting the joint into service.

Bonding of PVC-U Sheet

- Ensure PVC-U sheets are clean, dry and free from burrs.
- Clean and prime both sheets with Bostik PVC Priming Fluid.
- Apply cement in a thin even coat to both surfaces and whilst still wet, position together.
- Weigh down or clamp until initial bonding takes place - approx. 10 minutes (depending on weather conditions). While clamped wipe off any excess cement from the edges of the sheets before it dries.
- Allow 24 hours to set before applying any stress or strain on the bond.

LIMITATIONS

- At temperatures greater than 30°C, rapid evaporation of solvent can occur before the solvents can penetrate the pipe surfaces. This may prevent a satisfactory bond and lead to a

dry joint resulting in a failed bond. Always re-coat the pipe and fitting if the adhesive dries during application.

- When not in use ensure the lid is tightly secured on cement and priming fluid bottles. Evaporation of the solvent will affect the performance of the product.
- For pressure applications, use Bostik PVC Type P Cement.
- This product is not suitable for use in hot water systems.
- Application to larger diameter pipes may require a larger brush than that supplied. If a small brush is used on large diameter pipes and fittings, application time and full coverage of the pipe and fitting can take too long resulting in dry joints.

Important Notes

It is recommended that this product is fully evaluated as suitable for the application methods to be employed and for suitability of performance both initially and for the expected life of your product under the condition it is expected to withstand.

CLEANING

Wash tools and equipment with water. Remove excess adhesive using a wet cloth before the product hardens. If allowed to set it must be removed mechanically.

STORAGE

This product has a shelf life of 18 months from the date of manufacture when stored in the original unopened container at normal room conditions.

PACKAGING

Size	Product codes
4L /C2	30633722
500mL/ C10	30633720
250mL/ C10	30633655

HEALTH AND SAFETY

This product is highly flammable.

Product Safety Data Sheet must be read and understood before use. These are available on request and via the websites. Visit www.bostik.co.nz for copies.

For emergency information contact the National Poisons Information Centre, phone 0800 764 766 (0800 POISON) or CHEMCALL, phone 0800 243 622.

DISCLAIMER

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