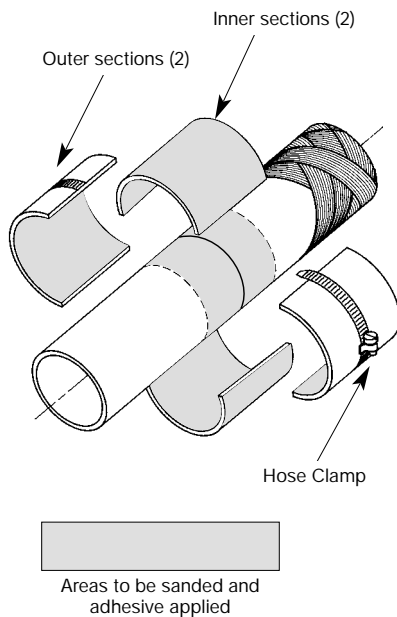


Maintenance Coupling

Assembly instructions for butt-end joints and repair

Instructions



1. Cutting the pipe — Before cutting the replacement length of pipe, allow the temperature of the existing system to stabilize to avoid length changes through expansion or contraction. Measure the replacement piece carefully so that the space between its ends and the ends of the pipe in the existing system will be no more than $\frac{1}{8}$ inch.

2. Positioning the coupling — Center the maintenance coupling over the joint and mark the lap length on the pipe ends. Sand the pipe ends with a belt sander using belts with a 40-grit abrasive. Sand inaccessible areas with a flapper sander or by hand using a “shoeshine” method. Sand until all gloss is removed from surfaces to be bonded. Sand the cut ends of the pipe as well.

3. Checking for snugness of fit — Fit the parts together dry before final sanding. The 180° inner sections placed around the pipe ends should, when held in contact on one side, show from 0 to $\frac{1}{8}$ inch separation on the opposite side. If, with zero separation, the inner sections are not snug against the pipe surfaces, file back an edge as required to get a snug fit. If the sections, when fitted snugly, show a separation of more than $\frac{1}{8}$ inch, correct any misalignment of pipe ends and sand to fit. The outer sections of the coupling should show $\frac{1}{8}$ inch or more of separation.

4. Final sanding — All mating surfaces must be clean and dry and must be sanded within two hours of assembly. Sand using a $\frac{1}{4}$ -inch drill motor at 1700-2000 rpm and a flapper type sander with a 40- 50 grit aluminum oxide abrasive, available from Ameron. After sanding, bonding surfaces should show a dull fresh finish, not a polished look.

Use special care in handling parts to avoid contamination. Handle the parts with new gloves which are used only for this purpose or with clean, dry cotton cloths.

If the bonding surfaces are wet, warm them with a Bondstrand heating blanket until dry, then resand. Protect the bonding surfaces from moisture during wet weather with tenting over the work area.

5. Selecting the adhesive — Unless the project specifications or the Bondstrand Corrosion Guide (FP132) recommends a special adhesive for your particular service, use Bondstrand PSX™34 epoxy adhesive. Instructions for mixing and using the adhesive are in the adhesive kit.

Larger couplings are more difficult to handle and assemble; once the adhesive has been mixed, the time available for assembly is limited by the adhesive pot life. A crew of two or three is suggested when assembling 8- through 16-inch couplings.

Instructions (cont.)

6. Applying the adhesive — With the spatula supplied in the adhesive kit, apply adhesive to completely cover the cut pipe edges, the prepared pipe ends and the inner surfaces of the two inner sections of the coupling. Use enough adhesive so that any excess will be forced to flow to the edges of the sections when assembled around the pipe ends. Assemble these two inner half sections by centering them around the butted ends of the pipe. If the potlife of the adhesive is now more than half expired, it may be necessary to defer further assembly and cure the inner sections. If so, clamp the sections and cure according to the instructions provided in the adhesive kit. After curing, let the parts cool completely, remove the clamps, resand the remaining mating surfaces, mix a new batch of adhesive and proceed as follows.

Apply adhesive to cover completely the outer surfaces of the inner sections. Assemble the two outer sections with the split line about 90° away from the split line in the inner sections. Place the hose clamps around the assembly and draw them tight. Remove excess adhesive for a workmanlike appearance.

7. Curing the adhesive — Heat-cure the adhesive using Ameron heating blankets. Cure time is 1 hour and 15 minutes for all diameters. Apply the heating blankets in accordance with the instructions provided with the blanket, making certain that any overlap of the blanket covers the thermostat. It is always a good idea to insulate around the heating blanket and to close the ends of the piping system to prevent movement of cold air inside the pipe while the adhesive is curing.

Maintenance coupling kit

Kit includes inner and outer sections, hose clamps and assembly instructions. Adhesive must be ordered separately.

Pipe Size	Coupling Code	Coupling Length	Adhesive Usage ^{1,2}	Pipe Size	Coupling Code	Coupling Length	Adhesive Usage ^{1,2}
(in)		(in)	(kits)	(in)		(in)	(kits)
—	—	—	—	8	80400801	5.38	3
2	20400801	4.00	1	10	A0400801	5.88	4
3	30400801	4.00	1	12	B0400801	6.38	4
4	40400801	4.00	2	14	C0400801	7.38	6
6	60400801	4.88	2	16	D0400801	8.38	8

1) Approximate number of 5-ounce adhesive kits required per maintenance coupling. Maintenance coupling kits do not include adhesive.

2) Rated hydrostatic pressure for maintenance coupling is 150 psi at 70°F. Pressure rating is reduced by 50% if RP105B adhesive is substituted for PSX™34.

Important notice

This literature and the information and recommendations it contains are based on data reasonably believed to be reliable. However, such factors as variations in environment, application or installation, changes in operating procedures, or extrapolation of data may cause different results. Ameron makes no representation or warranty, express or implied, including warranties of merchantability or fitness for purpose, as to the accuracy, adequacy or completeness of the recommendations or information contained herein. Ameron assumes no liability whatsoever in connection with this literature or the information or recommendations it contains. Product specifications are subject to change.



FIBERGLASS PIPE GROUP

Fiberglass Pipe Division Asia

Ameron (Pte) Ltd.
No. 7A, Tuas Avenue 3
Singapore 639407
Tel: 65 861 6118
Fax: 65 862 1302/861 7834

GROUP HEADQUARTERS

P.O. Box 801148 • Houston, TX 77280 • Tel: (713) 690-7777 • Fax: (713) 690-2842 • <http://www.ameron.com>

Fiberglass Pipe Division Europe

Ameron B.V.
J.F. Kennedylaan 7
4191 MZ Geldermalsen
The Netherlands
Tel: +31 345 587 587
Fax: +31 345 587 561
Telex: 40257 bonds nl

Fiberglass Pipe Division Americas

P.O. Box 878
Burkburnett, TX 76354
Tel: (940) 569-1471
Fax: (940) 569-2764

Ameron Composites

P.O. Box 71370
11 McBride Street
Newnan, Georgia 30263
Tel: (770) 253-2000
Fax: (770) 253-9234

Fiberglass Pipe Division Centron International

P.O. Box 490
600 FM 1195 South
Mineral Wells, Texas 76068
Tel: (940) 325-1341
Fax: (940) 325-9681