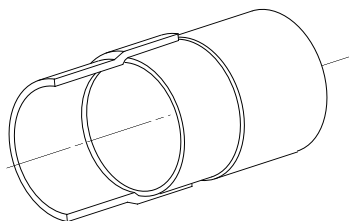


FIBERGLASS PIPE GROUP



Bondstrand RP105B Adhesive Kit

vinyl ester adhesive for bonding fiberglass pipe and fittings

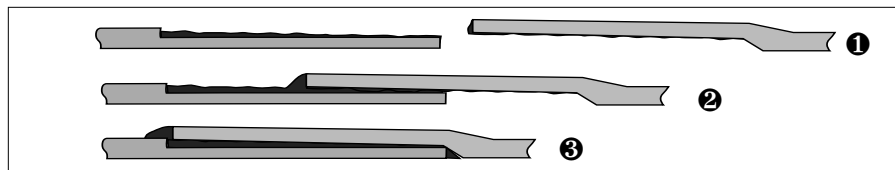
Description

The RP105B vinyl ester adhesive kit contains a paste resin, liquid catalyst, mixing spatula and assembly instructions. The resin contains aluminum oxide grit and is off-white in color with black specks. The catalyst is a white liquid. The mixed adhesive is light gray. RP105B is formulated for bonding permanent Quick-Lock joints on Ameron fiberglass-reinforced vinyl ester pipe and fittings.

Instructions

RP105B is a gap-filling adhesive designed to fill the space between the straight spigot and the slightly tapered bell (3) in the Quick-Lock joint. For proper adhesive distribution (2), apply a generous layer of adhesive to the outside of the spigot and a thin layer to the inside of the bell (1).

After insuring that the bonding surfaces are dry and clean, completely mix all of the catalyst with the resin. **Never split a kit.** Apply adhesive to both bonding surfaces and draw both parts firmly together. Required cure times must be observed. Detailed joint assembly instructions may be found in *Quick-Lock Installation Instructions, FP170.*



Pot life

RP105B will cure within 3 hours at ambient temperatures above 60°F. **Below 60°F, or to accelerate cure, an external heat source must be used.** If ambient temperature is below 60°F, or a more rapid cure is required below 80°F, use an Ameron approved electric heat blanket to supply external heat following the procedure in Steps A and B. Joint surfaces should be warmed to 70°F prior to application of adhesive when ambient temperature is below 60°F.

- A) Turn the heat blanket on for 15 minutes, then turn it off.
- B) Allow the bond to set an additional 15-20 minutes before moving.

Pot Life and Cure Time

°F/°C	60/16	70/21	80/27	90/32
Pot life (min)	25	15	10	8
Cure time (hr)	3	2	1	1

Adhesive kit sizes and bonds per kit

The values in this table are based on the quantity of adhesive required by an experienced crew working at a temperature of 80°F (27°C).

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CERTIFICATED FIRM

Kit Size (fl oz)	Total Pkg Wt (lb)	Bonds per Kit											
		Nominal Pipe Size (in/mm)											
		1/25	1/2/40	2/50	3/75	4/100	6/150	8/200	10/250	12/300	14/350	16/400	
3	1/4	10	6	4	3	2	1	1/2	1/2	1/2	1/4	1/4	
6	1/2	-	-	-	6	4	2	1	1	1/2	1/2	1/2	

1) RP105B adhesive kits are available in 3 fluid ounce (90 ml) and 6 fluid ounce (180 ml) sizes.

Toxicity and precautions

Resin: The resin contains styrene and should be used only in good ventilation. In the absence of good ventilation, a NIOSH-approved organic vapor respirator should be used. The resin may be irritating to the skin and eyes and may cause sensitization. Avoid breathing vapors. Avoid contact with eyes, skin or clothing. Wash thoroughly after handling.

Catalyst: The catalyst is a liquid dispersion containing benzoyl peroxide in dibutyl-phthalate. Do not heat above 110°F before using. Avoid contact with eyes, skin or clothing. Wash thoroughly after handling.

First aid

In case of contact

Eyes: Immediately flush eyes with lots of water for at least 15 minutes. Call a physician.

Skin: Wash skin with soap and water.

Clothing: Remove contaminated clothing and wash before reuse.

Inhalation: Remove to fresh air. Give oxygen or artificial respiration if necessary.

Ingestion: If catalyst is swallowed and person is conscious, give plenty of water or milk to drink. **Do not induce vomiting.** Call a physician. If resin is swallowed, give 100 grams (about ¹/₄ lb) activated charcoal slurry in water. **Do not induce vomiting.** Call a physician.

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.

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