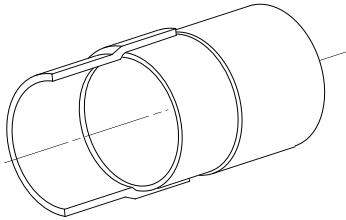




FIBERGLASS PIPE GROUP



Bondstrand RP6B Adhesive Kit

epoxy adhesive for bonding fiberglass pipe and fittings in potable water and food service

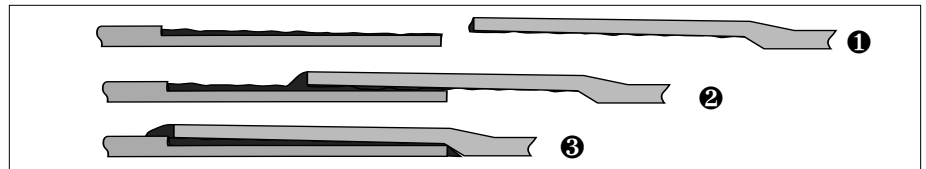
Description

RP6B is a two-part amine-cured epoxy resin system formulated for bonding permanent Quick-Lock joints on Ameron fiberglass-reinforced epoxy pipe and fittings. RP6B is FDA-approved for use in potable water and food lines. The RP6B adhesive kit contains resin, hardener, mixing spatula, paper towels and assembly instructions. A heat cure is required before joints are tested or put into service. The resin is a white paste with sand filler. The hardener is a black paste. The mixed adhesive is dark grey.

Instructions

After insuring that the bonding surfaces are dry and clean, completely mix all of the catalyst (hardener) with the resin. **Never split a kit.** Apply a uniform coat to both bonding surfaces and draw both parts firmly together. Required cure times must be observed. For service temperatures up to 150°F (66°C), a minimum cure of 30 minutes is recommended for joining pipe and mounting flanges and a minimum cure of 45 minutes for joining fittings. For service temperatures above 150°F(66°C), increase the cure times to 60 and 75 minutes, respectively. Detailed joint assembly instructions may be found in QUICK-LOCK INSTALLATION INSTRUCTIONS, FP170.

RP6B 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).



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).

Kit Size	Total Pkg Wt	Bonds per Kit											
		Nominal Pipe Size (in/mm)											
(fl oz)	(lb)	1/25	1.5/40	2/50	3/80	4/100	5/125	6/150	8/200	10/250	12/300	14/350	16/400
3	¼	10	6	4	3	2	1	1	½	½	½	¼	¼
6	½	-	-	-	-	4	2	2	1	1	½	½	½

Important: Be aware of the working time available after the adhesive has been mixed. It may not be possible to achieve the listed number of bonds in the smaller sizes because of the available working time (pot life) of the adhesive. See the adhesive kit package for approximate working times.

Pot life

ISO-9001



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Pot Life and Cure Time (minutes)				
°F/°C	70/21	80/27	90/32	100/38
3-oz kit	50	30	20	9
6-oz kit	45	25	15	7

1) Pot life is measured from when resin and hardener are first mixed until the adhesive starts to thicken and harden and can no longer be used.

An external heat source must be used to force cure the adhesive. The adhesive and bonding surfaces should be warmed to 70°F (21°C) prior to mixing and applying the adhesive. Adhesive may be force cured using an Ameron-approved heating blanket.

Toxicity and precautions

Hardener — The hardener is irritating to skin, eyes and respiratory tract. It is toxic orally and may cause sensitization. Avoid contact with eyes, skin or clothing. Avoid breathing vapors. Wear rubber gloves and apron and NIOSH-approved respirator. Wash thoroughly after handling.

Resin — The resin may be mildly irritating to skin, eyes and respiratory tract. Avoid contact with eyes, skin or clothing. Avoid breathing vapors. Wear rubber gloves and eye protection. Wash thoroughly after handling.

First aid

In case of contact

Eyes — Immediately flush eyes with plenty 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.

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