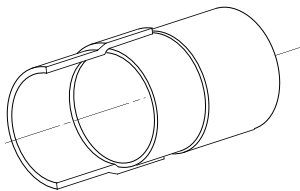


FIBERGLASS PIPE GROUP



Chem Cure Pak®

for heat assist adhesive cure methods

General

Typically, adhesives will not readily cure or set up at temperatures below 40° F, and cure times are extended at temperatures below 60°F. Therefore, when ambient temperatures fall, it may be necessary to apply heat to the bonded joint.

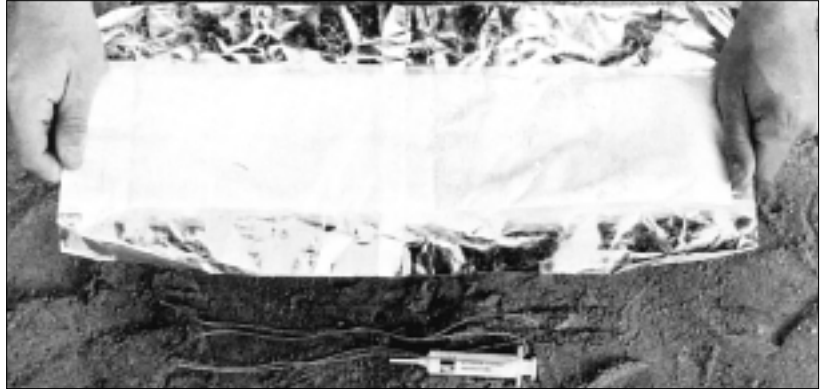
The Chem Cure Pak® or a heat blanket is recommended. These cure methods can also be used at higher temperatures when a rapid cure is required.

The Chem Cure Pak® consists of two acids mixed together as one component, and lime (CaO) as the second component. When water is added after the two components have been thoroughly mixed, a heat generating chemical reaction occurs.



Preparation of Chem Cure Pak®

- a. Remove the clips which hold the bag in a folded position and unfold the bag.



- b. Punch a 1" hole in the acid end of the bag. The acids are coarse granules while the lime is a fine powder. Allow the acid to fall into the lime section. The hole will let air into the bag making it easier to mix the two components.



- c. Grasp the ends of the plastic bag and mix the chemicals by turning the bag vertically end over end. Continue in this manner until a thorough mixture has been obtained. (Do not allow material to come out through the vent hole.)



- d. Flatten the powder in the package leaving approximately 3" of empty packaging at both ends.

Installation of Chem Cure Pak®

- e. Place the bag under joint to be cured making sure that the center of the Chem Cure Pak® is aligned with the center of the tapered pipe spigot in the joint.
- f. Wrap the bag tightly around the joint to be cured ensuring that the ingredients remain evenly dispersed. Fold the empty ends of the pak together.

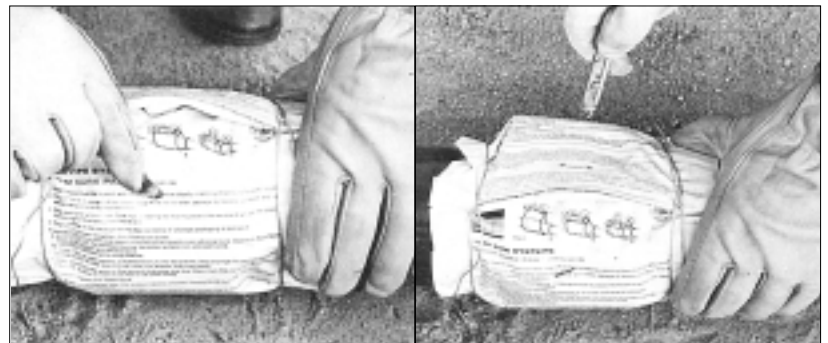


- g. Secure the Chem Cure Pak® tightly into place using tie wires.



Activation of Chem Cure Pak®

- h. Using a pocketknife or other sharp instrument, puncture a small hole through the backing and into the plastic bag on both sides of the Pak—180° apart.



- i. Fill the syringe supplied with the Chem Cure Pak® with water. Insert the syringe into each hole and discharge 1/2 the syringe (approx. 1/3 oz. [10 ml]) into each hole.



Activation of Chem Cure Pak® (cont'd)

- j. Steam should escape within a few seconds indicating that the Chem Cure Pak® is operating correctly. **Caution: Surface of Chem Cure Pak® is extremely hot while curing.**



- k. If no steam is generated, repeat step (i). If no steam is generated after the second injection of water, remove Chem Cure Pak® and repeat steps (a) through (c) with a new Chem Cure Pak®. The adhesive bond will cure within one hour. The Chem Cure Pak® may be left on the pipe without danger, either to the pipe or surroundings. Pak will not adhere to pipe surface. Untie wires to remove only when necessary.

Caution: Store unmixed Chem Cure Paks® in a dry area. Do not mix Chem Cure Paks® until ready for use. Use only Ameron Pipe Systems adhesives with the Chem Cure Pak®. Use of Chem Cure Pak® in conjunction with other brand adhesives could produce unsatisfactory results. **Danger: Contains Oxalic Acid. Harmful Dust and Vapor. Harmful If Swallowed. Causes Skin Irritation.**

Poison: Avoid contact with skin, eyes and clothing. Avoid breathing dust or vapor. Use only with adequate ventilation. Do not take internally. Keep out of the reach of children. In case of external contact immediately flush skin or eyes with plenty of water for at least 15 minutes; for eyes, get medical attention. Internal: Give tap water, milk or milk of magnesia.

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, expressed 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.



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