

SMITH FIBERCAST 8055 EPOXY ADHESIVE KIT

For use in bonding RED THREAD® II and GREEN THREAD® Bell & Spigot or T.A.B.™ (threaded and bonded) joint pipe where temperatures do not exceed the maximum rating of the pipe.

NOTE: This bulletin contains condensed instructions. Refer to Manual No. F6000 for complete installation instructions.



CAUTION



Wear gloves and eye protection. Avoid contact with the adhesive and hardener, since they are capable of causing skin and eye irritation. If contact is made, flush with water and wash with soap and water. Avoid inhaling fumes. Work in a well ventilated area.

Adhesive Mixing

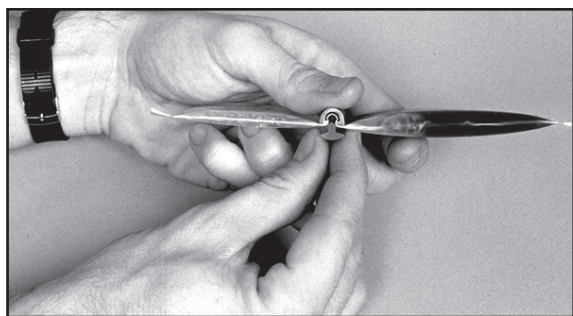
If there are any crystals in the hardener, warm to approximately 100°F and be sure all crystals are dissolved before mixing with the adhesive. For best results, base adhesive should be 80°F before mixing.

Bonding Operation

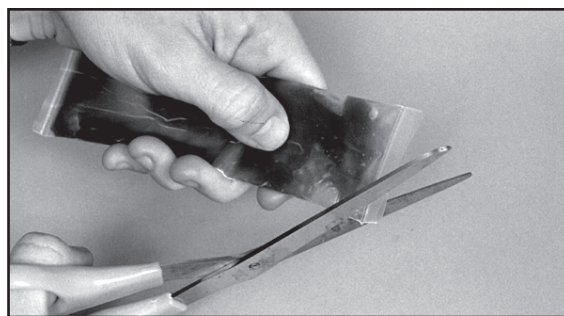
1. Wash all bonding surfaces thoroughly if they are contaminated by grease, oil, dirt, fingerprints, etc. Acceptable solvents are trichloroethylene, acetone, or methyl ethyl ketone (MEK).

WARNING

Acetone and MEK are extremely flammable. When using these solvents, do not smoke or use near an open flame. Never use gasoline, turpentine, or diesel fuel to clean joints.



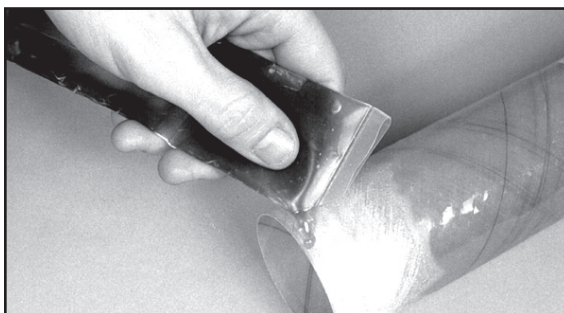
1. Remove clamp



3. Cut corner.



2. Knead until hardener and adhesive are thoroughly mixed.



4. Dispense.

8055 EPOXY ADHESIVE KIT

Solvent containers may be under pressure. Use caution when removing inner seals, especially in warm weather. Use eye protection. Concentrated vapors can be ignited. When using solvent, do not smoke or use near an open flame. Use with adequate ventilation. Refer to the warning label on each container for additional information. Once surfaces have been cleaned, do not contaminate them by touching with hands, laying pipe in the dirt, etc. Contaminated surfaces will cause a poor bond.

Assure the solvent has evaporated from the bonding surfaces before applying adhesive.

2. Using a clean paint brush, apply a thin uniform coat of adhesive, first to the bell then the spigot bonding surface. Coat the entire tapered area of both surfaces, removing all brush bristles.

3. Aligning and locking the joint properly is very important. For the correct installation procedures for both bell and spigot pipe and T.A.B. joint pipe, refer to Fiber Glass Systems Manual No. F6000, Pipe Installation Handbook.

4. Pipe or sub-assemblies can be moved before the joints are cured as long as care is taken not to disturb the lock of the joint. Bending or excessive movement is not advised.



CAUTION



Fiberglass Systems recommends that you DO NOT test any installation with air or gas because of the safety hazards created.

Kit Number	Description	Quantity (Mixed Adhesive)	Working Life*	Approximate Number of Bonds per Kit				
				Pipe Size				
	Bag kit for repairs			1"	1½"	2"	3"	4"
8055		1.6 oz.	15 mins.	13	7	3	2	1

*Working life is the time it takes properly mixed adhesives to "set up" (harden) at 75°F. It is a function of temperature and as the temperature increases, the working life decreases.

ADHESIVE DISPOSAL: Once the adhesive and hardener have been mixed and reacted, nothing can be extracted, and it is classified as non-hazardous material. Dispose of in a normal manner as other solid wastes. Excess adhesive and hardener can be mixed, allowed to react, and disposed of as above. If extra jars of adhesive or hardener have accumulated without the other component to mix and react, contact your Smith Fibercast regional manager. Hardener jars, when empty are not subject to EPA regulations and can be disposed of in a normal manner. These guidelines are based on federal regulations. State and local regulations and ordinances should be reviewed.

SOLVENT DISPOSAL: Solvent is classified as a hazardous waste and cannot be dumped. It can be used as a solvent and allowed to evaporate during use. Empty solvent cans meet EPA regulations for disposal and can be disposed of in a normal manner. These guidelines are based on federal regulations. State and local regulations and ordinances should be reviewed.

It is the policy of Fiber Glass Systems to improve its products continually. In accordance with that policy, the right is reserved to make changes in specifications, descriptions, and illustrative material contained in this bulletin as conditions warrant. Always cross-reference the bulletin date with the most current version listed at www.smithfibercast.com. The information contained herein is general in nature and is not intended to express any warranty of any type whatsoever, nor shall any be implied.

