

UNITED FIBERGLASS OF AMERICA WARM WEATHER ADH 600 and COLD WEATHER ADH 610 ADHESIVE APPLICATION GUIDE

The United Fiberglass warm and cold weather adhesive systems have been specially formulated for United Fiberglass products and are designed to create a permanent weld for joints and fittings. Each kit contains a two-part epoxy adhesive system and one static mixing tip. A dual plunger adhesive gun is also required and must be ordered separately.

Note: Poor surface preparation is a major hindrance to proper adhesion



All O.D. field cuts or bonding surfaces that have not been factory sanded must be abraded with sand paper (#4 or equal) to remove resin glaze. Remove all dust, moisture and residue prior to applying the adhesive.

Remove applicator gun and adhesive kit from their containers. Remove black plastic nut and tips from the end of adhesive kit and place the cartridges in the applicator gun. Next place the static mixing tip on the end of the cartridges and screw down with the plastic nut. Each kit comes with one static mixing tip. Additional tips are available from the factory.

Begin squeezing the handle of the gun to start adhesive through the mixing tip. Squeeze out enough adhesive until you achieve a gray uniform color. Adhesive is now thoroughly mixed and ready for application. (Note: adhesive should always be stored at room temperature for ease of installation. Cold adhesive is difficult to squeeze through the cartridges).

An alternate method of mixing is to squeeze adhesive directly from the cartridges without mixing tip and into a mixing bowl. Dispense just enough adhesive to complete desired number of joints. Mix adhesive thoroughly with a spatula until you achieve a gray uniform color. Apply adhesive following the directions below. (This method eliminates the need for additional mixing tips due to epoxy hardening in the tip).

Approximately 1" from the end of the spigot, apply enough adhesive to cover a 2" area around the spigot end. Spread adhesive uniformly with a spatula or wooden mixing stick. Immediately insert the spigot end into the bell or fitting and seat into place using a "twist and tap" motion-tapping the end of the conduit with a wooden block and rubber mallet, taking care not to damage the end. Spread excess adhesive around the outside of the bell or fitting. Care should be taken not to disturb the joint until it has fully cured.

The pot life or working life of the ADH 600 Warm Weather Adhesive is approximately 45 minutes to an hour, with a total cure time of 4 hours. This product should be used when ambient temperature is above 50° F. For ambient temperatures below 50° F, use ADH 610, which has a pot life of approximately 15 minutes to ½ hour, with a total cure time of 4 hours.

Estimated Joints Per Cartridge

2"	24 Joints
3"	20 Joints
4"	16 Joints
5"	12 Joints
6"	8 Joints

PART #	DESCRIPTION
ADH 600	30 oz Warm Weather Adhesive
ADH 610	30 oz Cold Weather Adhesive
ADH 650	Dual Cartridge Applicator Gun
ADH 620	Mixing Tips