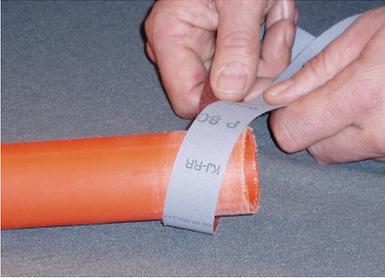
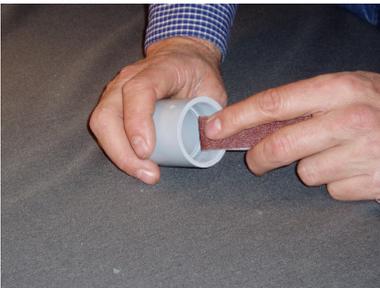


## BonDuit® Application Instructions



**Sand Conduit**



**Sand Coupling**



**Clean Coupling and Conduit with Type TR™**



**Close Tool**

1. Cut conduit to the desired length. If possible, use a pipe cutter or a miter saw to cut the conduit at a 90° angle. A good, straight cut will maximize adhesion area and improve the connection considerably.
2. For conduit over 3 inches, taper the end at a 45° angle with a rasp or knife. This will help when the conduit is inserted into the coupling.

**Surface preparation is critical for a good bond. Abrade and clean both adhesion surfaces well.**

3. Clean both conduit and coupling with a rag or American Polywater's Grime-Away™ Multi-Purpose Cleaner Wipes to remove dirt and grime.
4. Use 80-grit abrasive cloth to sand the outside of conduit ½ inch beyond the depth of insertion into the coupling. Using same cloth, thoroughly sand inside of the coupling. Be sure all the polish is removed.
5. Clean the adhesion surfaces of both the conduit and coupling with Type TR™ Cleaner Wipe to remove any oils and displace water. Gloves are recommended.

*Note: Prepare as many conduit and coupling sets as possible and have them ready to assemble in advance. This will reduce BonDuit® Conduit Adhesive waste.*

6. Place the BonDuit® Conduit Adhesive cartridge into dispensing tool and snap it into place. See instructions on page 4 for more information on the use of the dispensing tool.
7. Twist cap 90° counterclockwise to remove from cartridge. Depress handle on dispensing tool to prime cartridge each time product is used until both the white and black resins are coming out of the cartridge.
8. Place mixing nozzle onto tool and lock into place by twisting clockwise. Depress handle on dispensing tool until BonDuit® Conduit Adhesive comes out of nozzle tip. Pump 1 or 2 more times to make sure you are getting an even mixture. Dispense and discard this excess material.

**The BonDuit® Conduit Adhesive should be a uniform light gray color with no streaking when it comes out of the nozzle tip.**



**Priming Cartridge**



**Apply BonDuit® Adhesive**



**Smooth Excess Material**

9. Place BonDuit® Conduit Adhesive in a 1/8- to 1/4-inch bead using a zigzag pattern the depth of the connector insert. The pattern should be about 3/8-inch in width and extend to the outer edge of the conduit. The end of the mixing nozzle may be trimmed off up to the last notch to place a larger bead for larger diameter conduits.

10. Twist the coupling **immediately** onto the conduit. You must twist the coupling to be sure that BonDuit® Conduit Adhesive is well mixed and spread evenly on the inside of the splice.

*For conduits over 3 inches, it may be necessary to use a come-along or other mechanical assistance to pull the splice together.*

11. Smooth any excess BonDuit® Conduit Adhesive. Gloves are recommended.

12. BonDuit® Conduit Adhesive develops a strong bond, allowing movement or burial quickly. See chart below for temperature dependence. Do not move joint until set.

Temp.	Working time	Set time before movement
35° F 2° C	40 Minutes	7 Hours
52° F 11° C	20 Minutes	3 1/2 Hours
60° F 16° C	10 Minutes	1 1/2 Hours
70° F 21° C	6 Minutes	60 Minutes
88° F 31° C	4 Minutes	40 Minutes

*Note: If material in the mixing nozzle has set up, replace the mixing nozzle.*

13. To store cartridge, remove mixing nozzle and replace the cap on cartridge.

### **Application Temperature**

Working temperature for BonDuit® Conduit Adhesive is 35°F to 95°F (2° C to 35°C).

### **Cool Weather Application**

In cool weather (below 60° F) keep BonDuit® Conduit Adhesive warm before using (above 60° F or 17°C). Keep couplings in a warm area before use. It may be necessary to heat the transition joint to force the BonDuit® Adhesive cure. Below 35° F, the joint should be heated to cure the adhesive.

### **Warm Weather Application**

In warm weather (above 85° F), keep BonDuit® Conduit Adhesive cool, below 70° F (21° C). This will help keep the adhesive from curing before coupling is attached. If possible, use adhesive to make bonds in the cooler mornings and out of direct sunlight to slow down cure rate.