



# MIXING

RECOMMENDED TOOLS: Putty Knife, Cardboard Sheet and "Tongue Depressor" or Paint Stir Stick as an applicator.

Thoroughly mix the two parts on the Cardboard Sheet using the putty knife until there are no streaks. Scrape and clean the putty knife frequently to insure all material is included in the mixture.

When thoroughly mixed, evenly spread the adhesive over the mixing board to about a ¼" thickness. This "unbulking" prevents hot spots from developing in the mix, shortening the pot life.

Any unmixed adhesive will not cure and will cause soft spots in the glue line. In addition, unmixed adhesive has no strength, chemical resistance or heat resistance, and is a potential joint failure.

# GLUING PROCEDURE

Following the detailed instructions in the **Conley Fabrication Manual**, apply the glue and assemble the parts. Once together, **DO NOT ALLOW** the joint to move. Until the adhesive has cured, it does not have the strength required and movement may cause voids or microfractures resulting in leaks.

The glue must reach "B Stage" before it can be properly cured. This may be done with a heat tape set at LOW for 30 to 45 minutes. The actual time depends on the ambient temperature, and if 95 degrees F or above, "B Stage" may be reached without the heat tape. The glue has "B Staged" if it is hard and does not leave a residue when touched.

The following chart may be used to determine the cure time required at various heat tape settings. Remember, these adhesives require heat to cure. They will never completely cure without the addition of heat.

# CURING

**PROPER CARE OF CONLEY ADHESIVES REQUIRES THE USE OF A CONLEY PIPE WELD CURING TAPE OR COMPARABLE HEAT SOURCE.**

The chart below indicates the approximate final stage curing times at different temperatures for Conley adhesives. The initial or "B Stage" is accomplished either by high ambient temperature or with a low temperature setting on the heat tape. "B Stage" is achieved when remaining adhesive on the mixing board is hard to the touch.

Ambient Temperature	Pipe Size	Heat Tape - A "B Stage" Time Setting	Heat Tape – B "B Stage" Time Setting	Heat Tape - A Full Cure Time Setting	Heat Tape – B Full Cure Time Setting	Total Cure Time
80 – 90°F	ALL	30 Min. Low-Med	30 Min. - "2"	1 Hr. – High	1 Hr. – Full	1 Hr. – 30 Min.
70 – 80°F	1" to 4"	30 Min. Low-Med	30 Min. - "2"	1 Hr. – High	1 Hr. – Full	1 Hr. – 30 Min.
70 – 80°F	6" to 12"	45 Min. Low-Med	45 Min. - "2"	1 Hr. – High	1 Hr. – Full	1 Hr. – 45 Min.
70 – 80°F	14" to 30"	1 Hr. Low-Med	1 Hr. - "2"	1 Hr. – High	1 Hr. – Full	2 Hr.
Below 70°F	ALL	2 Hr. Low-Med	2 Hr. - "2"	2 Hr. – High	2 Hr. – Full	4 Hr.

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