

BonDuit[®]

Conduit Adhesive

BonDuit[®] Conduit Adhesive joins polyethylene duct to PVC, fiberglass, and metal duct using standard PVC couplings. This rapid-cure, two-part resin adhesive forms a durable bond for a strong, permanent, water-tight joint.

BonDuit[®] Conduit Adhesive is a versatile field-friendly conduit joining solution. It works for multiple conduit types and sizes. It is easy to use and no special training is required.

Application Instructions



Sand Conduit



Sand Coupling



Clean Coupling and Conduit
with Cleaning Wipe

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 diameter over 3 inches (75 mm), 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 (1 cm) 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 **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.



Close Tool



Priming Cartridge



Apply BonDuit® Adhesive



Smooth Excess Material

Place BonDuit® Conduit Adhesive cartridge into dispensing tool and snap into place. See tool instructions for more information.

6. 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.
7. 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.

8. Place BonDuit® Conduit Adhesive in a 1/8- to 1/4-inch (3 to 6 mm) bead using a zigzag pattern the depth of the connector insert. The pattern should be about 1/2-inch (1 cm) 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.
9. 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 (75 mm), it may be necessary to use a come-along or other mechanical assistance to pull the splice together.

10. Smooth any excess BonDuit® Conduit Adhesive. Gloves are recommended.
11. 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 ½ Hours
60° F 16° C	10 Minutes	1 ½ 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.

12. 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). Cold adhesive is difficult to pump and may stress the application tool. Keep couplings in a warm area before use. It may be necessary to heat the transition joint to force the BonDuit® Adhesive cure. Below 45° F, the joint should be heated for 8 hours to reach maximum strength.

Warm Weather Application

In warm weather (above 85° F or 30° C), 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.

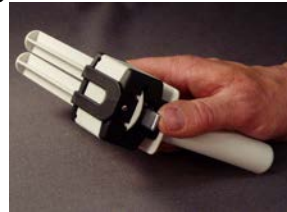
Applications per Cartridge

Each cartridge contains enough material for numerous applications, depending on the size of each coupling or joint.

Conduit Size	Applications per Cartridge
1 inch (75 mm)	20-30
1½ inch (120 mm)	12-18
2 inch (150 mm)	10-15
4 inch (300 mm)	4-6

Dispensing Tool Assembly Instructions

- 1. To assemble the dispensing tool, insert the piston. Rotate the black retaining collar forward. While lifting the metal tab, slide piston with ratchet teeth side down, into the slot through the front end. Push the piston all the way through and gently release the metal tab. The metal tab should catch on the ratchet teeth.**
- 2. Insert BonDuit® Conduit Adhesive cartridge into the wide opening on the black retaining collar. Push the collar back and press firmly to snap into place.**
- 3. Twist cap 90° to remove from cartridge. Place mixing nozzle onto cartridge and lock into place by twisting. Save cap for storage of unused material.**



Lift Metal Tab



Insert Piston



Insert Cartridge



Secure Collar

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Important Notice: The statements here are made in good faith based on tests and observations we believe to be reliable. However, the completeness and accuracy of the information is not guaranteed. Before using, the end-user should conduct whatever evaluations are necessary to determine that the product is suitable for the intended use.

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