

# INSTRUCTIONS FOR AMBIENT TEMPERATURE ADHESIVE KIT (Product code #20-0164)

**Atkore**<sup>™</sup>  
FRE Composites

## Adhesive Joint (Not Recommended For Use Below 54°F (12°C))

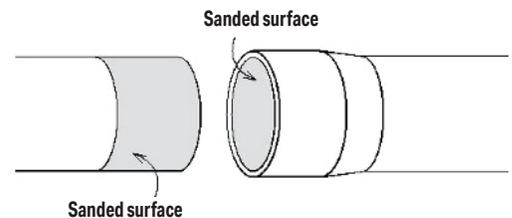
The design engineer may elect to specify that the conduit joint be adhesive bonded for greater pullout strength requirements approximately lb. = diameter (in.) x 1000 lb. or kg = diameter (cm) x 200 kg, when excessive vibration occurs in the environment (see our FRE® Bridge Installation Work Practice).

A detailed applications procedure, as well as all the necessary tools and materials, is included with the FRE® Adhesive Kit for the user's reference. All joints must be bonded with adhesive shall it not be assembled with our TriSeal™ gasket.

The Bell and Spigot is not designed to withstand under a bridge sufficient pullout load based on its friction fit (interference) joint only. Usage of the FRE® Adhesive Kit varies with diameter of the conduit.

## 1. Preparation

- 1.1 Clean area free of dirt, water, grease and dry.
- 1.2 The internal face of the bell (female end) and the external face of the spigot (male end) must be sanded (to simply remove the glossy finish) with 80 grit sand paper.
- 1.3 To prevent contamination of the surfaces to be joined, avoid any further contact after cleaning.



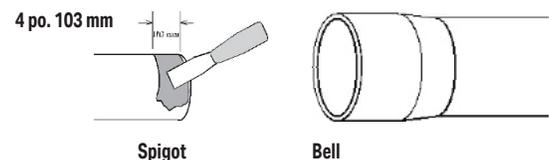
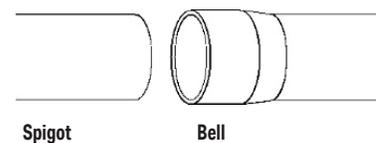
## 2. Cartridge Assembly (Cartridges Must Be Kept Above 59°F (15°C) At All Time)

- 2.1 After having installed the adhesive dual cartridge in the applicator, insert the static mixer fully (20-0166 - green). Squeeze the handle until the adhesive comes out and place on cardboard or if space permits, apply directly to male end. Please note the mix inside the static mixer will harden after a period of 10 minutes without use @ 25° C.



## 3. Apply The Adhesive On The Conduit

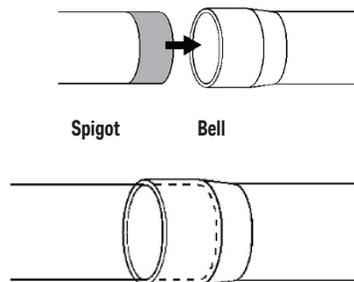
- 3.1 The two parts (bell and spigot) have to be side by side.
- 3.2 Apply the adhesive with a putty knife on the spigot to cover a 4" (103 mm) section.



### 4. Bonding

- 4.1 When the spigot is totally covered with adhesive, insert the spigot in the bell.
- 4.2 When the spigot is pushed to the end of the bell, smooth out the glue at the joint to form a chamfered edge.
- 4.3 Once the joint is made, make sure it is cured before moving the conduit.  
(see below recommended cure times).

Cure temperature	Cure time (100% cured)
54 °F (12 °C)	12-24 hrs
77 °F (25 °C)	2 hrs (Alternate cure)



\*Please refer to [DUAL CARTRIDGE ADHESIVE KIT USAGE GUIDELINE](#) for more information.