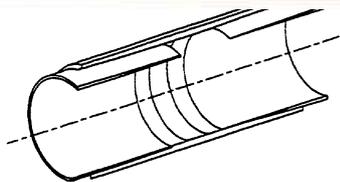




Bondstrand® Product Data



PSX 20 Structural Adhesive Kit

Epoxy siloxane adhesive for bonding fiberglass pipe and fittings.

Description

PSX-20 adhesive is a patented two-part epoxy siloxane adhesive designed for joining fiberglass pipe and fittings. PSX-20 is a non-flowing thixotropic paste offered in easy-to-use kits. PSX-20 can be used to connect epoxy, vinyl ester and phenolic systems.

Preparation of bonding surface

Using the sandpaper supplied in the adhesive kit, **clean** both surfaces **thoroughly** to remove all dirt, grease and foreign materials. Make sure the bonding surfaces are free moisture. **Do not touch** the bonding surfaces with bare hands. dirty or greasy gloves or rags after cleaning them.

Mixing the adhesive

In cold weather it is necessary to the resin to 50°F (10°C) to permit good mixing and easier application. Open the hardener container. **Using the stick supplied**, mix the hardener. Put all of the hardener into the resin container The mix into is 4 to 1. **Never split a kit**

Pot life and Cure time

At 77°F (25°C) the pot life of PSX.20 adhesive is 20 to 30 minutes. The pot life decreases with rising temperatures:

Adhesive			Minimum Ambient Minimum Joint		
Temperature	Pot Life (min.)		Temperature	Cure Time	
(°F)	(°C)	(minutes)	(°F)	(°C)	(hours)
40	5	120	40	5	12
65	18	40	66	18	5
75	24	25	75	24	4
95	35	10	96	35	3

In subzero or extremely windy conditions, extend the heat-cure times accordingly and use insulation as necessary to insure adequate bonding. Cap the ends of the piping to prevent the passage of cold air In severe conditions, warm air may be blown through the interior of the pipe.

A heat cure is recommended for installations with service temperatures above 180°F (82°C) or operating pressures over 300 psi. For ambient temperature conditions below 40°F (5°C), an external heat cure must be used. A minimum heat cure time of at least 30 minutes is recommended for 2-through 6 inch pipe. Even after the adhesive has turned solid at ambient temperatures, heat curing will promote chemical cross-linking of the adhesive, thus increasing its strength. temperature resistance and corrosion resistance. A single Chem Cure Pak may be applied or an Ameron-approved electric heat blanket may be used. The heat cure may be applied at anytime after the bond is made and before the pipe has been tested or put into service.

Kit sizes and bonds per kit

Adhesive kits are available in 1-, 5-and 8-oz. sizes. The table below indicates the number of bonds per kit for each pipe size. Values in the table are based on the quantity of adhesive required by an experienced crew working at a temperature of 75°F (24°C) with a 30 minute adhesive pot life.

it size	Wt	Bonds per kit per pipe size										
		(oz.)	(1b.)	2	3	4	6	8	10	12	14	16
1	0.5	2	1									
5	1.2	11	7	5	2		2	2	1	1		
8	1.4		13	8	4		3	3	2	2	1	

Shear Strength Comparison

Polysiloxane-phenolic adhesive demonstrates a significant improvement in bonding capabilities over conventional epoxy adhesives. when cured at room temperature, PSX-20 achieves 15 to 20% greater shear strength than conventional epoxy adhesives. With elevated temperature cures. lap shear strength increases to 20 to 35% over standard epoxy adhesives. PSX.20 also offers significant improvements over conventional epoxy adhesives when bonding phenolic based laminates. When applied according to manufacturer's instructions, PSX.20 yields a secure bond for Bondstrand and Bondstrand PSX products.

Storage

Do not store PSX-20 adhesive at elevated temperatures. stored adhesive kits should not be exposed to temperatures in excess of 20°F (49°C) or in the direct sunlight. Rotate stock frequently.

Toxicity

Hardener The hardener is irritating to the skin, eyes and respiratory tract. It is toxic orally and may cause sensitization.

Resin: The resin is irritating to skin and eyes and may cause sensitization.

Handling precautions

Hardener Do not get in eyes, on skin or clothing. Avoid breathing vapor; use caution when opening can. Wear rubber gloves and apron and NIOSH-approved respirator Wash thoroughly after handling.

Resin: Avoid contact with eyes, skin or clothing. Wear rubber gloves and eye protection. Wash thoroughly after handling.

First aid**In case of contact**

Eyes; Immediately flush eyes with plenty of water for at least 15 minutes. Call a physician.

Skin: Wash skin with water and soap, if available.

Clothing: Remove contaminated clothing and wash before reuse.

Inhalation: Remove to fresh air. Give oxygen or artificial respiration *if necessary*.

Ingestion: If patient is conscious, give 1 to 2 glasses of water to dilute. *Do not induce vomiting.* Call a physician immediately.

Important notice

This literature and the information and recommendations it contains are based on data reasonably believed to be reliable. However, such factors as variations in environment, application or installation, changes in operating procedures, or extrapolation of data may cause different results. Ameron makes no representation or warranty, express or implied, including warranties of merchantability or fitness for purpose, as to the accuracy, adequacy or completeness of the information contained herein. Ameron assumes no liability whatsoever in connection with this literature or the information or recommendations it contains

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