



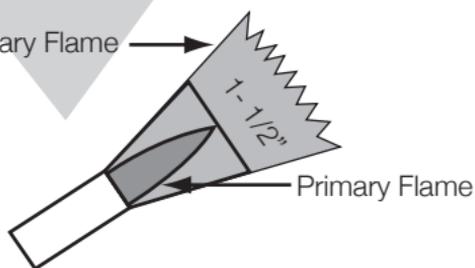
# POLY-WELD ADHESIVE

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## Directions for bonding polyethylene:

Color: White  
30g. (1.06oz.)

1. Note caution information on glue dispenser.
2. Clean and roughen all bonding surfaces.
3. Polyethylene must be flame treated to ensure a strong bond.
  - Fit a propane torch with a flame spreader.
  - Following the operating cautions of the propane torch, ignite the flame.
  - Observe the flame in a darkened room, noting the primary (bright blue) and secondary (faint yellow) portions of the flame. (See drawing below)
  - Adjust the flame so that the primary flame is contained within the spreader, and the secondary flame is 1-1/2" beyond the spreader. (see drawing)
  - Treat the polyethylene to be bonded with the tip of the secondary flame by passing it over the polyethylene in 5 gentle strokes. Total exposure to the flame should be 2-3 seconds (.5 seconds per stroke). This light exposure should not deform or melt the polyethylene in any way.
  - Test the polyethylene for bond readiness by wetting it with water. If the water beads up and runs off immediately, the treatment was not effective. If the water sheets on the surface, the surface is ready for bonding. If unsure, compare water's action on the treated area with an untreated area.
  - Bond joints within 1 hour after treating. Always prepare test bonds to be certain that flame treating is effective with your material.
4. Remove cap from glue dispenser, cut tips off nozzle ends at groove.
5. Mix equal parts of resin and hardener to uniform color.
6. Apply to bonding surfaces, press together leaving glue between joints.
7. Working time = 15-30 min.
8. Handling time = 1-2 hrs.
9. Full Cure time = 24 hrs.
10. Replace cap on glue dispenser.
11. Apply to wet or dry surface.
12. Cold temps slow cure time.
13. Clean un-cured glue with alcohol.



*Caution: Do not Flame Treat containers for flammables such as fuels, chemicals or gases.*



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