

		<p>3281 - Guasti Road, Suite 260 Ontario, CA 91761 (909) 987-0550 (800) 538-3091 Fax: (909) 987-0490 http://www.supergluecorp.com</p> <p style="text-align: center;">Copper-Bond Epoxy</p>
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Pacer Technology/Super Glue Corporation Copper-Bond Epoxy Adhesive (80582, 80583) is a unique 2-part epoxy system, which was developed specifically to join copper tubing and fittings for water systems. It works best on:

- Copper
- Stainless steel
- Aluminum
- Brass
- Bronze
- Chrome
- Galvanized steel

Copper-Bond epoxy is UL listed for use in fire sprinkler systems using pipe from 3/4" to 2" size, Type L or M, with a maximum system pressure of 175 psi. This thin film adhesive is designed to join two surfaces and is not appropriate for use as a patching material for leaks. The epoxy will not interfere with using the plumbing system for a ground and can be used with .002 to .020" gap.

PROPERTIES:

<u>Initial color:</u> R(white paste)/H(brown-yellow paste)	<u>Full Strength:</u> 24 hours
<u>Final color:</u> Brown-copper	<u>Mix Ratio (parts by volume):</u> 1:1
<u>Working Time:</u> 5 minutes	<u>Temperature Use Range:</u> 36 ⁰ to 150 ⁰ F
<u>Handling Time:</u> After 20 minutes	(2 ⁰ to 65 ⁰ C)

USE INSTRUCTIONS:

1. Assemble tools & materials: pipe, fittings, tubing cutter, abrasive cloth and copper pipe fitting brush. (Be sure to de-burr the pipe with a file).
2. Cut the tubing with a wheel cutter or hacksaw.
3. De-burr the pipe and clean the outside of the pipe with abrasive cloth.
4. Clean the inside of the fitting with a fitting brush.
5. Check the dry fit of the pipe: it should slide easily into the fitting. Dented or out-of-round parts should not be used and may result in leaks.
6. Open Copper-Bond syringe by cutting tips evenly across. Dispense on clean, flat disposable surface (such as cardboard). If product does not flow, use nail to puncture the skin, which sometimes forms on the inside. Copper-Bond must be mixed in equal parts by volume. If adhesive comes out unevenly at first, discard the unequal amount and dispense more Copper-Bond. Mix thoroughly until uniform in color (approximately 20-30 seconds of vigorous stirring).
7. Apply a heavy film of mixed product to the outside of pipe to the full depth of the joint.
8. Apply a thin film to the inside of the fitting. Do not leave any bare spots as this may cause a pinhole leak.
9. Insert pipe into fitting with a slight twist as you insert & wipe off excess Copper-Bond with a rag.
10. Copper-Bond sets in approximately 20 minutes. Before pressurizing, test the product you mixed with a fingernail: it should be hard. If it is not hard, wait longer and then retest. If product is not hard within one hour, it was not mixed in an equal part by volume. Take the joint apart and go back to Step #6.
11. Copper piping must be supported horizontally every ten feet, vertically every eight feet. In addition, Copper-Bond joints must not be disturbed during the cure time. It is good practice to flush a new piping system for 10 minutes before using any water from it.

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TIPS FOR USE:

- Do **not** use Flux with Copper-Bond.
- Cured Joints can be taken apart by heating with a propane torch.
- Pinhole leaks (small drip from the joint) are caused by not using enough Copper-Bond. Follow Steps #7 and #8 carefully.
- Use Copper-Bond on any system carrying water, freon, oxygen and natural gas. Do **not** use with antifreeze or any other types of chemicals or with fluorine gas.
- To rebond soldered joint, remove all solder, sand & clean parts, and then apply Copper-Bond.
- If soldering in nearby area as joint to bond, perform all soldering first, then bond joints with Copper-Bond.
- Although Copper-Bond is compatible with all types of copper water systems, consult local codes for restrictions.

STORAGE AND SHELF LIFE

After use, pull back on plunger, wipe tips to remove residual product and reseal with plug. Store product sealed, with tips up, in a cool, dry location. Stored under these conditions, a one-year shelf life can be expected.

SAFETY AND HANDLING PRECAUTIONS

Contains Epoxy resin & amine hardener. May cause skin sensitization or eye irritation with direct contact in the uncured state. In case of direct eye contact, flush with water for 15 minutes and consult physician. Wash hands and skin thoroughly with soap and water after use. If liquid material is swallowed, seek medical advice immediately and show container label. **KEEP OUT OF REACH OF CHILDREN.**

For more information, refer to Material Safety Data Sheet available upon request or obtain from our Pacer Technology/Super Glue Corporation website @ www.supergluecorp.com.

In case of emergency, call CHEMTREC at (800) 424-9300 or call Pacer Technology (800) 538-3091 (outside CA only) or (909) 987-0550.

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