

8014, 8024, 8069 & 8069-C Adhesive Kits

For use with RED THREAD®, RED THREAD® II, GREEN THREAD®, GREEN THREAD 175/175-C and 250/250-C, and SILVER STREAK® Piping Systems and with UL Listed RED THREAD IIA Piping Systems

Note: This bulletin contains limited installation information. It is important to read and fully understand the instructions in **Manual No. F6000** for standard products or **Manual No. B2160** for UL-Listed products and **Manual No. F6300** for Marine-Offshore before beginning installation. Ambient temperature, adhesive working life, and number of crewman should be considered when ordering adhesive. For long runs of 8" and larger pipe, one kit per joint is recommended.

8014 Kit		Bonds per Kit	
Description	Qty.	Pipe Size In.	No.
6.5 oz. Can Mixed Adhesive	1	1	45
1.0 oz. Container Hardener	1	1½	27
1" Paint Brush	1	2	21
Stir Stick	1	3	15
Vinyl Gloves	1 pr.	4	8
		6	5
		8	3
		10	2
		12	1

8024 Kit		Bonds per Can*	
Description	Qty.	Pipe Size In.	No.
2.7 oz. Can Mixed Adhesive	2	1	20
0.4 oz. Container Hardener	2	1½	12
1" Paint Brush	2	2	9
Stir Stick	2	3	6
Vinyl Gloves	2 pr.	4	4
		6	2
		8	1
*Total for both kits is double the no. of joints.			

8069 & 8069-C Kit		Bonds per Kit	
Description	Qty.	Pipe Size In.	No.
9.4 oz. Can Mixed Adhesive	1	8	4
1.4 oz. Container Hardener	1	10	3
2" Paint Brush	1	12	2
Stir Stick	1	14*	2
Vinyl Gloves	1 pr.	16*	1
		18*	1
		20*	¾
		24*	½
*Green Thread 175 & 250 taper joint only available in 14" diameter and larger.			

The 8000 series adhesives are room temperature, two component, epoxy adhesive systems. Once mixed, the adhesive's working life is limited to approximately 15 minutes at 75°F (23.9°C). The adhesive is recommended for use with NOV Fiber Glass Systems piping systems in recommended services where continuous service temperatures do not exceed 230°F (110°C).

Precautions

Testing piping systems with air or gas is **not** recommended due to inherent safety concerns. Refer to NOV Fiber Glass System's installation **Manual No. F6000** or **F6300** for hydro testing procedures.

Gloves and eye protection should be worn when working with adhesive components. Direct contact may cause skin irritation. If contact is made with skin wash area with soap and water until contamination is removed. Eyes should be flushed with clean water and evaluated by trained medical personnel. The work area should be well ventilated and direct inhalation of fumes should be avoided.

Adhesive that is allowed to setup (harden) in the container will undergo an exothermic reaction. Depending on the quantity of adhesive, the reaction may generate foul-smelling smoke and temperatures up to 400°F (204°C). An exotherming container of adhesive should be moved to a well ventilated area or outdoors. During this process wear gloves and avoid inhalation of the smoke.

The user should read and follow solvent manufacturers' safety recommendations when working with solvents.

POT LIFE OF ADHESIVE

The pot life (working life) of an adhesive is the time it takes for the adhesive to begin to harden in the mixing can. The life is measured from the time the hardener and adhesive are first mixed. Though the pot life is quite short at high temperatures, it increases as the temperature drops below 75°F (24°C).

The pot life of adhesive in hot weather can be extended by keeping the adhesive cool or by reducing the concentrated mass of adhesive in the can. This can be easily accomplished in the field as follows:

- Cool the can by wrapping with rags or paper towels, and then keep the wrappings wet with water or solvent. The can will be cooled by evaporation of the water or solvent. **Do not put water or solvent in the adhesive.**
- Reduce the concentrated mass by removing the mixed adhesive from the can and spreading the adhesive into a thin film onto a piece of tin or aluminum foil. This aids the dissipation of heat generated by the curing process.

JOINT PREP

A strong adhesive bond requires clean bonding surfaces. The bonding surfaces must be free of oily fingerprints, dirt, oils, grease and other contaminants. Freshly tapered spigots or factory-fresh spigots and bells do not require cleaning unless visibly contaminated. Soil or dirt may be removed by washing

with water. Surfaces may be cleaned with acetone or methyl ethyl ketone. Once the surfaces have been cleaned, do not contaminate them by touching with hands, laying pipe in the dirt, etc. The surfaces should be dry and freshly sanded before applying adhesive.

Warning: Acetone and methyl ethyl ketone are extremely flammable. When using these solvents, do not smoke or use near an open flame. Never use gasoline, turpentine, or diesel fuel to clean joints.

ADHESIVE MIXING

The ideal temperature range for mixing the adhesive base and hardener is 70°-80°F (21-27°C).

To mix, pour the entire contents of the hardener container into the adhesive container. **DO NOT SPLIT A KIT.**

Mix the adhesive and hardener together with the wooden mixing stick. Continue mixing until a uniform mixture is obtained and all adhesive is mixed in from the sides and corners of the can. A smooth uniform consistency and color indicates adequate mixing of the adhesive.

If the adhesive becomes warm and begins to set up in the container, safely dispose of the container. **DO NOT USE THIS ADHESIVE TO BOND A JOINT.**

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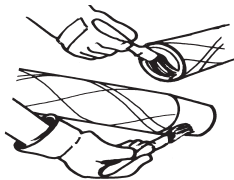
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NOV Fiber Glass Systems

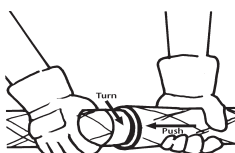
BONDING OPERATION

1. Using a clean paint brush, apply a thin, uniform coat of adhesive to the bonding surfaces. First coat the bell and then the spigot bonding surfaces.



Note: Completely coat both bonding surfaces of the joint and remove any loose paint brush bristles in the adhesive.

2. Align and lock the joint:



For 1"-2" diameter pipe, insert the spigot into the bell until the tapered surfaces touch. Then while pushing, turn the joint until it locks tight. Normally, one half to a full turn is needed. Hold in locked position until excess adhesive squeezes out.

For 3"-6" diameter pipe, turning is not practical, so align the pipe and push until the tapered surfaces touch. A driving force must be used to lock the joint. The additional force can be provided by using a piece of hard wood and a hammer.

Threaded and Bonded (T.A.B.) joints:

T.A.B. joints are available for 2 thru 6 inch diameter Red Thread II pipe to pipe connections. T.A.B. joint installation procedures follow the normal bell and spigot operations of cleaning, adhesive mixing, etc. as described previously. The threads on the bonding surfaces are designed for ease of installation and to improve the reliability of the bonded joint. See Installation Manual **No. F6000** for additional installation instructions.

For 8 thru 24 inch diameter pipe, a NOV Fiber Glass Systems hydraulic or manual come-along is recommended. Connect two come-alongs to the pipe and pull the joint together slowly while firmly hammering on the sides of the joint with a rubber mallet or 5 pound dead blow hammer. The vibrations from the hammer blows will aid joint lock up. Continue until joint insertion stops and locks tight. Take care not to damage the pipe.

Note: When using a hydraulic come-along, refer to Manual **No. F6000**, **F6618** or **F6619** for come-along pressure requirements. A strap clamp kit is also available for pipe to fitting connections.

3. To ensure joint lock up a pen mark should be placed on the pipe as a visual reference point. The mark is usually made after the joint has been pushed together snugly but not completely made up. The mark should be placed 1/4 to 1 inch from the end of the female side of the joint. The joint is then driven together until insertion of the male end stops. The mark is used as a visual point of reference between the two halves of the joint.

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4. Pipe or sub-assemblies may be moved after the joints are locked up as long as the joints are not loosened by excessive bending or abrupt movements.
5. When the joints are fully cured the assemblies may be handled, pressurized or hydro tested per recommendations in **Manual No. F6000** "Pipe Installation Handbook" or **Manual No. F6300** "Green Thread Marine-Offshore Installation Instructions."

ADHESIVE CURE

1. The time required to fully cure an adhesive joint is temperature dependant. The following table shows the time required for complete cure at specific temperatures.

Ambient Temperature °F	Cure Time*
50 (10°C)	18
60 (16°C)	12
70 (21°C)	6
80 (27°C)	4
90 (32°C)	2
110 (43°C)	1

*Piping systems must not be pressurized until the adhesive joints are fully cured.

2. When the temperature is between 50°F and 70°F (10°/21°C) joints may be heated to accelerate the curing process. Below 50°F (10°C) the joints must be heated to cure the adhesive. NOV Fiber Glass Systems offers customized electrical heating collars for this purpose. The collars are reusable and operate on standard 110/120 VAC or 220/240 VAC. Refer to Bulletin **No. F6640**, Manual **No. F6000**, or Manual **No. F6300** for additional information.
3. When using a heat assisted curing method do not handle or pressurize pipe assemblies until they have cooled to ambient temperature.

Adhesive Disposal: Once the adhesive and catalyst have been mixed and reacted, nothing can be extracted, and it is classified as non-hazardous material. Dispose of in a normal manner as other solid waste. Excess adhesive and catalyst can be mixed, allowed to react, and disposed of as above. If extra cans of adhesive or tubes of catalyst have accumulated without the other component to mix and react, contact your NOV Fiber Glass Systems regional manager. Catalyst tubes, when empty are not subject to EPA regulation and can be disposed of in a normal manner. These guidelines are based on federal regulations. State and local regulations and ordinances should be reviewed.

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