



## Champion Mix, CM-2070/2040/2020 Adhesive System

**Description:** The Champion Mix System is a two part polyamide cured epoxy resin system designed to permanently bond fittings and joints of fiberglass reinforced epoxy pipe together. Each cartridge system contains resin, hardener, and one plastic static mixer (see picture on back page). An adhesive gun is required for applying the adhesive (ordered separately).

**Preparation:** When making field cuts, all pipe and fitting bonding surfaces should be abraded with sandpaper to break the resin "glaze". All bonding surfaces must be dry prior to adhesive application.

**Assembly Of Cartridge:** Assemble the handle and the washers on the adhesive gun first. Remove the black plastic plugs from the top of the two tubes and mount the cartridge into the gun. Unscrew the bottom plastic nut from the cartridge and remove the small plastic plugs from each tube. Make sure to save the plastic plugs so resealing of the cartridge can be done if necessary. Fit the plastic static mixer into its place and fasten it with the black plastic nut.

**Application Of Adhesive:** In cold weather, warming of resin and hardener to 70°F is recommended to permit good mixing and easier application. Firmly squeeze the handle of the adhesive gun to push adhesive into the static mixer nozzle. Continue squeezing until the adhesive reaches the end of the nozzle and thereafter continue to squeeze until an uniform gray color is coming out from the nozzle. It is now completely mixed and ready to use. Apply a layer of adhesive, thickness depending on conditions but no less than 1/32 inch, to the surface of spigot (the end being inserted into the opposite socket). Spread it out evenly with a reusable steel spatula or similar tool. Without delay, insert the pipe into the fitting (or belled end) and seat either by turning or tapping using a two-by-four wooden block placed over the pipe end to seat the spigot into the socket end. Never use a metal hammer directly on the pipe or fittings. Clean up and remove excess adhesive from outside of joint.

**Pot Life/Cure Time:** The pot life (working time) of the adhesive is measured from the time the hardener and resin are first mixed, until the adhesive starts to thicken and harden and can no longer be used. These times are listed for 70° F ambient temperature. Lower temperature will extend the time and warmer temperatures will reduce the time.

**Temperature...70° F: Pot Life - 45 minutes; Cure Time - 4 hours (fully cured)**

If the adhesive has hardened in the static mixer, the mixer needs to be changed. Always cap the cartridge tubes after usage by removing the static mixer and plug the bottom of the tubes.

**Safety Precautions:** See Material Safety Data Sheet for this product.

**Important Notice:** This literature and the information and recommendations it contains are based on data that is true and accurate to the best of our knowledge. Variations in environment, application, mixing procedures, etc. may cause different results. Champion Fiberglass makes no guarantee of accuracy, adequacy, or completeness of the recommendations of information contained herein. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products.

