

## Cold Joining using **SICOMET GLUE** and **TEROKAL**



### Step 1

Preparation

**Adhesive SICOMET 8300**

Tin **TEROKAL3958** including brush

Grinder

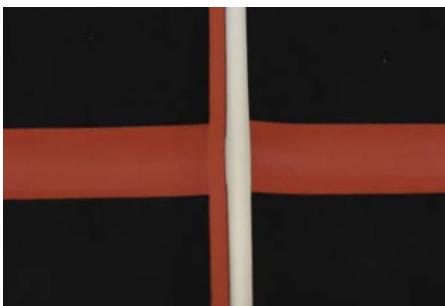
A wooden block for pressure



### Step 2

**Preparation of surface**

Grind the Flexjoint EP contact surface bottom and top layer 1.5 mm similar to the normal hot vulcanisation process.



Prepared contact surface 1.5 mm similar to standard vulcanization.



### Step 3

**Applying the SICOMET glue to ONLY one side** of the Flexjoint EP, start in the expansion area (red area)

**IMPORTANT**

Only glue steps of approximate 5 cm by time. After pressure do next 5 cm step.



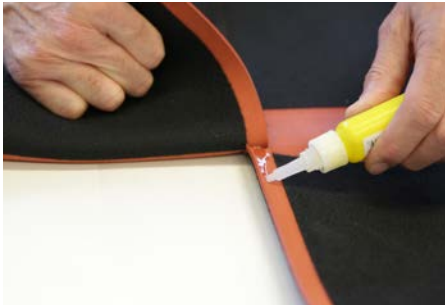
### Step 4

**Press the adhesive.**

The Flexjoint EP is over lapped with the other piece and pressure as showed using the wooden block.

Keep pressure application for about **15 seconds**.

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### Step 5

#### Applying the adhesive

Note the adhesion of the seam and applying the glue to the remaining side.

**IMPORTANT** Only glue steps of approximate 5 cm by time. Than do next 5 cm step.



### Step 6

#### Pressure to the seam

Apply pressure to the seam using the wooden block. Keep pressure application for about 15 seconds.

Note the adhesion of the seam and applying the glue to the remaining side.

## Repeat Steps 5 and 6



### Step 7

#### Completion with TEROKAL

Once the adhesion process has been completed and the adhesive has dried, check that the adhesive is dry and the patch is secure. The adhesive develops full strength after 24 hours, however this is dependent on environmental conditions.

