

**CON-SERV INC  
STANDARD OPERATING PROCEDURE**

S.O.P. No 1008

EFFECTIVE DATE: January 1, 1979

DESCRIPTION:

Q.C. APPRVD.: *R.E.*

Preparation of hi-temperature adhesive.

SHT. 1 OF 1

REVISED DATE: October 28, 1996

STEP	PROCEDURE	COMMENTS
1.	Use the instructions for Duralco 4700 as a reference.	
2.	Mix 1 pint increments at a time. 1 pint will cover approximately 8 1/2 sq. feet.	
3.	If mixing in 800 ml. tri-pour polyethylene beaker, mix as follows: Add 12 1/2 oz. of part (A) paste to beaker (1 1/2 oz.) for a total weight 14 oz. Then set balance at 1 lb. 1 1/2 oz. and add 3 1/2 oz. of part (B) powder.	Use a balance scale. Set at 14 oz. for part (A) and then set at 1 lb. 1 1/2 oz. for addition of part (B) <u>Caution:</u> Part (B) powder must be stirred thoroughly before weighing out desired amount.
4.	Stir thoroughly for 10 minutes, warm mixture for ease in stirring.	
5.	Spread using a small toothed trowel.	
6.	Cure as follows: 2 Hours at 220°F. And 4 Hours at 350°F.	This time is required to fully react polymer

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CK'D BY \_\_\_\_\_ OK'D BY \_\_\_\_\_

DEC 15 2006

RESUBMIT \_\_\_\_\_ APPROVED

BY \_\_\_\_\_ DATE 01-05-07

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