

**CON-SERV INC
STANDARD OPERATING PROCEDURE**

S.O.P. NO 1007

EFFECTIVE DATE: January 1, 1979

DESCRIPTION:

Q.C. APPRVD.: *RE*

Preparation of standard adhesive

SHT. 1 OF 1

REVISED DATE: October 28, 1996

STEP	PROCEDURE	COMMENTS
1.	Add 1 part of hardener (B) to 2 parts of resin (A) in a clean beaker.	
2.	Stir until the mixture takes on a uniform creamy color. Stir at least 1 minute.	
3.	Do not mix more than 3 or 4 stock sheet quantities.	Depending on the ambient temperature in the shop, the spread adhesive will start to cure chemically outside the press.
4.	Cure the adhesive as follows: 15 minutes at 200°F. or 10 minutes at 250°F.	This is the approximate time/temperature relationship based on 10 gauge steel. For thicker steel more dwell time will be required. Approximately 30 min. for 1" steel.

RECEIVED
 CK'D BY _____
 DEC 15 2006
 RESUBMIT _____ APPROVED ✓
 BY _____ DATE 01-09-07

DGO SS