

DUAL CARTRIDGE (side-by-side) APPLICATION USAGE INSTRUCTIONS

(see separate instructions for single-cartridge packaging)

(These instructions do NOT apply to the 50ml cartridge)

Please read all instructions prior to application!

Thank you for your interest in our Ratio-Pac® system. This product utilizes a two-component manual, spring assisted or pneumatic dispensing gun for applications. Through our experiences we have developed the following recommendations for successful application of this product.

1. Remove the two plugs from the tips of the cartridges (they may both be black, or one may be white). Save for later. Mark the plugs so you can place the A & B tips on their respective cartridges, and not mix them up.
2. Place the side-by-side cartridges into the dispensing gun.
3. GENTLY squeeze the trigger until BOTH components are dispensing out of the cartridges (this procedure “takes up the slack” in the cartridges to ensure that equal amounts of A and B will dispense at the same time; ***if this step is skipped, the product may not cure correctly!***)
4. Release the pressure on the trigger. Observe the A & B materials—they should not be “oozing” once the trigger pressure is released.
5. Place the mixing nozzle on the end of the cartridges and secure in place. If supplied, use the retaining nut to secure.
6. Optionally, clip the tip of mixing nozzle to desired thickness of bead (just like caulking tubes). For knife grade material you may need to clip the tip back most of the way to make it easier to dispense. For low viscosity products, you may not need to trim the tip at all.
7. Begin dispensing. Discard the first 4”-8 “ of the dispensed product into a proper waste container. For lower viscosity products, 4” should suffice; for thicker products, up to 8” of material may need to be discarded. If the product is colored, you should be able to see a definite color change—this is an additional visual indicator that proper mixing is occurring. ***It is strongly recommended that you practice dispensing a bead and monitoring the point at which full cure is obtained, so you will know how much you need to dispense to ensure adequate mixing.***
8. If dispensing is momentarily stopped and the trigger pressure is released, you should not have to repeat Steps 3-7; ***however***, if dispensing is stopped for longer than 3 minutes, and/or a new mix element is installed, then Steps 3-7 **MUST** be repeated. ***If this step is skipped, the product may not cure correctly!***
9. When finished dispensing, remove the mix element and discard. Remove the cartridges from the gun. Wipe off the tips with a clean cloth. Be careful to not mix A & B near the tips—you don’t want to plug the tips with cured adhesive.
10. Replace the plugs from Step 1—be sure to place the A tip in the A tube, same for the B—do not mix them up and put the A plug into the B tube, for example—you WILL glue the plug in place permanently.
11. Alternatively, the mix element can simply be left in place--the adhesive will cure in the mix element, and effectively “cap” the A & B tubes. When ready to use the cartridge again, simply remove the now-gelled mix element, and begin again at Step 2.