DAG II **DBB IV**

Diversified Bulkhead Bonder IV
Product Number: DBB IV
Quantity: 17 ounces 10:1 Twin tube cartridge set
Product Number: DAG II Manual Applicator Gun
Product Number: SM-2 Static Mixing Tube

Background: The bonding of a penetration fitting to its respective sump and pipe walls is a relatively new application in the Petroleum Equipment Industry. The proper bonding agent must be used with the appropriate penetration fitting material to achieve a long-term seal.
DBB III is an excellent aggressive bonding agent for bonding fuel-thane fittings to fiberglass sumps. DRP Polysulfide paste provides good adhesion between fuel-thane fittings and poly sumps. Until now there has been no good bonding agent for Alcryn. Additionally it has been determined by field-testing that the DBB III is not an adequate bonding agent for dense compression molded fiberglass sumps. DBB IV is a member of the Methyl Methacrylate family of adhesives. On applications where the user wants a 20-year warranty for parts and labor, DBB IV must be used.

Applications: DBB IV should be used on all Filled and Monitored penetration fittings. In some applications DBB IV may be a better choice for poly sumps. Where a bonder is used on Alcryn materials DBB IV should be used. DBB IV is not recommended for bonding fuel-Thane to Fuel-Thane such as solvent welding a split repair boot together.
DBB IV is also temperature sensitive. Bonds should be performed where ambient temperatures are less than 85 degrees F. Where bonds must be made above 85 degrees, special care in the application process must be made to achieve an acceptable weld.
Inexperienced personnel should not attempt to use DBB IV above 90 degrees.
DBB IV is highly fuel resistant based on manufacturer's testing.
DBB IV volumes are the same as those for DBB III and DRP for securing a penetration fitting to a sump wall.

Use the following chart as a guideline for various applications:

Field bonding Fuel-Thane or Alcryn to:

	DBB III	DRP	DBF II	DBB IV
Fuel-Thane*	**A**	**N/R**	**N/R**	**N/R**
FRP Surfaces	**B**	**B**	**B**	**A**
Poly Surfaces	**N/R**	**B**	**B**	**B**
Steel	**N/R**	**A**	**A**	**A+**
Wood	**N/R**	**A**	**A**	**A**

A+ = Highest Bonding A=Excellent Bonding B= Good Adhesion

***Alcryn does not bond to Fuel-Thane**

Use Instructions: Always dispense a quantity of adhesive at start-up to assure that the adhesive exiting the tip of the mixer is the proper color and is uniform, without streaks. If aged material is being used, allow the purged material to cure to assure quality before proceeding. Carefully dispense a sufficient quantity of adhesive on the substrate to assure that the bond gap will be completely filled when the parts are mated. Allow for squeeze-out at the edges of the bond to assure filling. Carefully secure or clamp parts to prevent joint movement while the adhesive sets. Do not apply excessive pressure that can cause excessively thin gaps and starve the bond line. A minimum gap of 20 mils (0.02 inch) is recommended for all other adhesives. Test the curing adhesive at the edges for fingernail hardness before removing clamps or fixtures. If clean up of the adhesive from the bonded area is required, we recommend that it be carefully performed using alcohol or other preferred industrial solvent while the adhesive is still wet or soft. Partially cured adhesive can be carefully removed with a sharp knife. Cured adhesive must be sanded or scraped, using a suitable solvent to remove remaining traces.

Ordering Instructions: This product is a net priced item to our distributors. Check with your local PEI distributor for pricing

Shipping: DBB IV is not a hazardous material and may be shipped ground without special handling.

Disposal: Generally the easiest way to dispose of DBB IV is to mix any remaining material and allow it to cure. The cured product is then a solid and normally may be dumpster disposed. However, the end user should check with local authorities for proper handling and disposal of such products.