

How to make connections with tube sleeves

General

- The tubing material of the tube sleeves should be the same as the tubes to be connected.
- For the tube sleeve, choose an inner diameter that closely matches the outer diameter of the tubes to be connected.
- Choose the appropriate adhesive and primer (only for nonpolar elastomers) for the tubing material used.
- If possible, clean and check the tubing with compressed air after the adhesive has cured.

Connecting PharMed® tubing by means of a tubing sleeve

Glue

ergo® primer 5150 and ergo® adhesive 5861

Description of ergo® Primer 5150

The primer ergo® 5150 is based on an additive which is dissolved in an organic solvent. It serves to prepare non-polar and hard-to-glue polymers such as Polyethylen, Polypropylen, Polyamid, Silicone rubber for bonding with an ergo® cyanoacrylate adhesive.

Directions for use

The primer can be applied through an absorbing material, small sponge or brush (there is one inside the bottle screw cap) to the corresponding surface. Dipping the parts into the primer is also possible.

After the primer is applied, wait for ca. 10 min for complete evaporation of the solvent. The elapse time between primer and adhesive application should be less than 1 hour.

If only one of the joining tubes is made of nonpolar elastomer, treat only this piece with primer. On the tubing made of polar material, the adhesive is applied to the untreated surface.

Bonding instructions for ergo® 5861

Apply the adhesive directly from the bottle on the tube with the smaller diameter. Immediately after this process, insert with smooth rotary movement into the outer tube. Stretching the end of the inner tube before applying the adhesive makes it easier to insert the tube into the sleeve. If possible, clean the tube bore thoroughly with compressed air (no occlusion / faster curing / leak check).

Caution: For this procedure there's just a short time available!

Advice on safety and health precautions: see data sheet of primer and adhesive.

Storage in unopened bottle: 6 months at room temperature.