

HFT CONDUIT & FITTINGS

HALOGEN FREE

HFT conduit & fittings have been tested and confirmed to contain no brominated flame retardants (polybrominated biphenyls and polybromo diphenyl ethers), chlorinated polymers (e.g. uPVC, PVDC, etc.), inorganic halides, or organohalides (detection limit 10mg/kg(ppm)). For full details of testing please refer to www.marley.co.nz

TEMPERATURE

It is recommended that the continuous service temperature does not exceed 110°C or fall below -40°C.

UV PROTECTION

HFT conduit & fittings has UV inhibitors for 5 - 10 years.

CHEMICAL RESISTANCE

HFT conduit & fittings are resistant to a wide range of chemicals. For full details of chemical resistance please refer to www.marley.co.nz

RESISTANCE TO BURNING

HFT conduit & fittings is classified by the AS/NZS 2053 standard as a 'non-flame propagating' conduit which does not support combustion

SAFETY

HFT conduit & fittings are non-conductive and there is no risk of becoming live.

JOINING

Conduit and fittings are easily joined with 3M™ Scotch-Weld™ Structural Plastic Adhesive DP8010 or DP8005. These are two-part acrylic-based adhesives (10:1 ratio by volume) that can bond many low surface energy plastics without special surface preparation. DP8010 has a long work life (up to 10 minutes) whilst DP8005 has a reduced work life of 3 minutes. Both solvents achieve handling strength in about 2 hours.

1) Apply adhesive to clean, dry substrates, which are free of paint, oxide films, oils, dust, mold release agents and all other surface contaminants.

35 ml Cartridge:

Place duo-pak cartridge in EPX applicator. Remove cap. Dispense and discard a small amount of adhesive to assure even ratio and free flow. Clear orifice if necessary. Use only orange 10:1 mixing nozzle by: (a) aligning nozzle notch with cartridge recess, and (b) twisting into place. Dispense and discard a small amount of adhesive through nozzle until the adhesive is mixed.

2) After the adhesive is applied, substrates must be mated within the work-life of the adhesive or sooner for one-sided applications. Adhesive thickness less than .127mm will yield unpredictable results. The joint design of the substrates should facilitate a .127mm to .203mm adhesive thickness at the bondline. Adhesive contains .203mm microspheres for this purpose.

3) The bonded surfaces should be fixtured, or clamped, for at least 2 hours. The clamping pressure should be sufficient to keep the surfaces in contact during cure (typically 0.275-0.552 bar). Plastic parts can be designed to be self- fixturing, negating the need for external fixturing.

Note: Heating the bondline to 66-80°C for 30 minutes will speed up curing. Assembled parts must remain at room temperature for 10 minutes prior to heating to allow more adhesive penetration into the substrates before heat-accelerated cure.

4) Cured adhesive appearance: the adhesive will yellow with time, a rippling effect in the adhesive as it cures is normal and indicates that the adhesive is mixed properly and curing normally.

For further details of Scotch-Weld™ DP8010 or DP8005 and its material safety data sheet (MSDS) please refer to either www.marley.co.nz or www.3m.com.au

INSTALLATION OF CONDUIT

The selections of conduit and fittings must comply with NZ Electricity Regulations, 1993. Installation should be made in conjunction with the New Zealand and/or Australian Electrical Code of Practice.