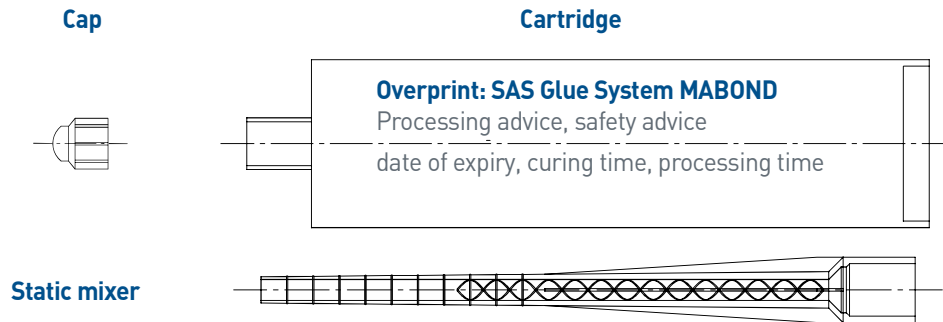


SAS Gluesystem: MABOND

Assembly instruction SAS 500/550; SAS 550; SAS 555/700



1. Preparation of the SAS Glue System MABOND

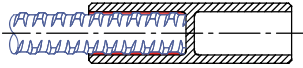
- | | |
|------------|--|
| <p>1.1</p> | <p>Don't use glue out of date (date of expiry). Remove the cap and screw on the static mixer. Use a new static mixer with a new cartridge. Never use a cartridge without a static mixer.</p> |
| <p>1.2</p> | <p>Insert the cartridge in the coaxial gun. Dispense a small amount of glue until a uniform colour appears. Not for use!</p> |

2. Assembling glued standard coupler connection (both sides glued on site)

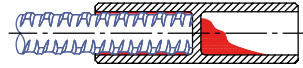
- | | |
|--|---|
| <p>2.1 Marking of both bars (half length of the standard coupler or the threadbar coupler)</p> | <p>2.2 Screw the coupler on bar 1 (two threads).</p> |
| <p>2.3 Fill in the glue acc. Tab. 2.</p> | <p>2.4 Screw in bar 2 until glue runs out of one side of the coupler.</p> |
| <p>2.5 Screw the coupler until marking of bar 1.</p> | <p>2.6 Screw bar 2 until:</p> <ul style="list-style-type: none"> - the bars (bar 1 and bar 2) meet in the middle - the glue runs out of both sides of the coupler - the marking of bar 1 and bar 2 is equal to the coupler |
| <p>2.7 Torqueing of the connection with torque momet acc. approval (glued coupler connection).</p> | |

3. Assembling glued coupler connection with middle stop (glued and pre-torqued coupler connection)

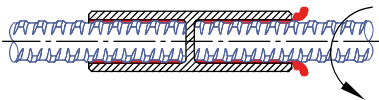
3.1 Delivery as one-sided glued and torqued connection.
Torque momet acc. approval (glued coupler connection).



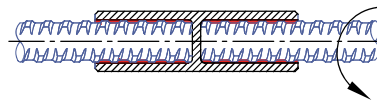
3.2 Fill in the glue acc. Tab. 2.



3.3 Screw in the connecting bar until:
- the face of the connecting bar lays against the middlestop
- glue runs out of the connecting side of the coupler

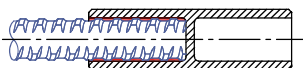


3.4 Torqueing of the connection. Torque momet acc. approval (glued coupler connection).

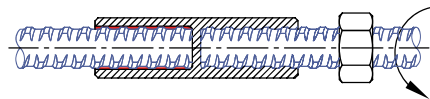


4. Assembling glued coupler connection with middle stop (glued and pre-torqued coupler connection)

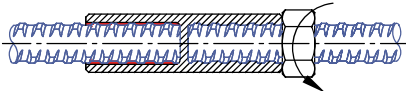
4.1 Delivery as one-sided glued and torqued connection.
Torque momet acc. approval (glued coupler connection).



4.3 Screw in the connecting bar until:
- the face of the connecting bar lays against the middlestop

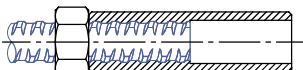


4.3 Screw the lock nut and torqueing acc. approval (torque coupler connection).

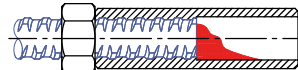


5. Assembling glued coupler connection (pre-torqued coupler connection with lock nut)

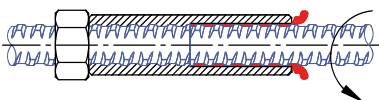
5.1 Delivery as one-sided torqued connection.
Torque momet acc. approval (torqued coupler connection).



5.2 Fill in the glue acc. Tab. 2.



5.3 Screw in the connecting bar until:
- the face of the connecting bar lays against the face of the other bar
- glue runs out of the connecting side of the coupler



6.4 Torqueing of the connection.
Torque momet acc. approval (glued coupler connection).

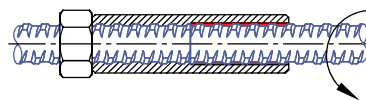


Tabelle 1: Processing time and curing time

Temperature	max. processing time	min. curing time	
		dry coupler connection	wet coupler connection
+ 40° C	1.4 min	15min	30min
+ 35° C bis + 39° C	1.4 min	20min	40min
+ 30° C bis + 34° C	2min	25min	50min
+ 20° C bis + 29° C	4min	45min	1:30h
+ 10° C bis + 19° C	6min	1:20h	2:40h
+ 5° C bis + 9° C	12min	2:00h	4:00h
0° C bis + 9° C	20min	3:00h	6:00h
- 4° C bis - 1° C	45min	5:30h	11:00h ¹⁾
- 5° C	90min	5:30h	11:00h ¹⁾

¹⁾ Coupler must be free of ice.

Tabelle 2: Amount of glue

Thread bar diameter	Standard coupler connection			Pre-torqued coupler connection	
	glue	volume	pump strokes	glue	pump strokes
(mm)	(ml)	(mm ³ /mm)	(amount)	(ml)	(amount)
12	3,2	41,91	0,50	1,6	0,25
14	4,8	48,34	0,75	2,4	0,375
16	6,5	52,54	1,00	3,3	0,50
20	11,3	81,06	1,75	5,7	0,875
25	13,0	110,07	2,00	6,5	1,00
26	14,5	114,51	2,25	7,5	1,125
28	16,0	125,83	2,50	8,0	1,25
30	19,5	139,76	3,00	10,0	1,50
32	23,0	148,05	3,50	11,5	1,75
36	29,0	180,31	4,50	14,5	2,25
40	35,0	211,29	5,50	17,5	2,75
43	45,0	250,53	7,00	22,5	3,50
50	65,0	325,03	10,00	32,5	5,00
57,5	78,0	338,23	12,00	39,0	6,00
63,5	84,0	372,00	13,00	42,0	6,50
75	130,0	538,17	20,00	65,0	10,00

Note: A glue cartridge contains 410 ml