



## INSTALLATION INSTRUCTIONS

### KOAT-A-ROLL® bonded

When installing Koat-A-Roll® on a drive roller, we recommend using Kastalon 3580 2-part epoxy bond in place of K-Lube®. Be sure to follow these additional instructions to ensure good bond strength.

#### Bonding Instructions:

1. Use a solvent to clean and prepare the roller surface to be bonded. Use a wire brush or steel wool to remove all loose material and metal oxides. Sandblasting of metals is recommended for optimum results.
2. Mix equal parts by volume of "A" and "B". Mix completely to ensure the proper chemistry reaction takes place. You will have approximately 45 minutes to work with the mixture when working in a 70 degree environment.
3. NOTE: At higher temperatures, the mixed material will become unworkable in a shorter period of time. Be cautious not to mix larger amounts of epoxy than needed.
4. Apply a thin film to the roller surface.
5. Using the K-Nozzle™ connected to a compressed air source; place the Koat-A-Roll over the end of the roller and slide on while blowing in air. Short rollers (less than 12" long) may often be assembled by hand without using compressed air.
6. Cure bonded parts at room temperature for 12 hours. If heat is available, bond may be heat cured at an accelerated rate according to the table shown below:

Temperature	Length of Cure
150°F	60 min.
200°F	30 min.
300°F	10 min.
400°F	3-5 min.

7. Until bond is completely cured, avoid handling the part so that sleeve does not shift or move.

