

# Estimated Joining Times (Minutes)

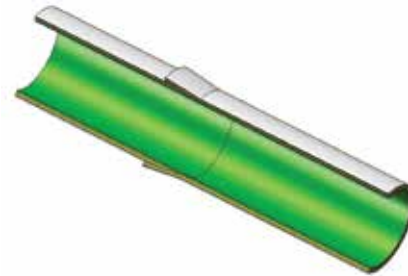


## Tapered Adhesive & Butt Joints

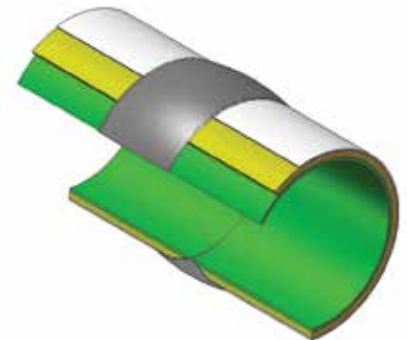
Dia. (inches)	Cut		End Prep		Assemble		Bond/Lay-up		Total Joint Time		Cure	
	TA	B&W	TA	B&W	TA	B&W	TA	B&W	TA	B&W	TA	B&W
1	2	2	1	5	3	7	5	15	11	29	50	180
1 1/2	2	2	1	5	3	7	5	20	11	34	50	180
2	2	2	1	7	5	10	10	30	18	49	50	180
3	2	2	1	10	5	10	10	30	18	52	50	180
4	2	2	3	10	7	10	10	30	22	52	50	180
6	3	3	4	15	10	15	10	35	27	68	50	180
8	5	5	7	30	15	25	15	40	42	100	70	180
10	10	10	10	30	15	25	15	40	50	105	70	180
12	10	10	10	30	20	30	20	80	60	150	70	220
14	-	10	-	45	-	30	-	140	-	225	-	220
16	-	15	-	60	-	40	-	180	-	295	-	240
18	-	15	-	80	-	40	-	200	-	335	-	240
20	-	20	-	100	-	45	-	240	-	405	-	280
24	-	20	-	120	-	45	-	300	-	485	-	280

**NOTES:**

1. Cure times for RPS' Tapered Adhesive joints require a heating collar (blanket).
2. Cure time for Butt & Wrap joints is the total cure time, and includes intermediate cures during lay-up sequences.
3. For Tapered Adhesive joints, the bonding time includes mixing, applying adhesive, seating the joint, securing the joint, and applying the heating collar.
4. For the Butt & Wrap joints, the lay-up time includes mixing of pastes and resin, as well as, wet out and applying of glass reinforcement. Final resin coat is also included.
5. Times listed are for joining only and do not cover handling, measuring, jiggging, travel, break-time, downtime, supports, etc.
6. Times are estimates and should be used only as a guide.



TA = Tapered Adhesive Joining



B&W - Straight Butt & Wrap Joining