

OATEY

BONDING ADHESIVE – X15

FOR BONDING OR SEAMING PVC SHOWER PAN LINER TO ITSELF

DIRECTIONS FOR USE

1. For large showers pan material may have to be seamed to adequately cover the floor, wall and curb area. Clean surfaces to be joined from dirt, grease, water or any other debris that may interfere with the bonding process.
2. Apply an even coating of adhesive with a brush or dauber applicator to both surfaces with a 2” overlap.
3. For best instant strength on contact, allow solvent coating to partially dry (approximately 15-30 seconds after applying X-15 to material) at which time both surfaces should be extremely tacky. Join the two surfaces and apply pressure using a paint roller or 2 x 4 wood section over the freshly bonded seam for 2-3 minutes. Observe the outer seam to make sure there are no gaps.
4. Do not disturb the liner immediately after assembly. Place a heavy object over the entire seamed area during cure period. This will help provide a strong bond between the pan liner surfaces. Good handling strength will develop in approximately two to four hours. Allow overnight cure before water testing a shower pan assembly.

CONDITIONS TO AVOID

1. **PUDDLING** – Excess adhesive will delay cure and handling strength. A thin, even coating on both surfaces to be joined is ideal.
2. **CURE** – is temperature dependent. The lower the ambient temperature, the slower the cure. Ideal application temperatures range from 60 to 80 degrees Fahrenheit. Avoid working in direct sunlight.
3. **NEVER** use Plastic Pipe solvent cement for seaming PVC shower pan liner.
4. **NEVER** use Oateyweld bonding adhesive to seam PVC pan liner material. Oatey X15 Bonding Adhesive is the only approved adhesive you will need for seaming Oatey PVC Shower Pan Liner.

ADDITIONAL INFORMATION

- 1. When used according to directions, Oatey Bonding Adhesive will give a permanent, waterproof seam.**
- 2. Seamed joints in a shower installation should always be water tested for leaks.**
- 3. Call manufacturer if assistance is needed.**