

Ivory 320

Epoxy Thixotropic Adhesive

PRODUCT DATA SHEET

Description

A two component medium cure, thixotropic epoxy adhesive with excellent gap filling properties.

Advantages

- A general purpose adhesive for most materials excluding certain plastics and stainless steel.
- Highly recommended in boat building applications in adhering wood to wood, wood to glass fibre, Formica and melamine to wood.
- Can be mixed with fillers such as saw dust or silica.

Surface Preparation

Any surface to be treated must be clean, dry, sound and free of contamination with foreign matter. Vacuum cleaning and wiping with *Flowcrete Epoxy Thinners* is recommended.

Smooth surfaces to be abraded.

Teak and oil containing woods to be thoroughly treated with oil-free acetone to provide an oil free bonding surface.

Mixing

Mix on a flat, clean surface such as a board or plate. Measure out quantities in accordance with mixing ratio and thoroughly mix to a homogeneous material using a spatula, paint scraper etc. If a filled material is required add the filler only after mixing is completed. All material should be stored in a cool place prior to mixing.

Important Note

Flowcrete's products are guaranteed against defective materials and manufacture and are sold subject to its standard Terms and Conditions of Sale, copies of which can be obtained on request

Properties

No of components:	2
Mixing Ratio:	
Ep / Act by volume:	1:1
Pot life @ 25°C:	45 minutes
Cure Time @ 25°C:	
Touch Dry :	6 hours
Practical Cure:	24 hours
Full Cure:	7 days
Volume Solids:	100%
Application Temp.:	Min 10°C
	Max 40°C
Max Service Temp.:	Dry 65°C
	Wet 40°C
Tensile Strength @ 25°C:	5mPa
Compressive Strength @ 25°C:	65mPa
Bond Strength:	
Concrete	Concrete breaks before bond
Wood	Wood breaks before bond
Colour:	Amber
Shelf Life:	2 years
Cleaner:	W.S.B.C.

Application

Spread the mixed material on one face, thick enough to extrude when both surfaces are mated and pressure applied. Bonded faces must be kept under pressure until the adhesive is set.

Health & Safety

Some of the components of this product may be hazardous during mixing and application. Please consult the relevant Health & Safety Data Sheet available from Flowcrete on request and sent with each delivery.