

## Technical Data Sheet

Issue No. 0.0

Date of Issue: July-2019

### Product Name: RelFix EP Adhesive

Two Component Thixotropic Epoxy based Structural Adhesive for RelWood™

### Description

RelFix EP Adhesive, an easy to use two-component solvent free thixotropic reinforced epoxy-based adhesive for bonding RelWood™ to RelWood™ sheets or Relwood™ to any other wood like material with excellent bonding characteristics.

### Application Areas

- Structural Bonding between sheets of any wood or wood like material for better long term dimensional stability
- Improves stiffness and prevents warping due to long term outdoor exposure
- Excellent adhesive for unlike materials like RelWood™, packing ply, particle board, wood, Bakelite etc.
- Outdoor wood furniture / fixtures

### Features & Benefits

- Excellent adhesion to any wood surfaces
- Solvent Free
- Pre-weighted Packing: No onsite proportioning required
- Thixotropic with easy application
- Can be grinded, planed, cut or drilled after drying

### Mechanical Properties

Compressive Strength @ 25° C (As per IS 6746) 7 Days	>50 MPa
Tensile Strength @ 25° C (As per ASTM D638) 7 Days	>25 MPa
Flexural Strength @ 25° C (As per ASTM D 790) 7 Days	>40MPa

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### Component Details & Physical Property

	Component A	Component B	Mixed
Feel	Paste	Paste	Paste
Color	Grayish white	Yellow	Grey
Mixing Ratio	100	65	-
Viscosity @ 25° C	75000 - 150000	150000 - 350000	-
Mixed Density			1.3-1.4
*Pot Life @ 25° C			60 minutes @ 25° C
*Setting Time @ 25° C			4 hours @ 25° C
Tg			55° C
Change in Volume			No Shrinkage Observed
Yield (Pack)	5kg	3.25kg	8.25 kg Combined Pack

Note: \* Ambient Temperature will affect the Pot life & Setting Time of the Product & is inversely related

### Mixing Procedure

- Mixing ratio: Component A -100 & Component B -65
- Full Pack Mixing is ideally suggested for accurate result
- Part Mixing suggested only if precise proportioning facility available at site
- Mechanical Mixing using low speed stirrer is suggested
- Mixing till uniform color achieved of the mixed material.

### Application Procedure

- Surface to be clean of Oil, Grease, dust & any other material which will affect the adhesion of RelFix EP Adhesive to Substrate
- Substrate Residual Moisture to be less than 4%. Not to be applied on substrate with rising dampness.
- Apply the mixed material with trowel or roller over the substrate to achieve required thickness. Application to be done on both sides which come into contact with each other.
- Sufficient quantity to be applied so that the bonding layer between both substrates are sufficiently thick. The rigidity against load/heat deflection will depend on the thickness achieved.
- Application to ensure a uniform and thick bonding layer and allow for at least eight hours for good bond strength

### Packaging Size

- Base: 5 kg
- Hardener: 3.25 kg

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### Shelf Life

- Base: 18 Months
- Hardener: 12 Months

### Storage Condition

- Material to be stored in cool dry place
- To be kept in shade with no direct sunlight

### Health & Safety Hazard Condition

Please refer to MSDS for detailed information on the health & safety hazard while using the product.

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