

TECHNIGLUE-CA R60 is a solvent free, epoxy resin, specifically formulated for use with TECHNIGLUE-CA hardeners to cure at room temperature, and produce high-strength, waterproof bonds. The thixotropic nature of the adhesive provides good gap filling and hold-up, on vertical surfaces.

TECHNIGLUE-CA hardeners are available with 3 different curing rates – Fast, Slow and Super Slow - allowing working times to be adjusted according to the job size and working temperature.

TECHNIGLUE-CA is suitable for bonding structural elements fabricated from wood, concrete, fibreglass, stone & marble, pottery, metal (ferrous and non-ferrous) and some plastics.

MIX RATIO

1 part hardener to 2 parts resin by volume

Take care to assure that the components are thoroughly mixed to a uniform colour before applying.

It is easier to judge the proportions by placing three equal quantities side by side (two of resin and one of hardener).

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.

UNCURED PROPERTIES

	R60	H60F-Fast	H60S-Slow	H60SS-Super Slow
Physical State	White thixotropic gel	Amber thixotropic gel	Amber thixotropic gel	Amber thixotropic gel
Viscosity mPas @ 25°C	480,000	400,000	335,000	350,000
Specific Gravity g/ml @ 25°C	1.09	0.97	0.96	0.96

CURE CHARACTERISTICS

	H60F	H60S	H60SS
Pot Life -100g @ 25°C (in air)	15 minutes	30 minutes	50minutes
Cured to a solid state @ 25°C	8 hours	12 hours	16 hours
Mix viscosity mPas @ 25°C	280,000	175,000	140,000
Shore D Hardness -1 day	80	75	79
- 2 weeks	82	76	80
HDT after 24 hours @ 25°C	41°C	32°C	35°C
2 weeks @ 25°C	63°C	48°C	50°C
24hours @25°C			
+16 hours @ 50°C	61°C	58°C	61°C
+ 8 hours @ 80°C	68°C	59°C	68°C

CURED PROPERTIES

Tensile Strength	25 - 30 MPa	3.6 - 4.4 ksi
Tensile Bond Strength	10 - 12 MPa	1.5 - 1.7 ksi
Compressive Strength	60 - 80 MPa	8.7 - 11.6 ksi
Flexural Strength	20 - 25 MPa	2.9 - 3.6 ksi

APPLICATION

The surfaces to be bonded should be dry and free from any contaminants such as oil or dust. Fibreglass, timber, painted, or metal surfaces should be thoroughly sanded to provide a good key. Concrete surfaces should be wire brushed to remove laitance.

Apply sufficient mixed epoxy to one or both of the surfaces to assure intimate contact between the bonding surfaces. Excessive clamping pressures should be avoided. Components need only be held firmly to avoid movement during the curing process.

COVERAGE

Depending on porosity and surface roughness, one litre of mixed TECHNIGLUE-CA will cover approximately three square metres.

CLEAN UP

Uncured TECHNIGLUE-CA resin and hardener mixture can be cleaned up with warm water.

HEALTH AND SAFETY

TECHNIGLUE-CA R60 resin and H60 hardeners have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.

- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.

- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

PACK SIZES

Order Code		Order Code		PACK
Resin		Hardener		
RA60	500 ml	HA60	250 ml	750 ml
RB60	1L	HB60	500 ml	1.5 L
RC60	4L	HC60F HC60S	2L 2L	6L
RD60	20L	HD60F HD60S HD60SS	10L 10L 10L	30L

STORAGE

TECHNIGLUE-CA R60 resin and H60 hardeners will keep for 2 years, if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 27/05/04



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