PRODUCT DATA SHEET

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STAYBOND EPOXY GLUE

DESCRIPTION: A non staining gap filling, 2 pack epoxy adhesive of exceptionally high strength and cohesive value.

USES: As a waterproof, structural glue for boatbuilding and laminating work. Also used for bonding fibreglass, metals, concrete, ceramics and glass to themselves or to dissimilar materials.

SIZES:

3.8Kg	1.9Kg	950g	470g	200g
(4L)	(2L)	(1L)	(500ml)	(250ml)

PROPERTIES (At 20°C)

COLOUR: Translucent cream

TOXICITY: See Precautions and refer to Safety Data Sheet

FINISH: Non staining, light amber

COVERAGE: 1 mixed litre = 1000cu.cm. (1 mixed litre will cover 1m² at 1mm thick)

DRYING TIME: Workable after 24 hours. Full cure 7 days

RECOATING: N/A

POT LIFE: At 20°C mix only sufficient for 20 mins use. Storage life is minimum of 5 years if correctly sealed. NOTE: The hardener deteriorates quickly if not sealed properly.

MIXING RATIO: 1:1 by volume.

THINNING: NOT BE THINNED UNDER ANY CIRCUMSTANCES.

WEIGHT/LITRE: 0.95kg when mixed

VOLUME SOLIDS: Exceeds 99%

FLASH POINT: Base: >200°C Hardener: N/A

CLEAN UP: NORGLASS EPOXY THINNER

U.N. NUMBER: 3082

TRANSPORTATION: DG Class:9 HAZCHEM:3Z P.G. III

PREPARATION:

TIMBER: Remove all forms of grease, oil, water or other contaminants.
Sand timber at 45degrees to the grain. Vacuum off all sanding dust from the grain. **This is essential for adhesion**.
Wipe over the surface to be glued with paper towel dampened with NORCLEAN-PLUS and allow to dry.
Oily timbers such as teak should be wiped down with NORGLASS ACETONE to remove surface oils and be coated with STAYBOND EPOXY GLUE within 20 minutes.
If left too long, more oil will rise to the surface of the timber reducing the overall adhesion.

OTHER SURFACES: All other substrates should be sandblasted or thoroughly solvent cleaned to ensure positive bonding.

APPLICATION:

Measure out an equal volume of STAYBOND Base and Hardener (using separate spatulas) onto a non-porous mixing board and blend together thoroughly.
Blending or mixing should be done with a stick or spatula **not contaminated with either base or hardener. Mark each appropriately.**
Mix together until a creamy paste is achieved and no sign of unblended material remains (no streakiness).
Apply the glue mix liberally to either or both faces to ensure positive coverage over the entire area and bring both surfaces into contact. DO NOT attempt to reposition the joint after 20 minutes at 20°C. Clean off excess glue exuding from the joint BEFORE SETTING TAKES PLACE.

DO NOT OVER CRAMP OR STARVE THE JOINT OF GLUE. This is very important on porous surfaces. At 10-25°C cramp for a minimum 48 hours. At 25-30°C cramp for a minimum 24 hrs.

SPECIAL INSTRUCTIONS:

Do not attempt to glue when the **surface temperature** is below 10°C or when the temperature is likely to fall to that point during the first 12 hours of glueing.
At temps below 25°C it is recommended to warm both tins for 10-15 mins prior to mixing.

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On large projects it is advisable to keep the mixed glue warm during application.
Under **no** circumstances can the mixing ratio of 1:1 by volume be altered or other extenders be added to the mix. Adding **excess Hardener** will make the mix rubbery not set it off quicker.
Do not glue to charred or blackened timbers caused by burning off or high speed sanding. These areas must be planed or re-dressed before glueing.

STAYBOND Complies with British Standards 1204 parts 1 & 2 for water and boil proof criteria.

PRECAUTIONS:

Wear protective clothing and use personal protective equipment required
Do not breathe fumes, gas, mist or vapours.
Do not eat, drink or smoke when using this product.
Use outdoors or in a well-ventilated area.
Wash hands thoroughly after handling.
Store locked up, in a well-ventilated place. Keep cool.
Keep out of reach of children

FIRST AID:

If poisoning occurs call a doctor or Poisons Information Centre (Aust) on 131126 or (NZ) 0800 764 766 and have label information ready.
If in Eyes rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. If eye irritation persists get medical advice.
If on Skin wash with plenty of soap and water. Take off contaminated clothing and wash before re-use. If skin irritation occurs get medical advice/attention.
If Swallowed rinse mouth. DO NOT induce vomiting. Give a glass of water. Never give anything to the mouth of an unconscious person. If vomiting occurs, place victim face downwards, with the head turned to the side and lower than the hips to prevent vomit entering the lungs.
If Inhaled remove person to fresh air. Remove contaminated clothing and loosen remaining clothing. Allow person to assume most comfortable position and keep warm. Keep at rest until fully recovered. Get medical advice if breathing becomes difficult.

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