

PRODUCT DATA SHEET

NORGLASS LABORATORIES PTY.LTD.

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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.

PROPERTIES (At 20°C)

- COLOUR:** Translucent cream
- TOXICITY:** See Precautions
- 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 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:** Non volatile

CLEAN UP: NORGLASS EPOXY THINNER

U.N. NUMBER: 3082

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. (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.

TRANSPORTATION:

DG Class 9 HAZCHEM 3Z P.G.III
36Kg 7.6Kg 3.8Kg 1.9Kg 950g 470g 200g
(40L) (8L) (4L) (2L) (1L) (500ml) (250ml)

PRECAUTIONS:

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.

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.

In cold weather prewarm both components by standing the cans in hot water for 15 minutes before mixing.

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Replace lids to both cans tightly when not in use.

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.

Provide adequate ventilation during use. Avoid contact with skin and eyes and do not smoke or eat without thorough washing

Do not leave the lid off the hardener as this product deteriorates rapidly when left exposed to air and/or humid conditions, rendering the product ineffective.

FIRST AID:

If poisoning occurs call a doctor or Poisons Information Centre (Aust) on 13 11 26 or (NZ) 0800 764 766 and have label information ready.

If swallowed DO NOT induce vomiting. Give large quantities of water or milk. In case of eye contact, flush immediately with plenty of water for at least 15 minutes and consult a doctor. Remove contact lenses if present and easy to do and continue rinsing. In case of contact with skin, remove contaminated clothing and wash skin thoroughly. If breathing difficulty arises remove to fresh air. Apply artificial respiration if not breathing.

SPECIAL

INSTRUCTIONS:

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