

ROTAFIX STRUCTURAL ADHESIVE (LM) EPOXY BONDING ADHESIVE



PRODUCT CODE: 3113 - 3 litre

DESCRIPTION: ROTAFIX STRUCTURAL ADHESIVE is a unique 2-part thixotropic epoxy gap filling adhesive (thickness 0.20mm-12mm*). ROTAFIX STRUCTURAL ADHESIVE is formulated for bonding GFRP and CFRP fibre rods and plates in particular to timber components

SPECIFIC USES:

- 1) As a gap filling adhesive for use with stainless steel, glass fibre anchors and fixings.
- 2) As a thin film adhesive for greenheart timber to metal construction.
- 3) In conjunction with **Rotaflex Pultrusions** for the repair and upgrading of glu-laminated components.
- 4) With masonry stitching components such as **Rotaflex Rod** and **Spirotie**.
- 5) Crack injection of stone, masonry or timber

PACKAGING: Available in 3 litre packs.
Weight of base component 2.5 kgs. Both components are thixotropic.
Weight of curing agent 1.0 kgs.

PREPARATION OF SUBSTRATE: All surfaces should be clean, sound and free from contaminants.

MIXING: If using the whole of the pack mechanical mixing is advised. It is possible to proportion the pack, e.g. 250 gms of base may be mixed with 100 gms of hardener to form a part mix. Suitable scales must be used for proportional mixing. Contact Rotafix Technical Department for further information.

APPLICATION AND EQUIPMENT:



ROTAFIX STRUCTURAL ADHESIVE should only be applied to substrates which are clean, free from dust and loose rust, loose stone particles or other deleterious substances. In the case of injection ROTAFIX STRUCTURAL ADHESIVE may be used with 400cc and 1 litre cartridges, in conjunction with suitable plastic injection tubes. Contact Rotafix Technical Department for specification applications. The mixed material will pump under low shear conditions. The mixed paste may be applied on vertical surfaces up to 10mm thick dependent on temperature. The 'open' time at +15°C is a minimum of 2 hours. The 'open' time will not significantly change within the temperature range +5°C to +30°C

CURE SCHEDULE:

** According to CEN Standard N20

Workability:	Cure Schedule	**Peak Exotherm	
		uninsulated	Insulated
12 hrs at +10°C	3 Days at +10°C	15°C	20°C
6 hrs at +20°C	2 Days at +20°C	30°C	35°C
6 hrs at +30°C	1 Day at +30°C	40°C	80°C

MATERIAL USAGE /COVERAGE: 1 litre of mixed material covers 1m² at 1mm thick.

CURED PROPERTIES:

Compressive strength >55N/mm² . +5 days at +20°C.
ROTAFIX STRUCTURAL ADHESIVE has a bond strength to prepared hardwood and softwood Timber exceeding 6N/mm² Bond Strength to grit blasted steel 6-10 N/mm²
Tensile strength >20 N/mm² Flexural Strength: 62N/mm² (average)
modulus of elasticity 2.4 GPa (ductile failure mode)

CLEANING OF TOOLS:

Uncured ROTAFIX STRUCTURAL ADHESIVE may be readily removed from tools and equipment with Rotafix **S200PC** Solvent Cleaner. Mechanical methods are required to remove cured material.

The site conditions and equipment required when using individual Rotafix products are specific for each project. Only advice given by Rotafix in writing will be considered as part of our contractual liability.

Epoxy resins and their associated curing agents can cause irritation to some people.

Please take the necessary precautions indicated in the COSHH details available from our offices.

Please read our Users Safety Guide on the Handling of Resin and Polymer products.

The information in this document is based on practical tests, but given without guarantee inasmuch as methods of use by others is beyond our control. Due to continuing development and improvements, it may be necessary to change without notice the material specification. All goods are sold subject to our Standard Conditions of Sale.

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