

TECHNIGLUE R60 is a solvent free, epoxy resin, specifically formulated for use with TECHNIGLUE 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 H60 hardeners are available with two different curing rates - Fast and Slow - allowing working times to be adjusted according to the job size and working temperature.

TECHNIGLUE R60 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.

Independently tested by FORAY Industries - NATA Accreditation 1231 - using the SCAQMD Test Method 303-91 *Determination of Volatile Organic Compounds in Various Materials Rule 1168*, Techniglu R60 has recently gained approval for VOC compliance under the specification of the Green Building Council of Australia / Green Star Office Design V3 IEQ-13. for the Multipurpose Construction Adhesive Category. June 2012.

UNCURED PROPERTIES

	R60	H60F - Fast	H60S - Slow
Physical State	White thixotropic gel	Amber thixotropic gel	Amber thixotropic gel
Viscosity mPas @ 25°C	420,000	600,000	600,000
Specific Gravity g/ml @ 25°C	1.12	1.01	1.00

CURE CHARACTERISTICS

	H60F - Fast	H60S - Slow
Pot Life -100g @ 25°C (in air)	20 minutes	40 minutes
Cured to a solid state @ 25°C	8 hours	12 hours
Mix viscosity mPas @ 25°C	280,000	175,000
Shore D Hardness -1 day	81	68
- 2 weeks	85	83
Glass Transition temperature:		
after 24 hours @ 25°C	33°C	21°C
after 2 weeks @ 25°C	49°C	43°C
24hours @25°C		
+16 hours @ 50°C	65°C	52°C
+ 8 hours @ 80°C	68°C	57°C

CURED PROPERTIES		
	H60F - Fast	H60S - Slow
Tensile Strength (ASTM D638-97)	67 MPa	55 MPa
Tensile Elongation at Break (ASTM D638-97)	6 %	7 %
Flexural Strength (ASTM 790-03)	95 MPa	80 MPa
Flexural Strain (ASTM 790-03)	4 %	5 %
Compressive Strength (ASTM 695-96)	55 MPa	51 MPa
Compressive Load (ASTM 695-96)	10630 N	9819 N
Tensile Strength (ASTM D3528)	20 MPa	24 MPa
Tensile Lap Shear Strength (ASTM D1002) Aluminium	13 MPa	13 MPa
Tensile Lap Shear Strength (ASTM D1002) Mild Steel	20 MPa	24 MPa

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 R60/H60 will cover approximately three square metres.

CLEAN UP

Uncured TECHNIGLUE R60 resin and H60 hardener mixture can be cleaned up with warm water.

PACK SIZES				
Order Code		Order Code		PACK
Resin		Hardener		
RA60	500 ml	HA60F	250 ml	750 ml
RB60	1L	HB60F	500 ml	1.5 L
RC60	4L	HC60F HC60S	2L 2L	6L
RD60	20L	HD60F HD60S	10L 10L	30L

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. 23.1.18

STORAGE

TECHNIGLUE 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.

HEALTH AND SAFETY

TECHNIGLUE 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 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.

