



TECHNICAL DATA BULLETIN

THIXO FLEX

TotalBoat Thixo Flex is a toughened two-part epoxy adhesive engineered for a superior grip to metals, plastics, glass, masonry, fiberglass, and wet and difficult-to-bond hardwoods. It is a thixotropic paste adhesive that has an easy to use 1:1 mix ratio by volume and provides a relatively long open working time. Structural bonds made with Thixo Flex are resilient and can withstand the stresses of expansion, contraction, shock, and vibration.

HANDLING PROPERTIES	<u>VALUE</u>	<u>TEST METHOD</u>
Resin Density, lbs/gal	10.0	ASTM D1475
Hardener Density, lbs/gal	8.3	ASTM D1475
Mix Ratio By Volume	1A : 1B	Calculated
Mix Ratio By Weight	1.2A : 1B	Calculated
Initial Mixed Viscosity at 77°F, cP	Thixotropic	ASTM D2196
Gel Time at 72°F, 100g mass, minutes	40	ASTM D2471
Working Time, thin film, minutes	75	
Initial Cure Time, hours	3-4	
Workable Cure Time ¹ , hours	7-10	(124 Hours For High Loads)
Minimum Recommended Temperature	40°F (4°C)	

PHYSICAL PROPERTIES	<u>VALUE</u>	<u>TEST METHOD</u>
Color	Buff	Visual
Tensile Strength, psi	5,330	ASTM D638
Tensile Elongation, %	23.8	ASTM D638
Tensile Modulus, psi	187,000	ASTM D638
HDT, Room Temperature Cure, °F	134	ASTM D648
HDT, Post Cure, °F	189	ASTM D648
Compressive Strength, psi	7,200	ASTM D695
Flexural Strength, psi	8,800	ASTM D790
Flexural Modulus, psi	203,000	ASTM D790
Density, Cured, g/cm ³ (lbs/in ³)	1.14 (0.041)	ASTM D792
Volumetric Yield, in ³ /lb	24.3	ASTM D792
Volumetric Shrinkage, %	3.5	ASTM D792/D1475
Hardness, Shore D	77	ASTM D2240
Onset of Tg by DSC, °F	195	ASTM D3418
Ultimate Tg by DSC, °F	213	ASTM D3418





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INSTRUCTIONS FOR USE:

For best results use this product at or above 40°F. Surfaces should be clean, dry and sanded before application to remove dirt, dust, grease, loose paint, oils or other contaminants. The adhesive will gel in about 40 minutes at 72°F. Assemble and clamp parts in position before the adhesive begins to gel. Keep parts clamped until the adhesive is cured, about 3-4 hours at 72°F. Cure time is faster at warmer temperatures and slower at cooler temperatures.

STORAGE:

Store at 60-90°F in a dry place. After use, tightly reseal all containers. Store products on a raised surface off the floor during cold weather and avoid storing near outside walls or doors. Epoxy resins that are contaminated with dust or moisture, or are subjected to low temperatures may crystallize. Do not use material that has any sign of crystallization until it has been liquefied. A crystallized resin or hardener can be returned to its original state by heating the material to 140°F to 150°F and stirring until it returns to the liquid state.

SAFETY HANDLING:

Work in well-ventilated areas using gloves, eye protection and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Safety Data Sheets for complete precautions with this product.

Jamestown Distributors has experience only in the compounding of resins and hardeners and not in the actual manufacture of tools or parts. Each piece is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.

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