

## TotalBoat Thixo Gap -- Tech Data Sheet

### DESCRIPTION:

TotalBoat Thixo Gap is a fast-setting thixotropic, two-component, room temperature curing epoxy adhesive for bonding and sealing applications. It is packaged in two-component cartridges and can be dispensed easily through the provided static mixing nozzle(s), using a Thixo Pro Series Gun. Thixo Gap contains glass spacer beads to ensure a minimum bond line thickness of 0.02 inches. It cures to a hard surface that can be drilled, painted, or sanded. It is not appropriate for use as a gap filler, and cannot be applied with a material thickness of over 1/2 inch.

### KIT INCLUDES:

- One (1) 450 ml Cartridge of TotalBoat Thixo Gap
- Two (2) Static Mixing Tips

### INSTRUCTIONS FOR USE:

1. For best results, use this product at or above 55°F.
2. Before application, surfaces should be clean, dry, and sanded with 80-grit (or more coarse) sandpaper to remove dirt, dust, grease, loose paint, oils, or other contaminants.
3. The adhesive will gel in about 30 minutes at 77°F when dispensed as a single bead, or in 10 minutes at 77°F in a mass of 150g or more.
4. Assemble and clamp parts in position before the adhesive begins to gel. Keep parts clamped until the adhesive is cured (about 24 hours). Cure time is faster at warmer temperatures and slower at cooler temperatures.

### MIXING:

1. Insert the cartridge into a caulk gun. For best results, use a caulk gun with an 8 to 1 (or higher) thrust ratio. Remove the retaining nut and the nose plug from the top of the cartridge. Attach the static mixing nozzle, if this is the desired method of application. Tighten the nozzle firmly. Trim the tip of the static mixing nozzle to deliver the desired size bead.
2. Dispense a small amount of material (3-4 inches of bead) that should be considered waste material to ensure that the two components (Part A and Part B) are flowing from both sides of the cartridge nozzle. Material should flow from the static mixing nozzle in one uniform color when dispensed.
3. The adhesive may also be dispensed without a static mixing nozzle, but must be dispensed into a cup and mixed thoroughly before application.

### STORAGE:

Store at 60-90°F, in a dry place. After use, reinstall the nose plug and retaining nut to store unused adhesive. 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 with the skin and eyes. Avoid clothing contamination. Wash hands thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult the SDS (Safety Data Sheet) for complete precautions with this product. Always use an appropriate respirator when sanding this material.

### HANDLING PROPERTIES:

**Dispensing Method:** Thixo Pro Series Gun  
**Components:** 2 - Resin and Hardener  
**Units:** 450 ml cartridge  
**Cartridge Tip:** TotalBoat Thixo Tip  
**Color:** Resin - Buff, Hardener - Amber  
Mixed/Cured: Buff color  
**Application Temperature/RH:** 55-90°F, 0-90% RH  
**Mix Ratio:** 2A:1B (by volume)  
100A:46B (by weight)  
**UV Stable:** No. This product has some UV resistance, but is not designed as a finish material.  
**Storage:** Store at 60-90°F, in a dry place. 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.

### PHYSICAL PROPERTIES:

**Minimum Bond Line Thickness:** .02" (Glass Spacer Bead Thickness)  
**Mixed Viscosity:** Thixotropic  
**Sag Resistance:** .5" (Vertical Surface)  
**Maximum Gap Filling Thickness:** 1/2"  
**Gel Time @ 77°F (150g mass):** 10 minutes  
**Full Cure/Clamp Time: @ 77°F (Thin Film):** 24 hours  
**Heat Deflection Temperature:** 133°F (Post Cured)  
**Tensile Strength:** 8,500 psi  
**Tensile Elongation:** 7.4%  
**Tensile Modulus:** 372,000 psi  
**Flexural Strength:** 13,200 psi  
**Flexural Modulus:** 393,000 psi  
**Shore Hardness (D):** 82  
**Compressive Strength:** 9,600 psi  
**Tensile Adhesion to Wood:** 1,3800 psi  
**Tensile Adhesion to Aluminum:** 1,890psi  
**Tensile Adhesion to G10 Laminate:** 2,030 psi

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