

SOLIDBOND 20S

High Performance Epoxy Adhesive

Solidbond 20S is a two part system general purpose epoxy adhesive recommended where strength and flexibility are required. Fillers such as silica, etc. can be incorporated with the epoxy adhesive. Solidbond 20s is recommended for the boating industry for applications of wood to wood and fibre glass to wood, etc.

BENEFITS:



Good chemical resistance.



*High impact resistance
High physical strength
Flexible (Allows for expansion rate differences between components).*



Paste consistency- Ease of application. Thixotropic and can be applied to vertical or overhead surfaces.

TECHNICAL DETAILS

Adhesion to Concrete	>1.5 MPa (Concrete failure)	ASTM D7234
Impact Resistance	1 kg >1.8 m 2 kg >1.5 m	ISO6272-1:2011
Hardness	80	Shore D
Water Uptake (Permeability)	Nil	Karsten Test
Service Temp	Wet 50°C Dry 70°C	
Chemical Resistance	Refer to chemical chart	
Solids Content	100%	
Pot Life	50 to 70 minutes	
Touch Dry	6 hrs	
Practical cure	24 hrs	
Full cure	7 days	
Colour	Natural	
Dry Film Thickness	0.25 mm	
Application Temperature	5 to 28°C	
PACKAGING	1 L, 2 L and 10 L kits	
Shelf Life on storage at 25°C - 12 months		

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APPLICATIONS

- mild steel
- aluminium
- high alumina tiles
- all regular building materials
- boating industry materials

SUBSTRATE REQUIREMENTS

All surfaces must be clean and sound.

Concrete

Concrete substrates must have a minimum compressive strength of 20 to 25 MPa, a minimum tensile pull-off strength of 1.5 MPa and be free of oil, fat, grease, dust, and loose friable materials.

Wood

Wooden substrates are to be suitably sanded, existing coatings are to be removed. Sweep dust and loose debris followed by vacuuming, to obtain a dry and dust-free surface.

Steel

Steel surfaces require abrasive blast cleaning (Sa 2 $\frac{1}{2}$., ISO 8501-1: 1988), alternatively the steel can be prepared mechanically to Grade St3. Mechanical cleaning is, however, not as effective as abrasive blasting and results in a shorter maintenance free life.

PREPARATION

Remove all previous coatings, unbonded concrete and laitance mechanically through diamond grinding, abrasive blasting or scarifying to obtain a sound and porous surface (sandpaper texture). Sweep dust and loose debris followed by vacuuming, to obtain a dry and dust-free surface.

HEALTH AND SAFETY

Please read Safety Data Sheet and specific health and safety data for this product provided in compliance with the requirements of OHS Act No. 85 of 1993. The finished system is not hazardous to health or the environment.

WARRANTY

Technical Finishes products are manufactured under high quality standards and are warranted against defective materials and are sold subject to standard Terms and Conditions of Sale, copies of which can be obtained upon request. Technical Finishes deals with approved applicators and carry a back to back warranty with these clients. Technical Finishes cannot be held responsible for the workmanship in surface preparation and application of our products, it is understood that the approved contractor will guarantee such workmanship and application. It is vital that the application is done in accordance to our specification.

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