

SOLIDBOND 20S

High Performance Epoxy Adhesive

Solidbond 20S is a structural, two-part, general purpose epoxy adhesive system where excellent bonding strength and flexibility is required.

Solidbond 20S is recommended in the boating industry for applications of wood to wood as well as wood to fibre-glass bonding. The addition of fillers such as wood sandings and silica may be incorporated with the adhesive.

UNIQUE PRODUCT BENEFITS

- Excellent adhesion.
- 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.

APPLICATIONS

- Wood bonding.
- Mild steel.
- Aluminium.
- High alumina tiles.
- All regular building materials.
- Boating industry materials.

TECHNICAL DETAILS

Adhesion to Concrete	> 1.5 MPa (Concrete failure)	ASTM D7234
Hardness	80	Shore D
Mix Ratio	1:1 (V/V)	
Pot Life	50 to 70 min.	
Cure Times @ 25°C		
Touch Dry	6 hrs	
Practical Cure	24 hrs	
Full Cure	7 Days	
Solids Content	100%	
Application Temperature	Min. 10°C Max. 40°C	
Dry Film Thickness	0.25 mm	
Colour	Amber clear	
Shelf Life	2 years	
Cleaner	Brush cleaner	

PACKAGING

Solidbond 20S is supplied in 1 L, 2L and 10 L kits

**Leading manufacturers of specialist epoxy and polyurethane flooring systems,
specialised construction and corrosion protection products.**

Distribution facilities nationwide

Western Cape	Eastern Cape	Gauteng	KwaZulu-Natal
+27 (0)21 535 4455	+27 (0)41 451 3944	+27 (0)11 822 7242	+27 (0)31 705 7733



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SURFACE PREPARATION

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

Any wood containing oil needs to be treated with oil-free acetone. 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 2½, 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.

INSTALLATION

Measure equal volume amounts of Part A and Part B using a spatula. Mix thoroughly until a uniform colour is obtained. Apply using a paint scraper to the cleaned surface. Do not keep the mixed epoxy in the container as it will rapidly start to cure.

HEALTH AND SAFETY

Please read Safety Data Sheet and specific health and safety data for this product provided in compliance with the requirements of OHSA 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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