

# ROTAFIX STRUCTURAL ADHESIVE (LM)

## EPOXY BONDING ADHESIVE

**PRODUCT CODE:** 3552 - 400cc

**DESCRIPTION:** Rotafix **STRUCTURAL ADHESIVE** is a unique 2-part thixotropic epoxy gap filling adhesive (thickness 2mm-12mm\*). **STRUCTURAL ADHESIVE** is formulated for bonding GFRP and CFRP fibre rods and plates in particular to timber components

**SPECIFIC USES:**

- 1) As a gap filling adhesive for use with stainless steel, glass fibre anchors and fixings.
- 2) As a thick film adhesive for greenheart timber to metal construction as well as glass.
- 3) In conjunction with **Rotaflex Pultrusions** for the repair and upgrading of glued laminated components.
- 4) With masonry stitching components such as **Rotaflex Rod** and **Spirotie**.
- 5) Crack injection of stone, masonry or timber

Please contact Rotafix Ltd for individual specifications

**PACKAGING:** **STRUCTURAL ADHESIVE** is supplied in two screw cap containers, base resin and curing agent. Included is a follower plate and empty cartridge assembly.

**PREPARATION OF SUBSTRATE:** \*\*All surfaces should be sound, fully abraded, clean, and free from contaminants.  
\*\* Please contact Rotafix Ltd for specification

**MIXING:** Add the total contents of the smaller container (hardener) to the contents of the larger container (base). Mix the pastes thoroughly using a flat end pallet knife, reference: 3642. Place the follower-plate onto the surface of the mixed material ensuring it fits parallel in the tub with the outer and central lip pointing upwards. Cut the seal from the front end of the cartridge sleeve. Place the rear end of the cartridge vertically and centrally over the hole in the follower-plate. Press the cartridge firmly and continuously down on to the follower-plate until the follower-plate bottoms on the mixing tub base. Carefully remove and invert the now full cartridge. Screw on the front injection nozzle plus any chosen injection tube assembly. Finally, insert the rear plunger.

**APPLICATION AND EQUIPMENT:**



Where applicable, install the full cartridge of **STRUCTURAL ADHESIVE** into the injection gun, reference:3667.

Alternatively, for spreader application as an adhesive, dispense directly from the cartridge without the aid of the front nozzle or injection tube.

*Mixing knife Ref:3642. 400cc injection gun Ref:3667. Available from Rotafix.*

**CURE SCHEDULE:** \*\*\* According to CEN Standard N20

Workability:	Gel Point	***Peak Exotherm	
		uninsulated	Insulated
12 hrs at +10°C	3 Days at + 10°C	15°C	20°C
6 hrs at + 20°C	2 Days at + 20°C	30°C	35°C
6 hrs at + 30°C	1 Day at + 30°C	40°C	80°C

**MATERIAL USAGE / COVERAGE:**

**Depends on specific application.** As a guide, 400cc of mixed material would represent a filled crack size of 10mm x 10mm x 4 linear metres or 0.4m<sup>2</sup> area @ 1mm thick.

**FULL CURE PROPERTIES:  
(+5 Days @ 20DegC)**

Compressive Strength	Tensile Strength	Tensile Modulus	Flexural Strength	****Bond Strength	CTE (-60 +40°C)
N/mm <sup>2</sup>	N/mm <sup>2</sup>	GPa	N/mm <sup>2</sup>	N/mm <sup>2</sup>	Deg C <sup>-1</sup>
68	38	2.4	70	~6-10	9.2 <sup>-5</sup>

\*\*\*\* Bond strength is dependant on quality of the prepared surface and adherend type

**CLEANING OF TOOLS:**

Uncured **STRUCTURAL ADHESIVE** may be readily removed from tools and equipment with disposable tissue. Rotafix do not recommend the use on site of solvent cleaners. Mechanical methods are required to remove cured material.

**The site conditions and equipment required when using individual Rotafix products are specific for each project. Only advice given by Rotafix in writing will be considered as part of our contractual liability.**

Epoxy resins and their associated curing agents can cause irritation to some people. Please take the necessary precautions indicated in the COSHH details available from our offices.  
Please read our Users Safety Guide on the Handling of Resin and Polymer products.

The information in this document is based on practical tests, but given without guarantee insomuch as methods of use by others is beyond our control. Due to continuing development and improvements, it may be necessary to change without notice the material specification. All goods are sold subject to our Standard Conditions of Sale.



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