



TECHNICAL DATA BULLETIN

THIXO

TotalBoat Thixo is a thixotropic, two-component, room temperature curing epoxy adhesive for bonding, sealing and filling applications. It is packaged in two-component cartridges and can easily be dispensed through the provided static mixing nozzle(s). Thixo cures to a hard, translucent surface that can be drilled, painted or sanded.

HANDLING PROPERTIES

	<u>VALUE</u>	<u>TEST METHOD</u>
Resin Color	Buff	Visual
Hardener Color	Amber	Visual
Resin Density at 77°F, lbs/gal	9.6	ASTM D1475
Hardener Density at 77°F, lbs/gal	8.8	ASTM D1475
Mixed Viscosity at 77°F, cP	Thixotropic	ASTM D2196
Thixotropic Index, 1/10 RPM	7.5	
Mix Ratio By Weight	100A : 46B	Calculated
Mix Ratio By Volume	2A : 1B	Calculated
Gel Time at 77°F, 150g mass, min.	30-35	ASTM D2471
Sag Resistance, inches	1-2	Vertical Surface
Minimum Recommended Temp., °F	55	

PHYSICAL PROPERTIES

	<u>VALUE</u>	<u>TEST METHOD</u>
Color	Buff	Visual
Tensile Strength, psi	6,000	ASTM D638
Tensile Modulus, psi	325,000	ASTM D638
Tensile Elongation, %	8.5	ASTM D638
HDT, Post Cured, °F	122	ASTM D648
Compressive Strength, psi	9,000	ASTM D695
Flexural Strength, psi	10,500	ASTM D790
Flexural Modulus, psi	307,000	ASTM D790
Tensile Adhesion, Wood, psi	1,420	ASTM D4541
Tensile Adhesion, Aluminum, psi	1,840	ASTM D4541
Tensile Adhesion, G-10 Laminate, psi	2,090	ASTM D4541
Hardness, Shore D	80	ASTM D2240





INSTRUCTIONS FOR USE:

For best results use this product at or above 55°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 50 minutes at 77°F. 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 AND HANDLING:

Remove retaining nut and nose plug from the top of the cartridge. Insert the cartridge into a caulk gun. For best results use a caulk gun with an 8 to 1 thrust ratio or higher. Dispense a small amount of material from the cartridge before attaching the static mixing nozzle to ensure that the two components (Part A and Part B) are flowing from both sides of the cartridge nozzle. Attach the static mixing nozzle to the cartridge and if necessary, reinstall the retaining nut. Tighten firmly. Trim the tip of the static mixing nozzle to deliver the desired size bead. Material should flow from the static mixing nozzle in one uniform color when dispensed. The adhesive may also be dispensed without a static mixing nozzle, but must be dispensed into a cup and thoroughly mixed 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 to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Material 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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