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	Epoxy Adhesives - Standard Setting		High Strength



Formulating The Future®

EST. 1989



FIXRITE® STANDARD

FIXRITE® is a two component, high bond strength epoxy adhesive specially developed to meet the increasing demand for high bond strength adhesives. An outstanding solvent free epoxy resin based FIXRITE® adhesive, bonds a wide variety of materials including metal, wood, glass, ceramic, cement, concrete, earthen-ware, granite, fiberglass, hard plastics, hard rubber and hard leather to themselves and to other rigid surfaces. It therefore has many uses in **households, engineering applications and industries**, such as domestic appliances, electrical/electronic applications (FIXRITE® is electrically non conductive-hence useful in the repair of plugs, connections, sealing of circuits etc.) civil engineering applications, (fixing of tiles, bonding of steel to concrete, sealing cracks in pipelines, water tanks, swimming pools, bathrooms, roofs, waterproofing in between tiles etc.) ship building industry, aircraft industry etc. FIXRITE® is recommended for archaeological conservation work such as repairs to ancient statues etc. FIXRITE® is mouldable to any shape and hence has many uses in repair work. i.e. for remaking or replacement of missing parts or pieces, etc. and used in mould making, model making etc. FIXRITE® could be mixed with pigments when coloured adhesive is required

 Properties			
	Resin	Hardener	Mixture
Appearance	Thick Viscous Paste	Thick Viscous Liquid	Paste
Colour	Slightly Whitish	Slightly Amber Clear	Slightly Amber
Density	1.1 Kg/Lt	0.92 Kg/Lt	1.01 Kg/Lt
Solid Content	100%	100%	100%
Viscosity - (mpas at 40°C)	9000 -10000	8000 -10000	Paste/Solid after Curing
Viscosity - (mpas at 30°C)	10000 -12000	9000 -11000	Paste/Solid after Curing
Mixing Ratio	One part of Resin to one part of Hardener by volume.		
Pot Life			Approx. 60 mins at 30°C (using 50 gms quantity)
Curing Time			70% - 80% Bond strength in 10 hrs. at 30°C 100% (full) Bond strength in 48 hrs. at 30°C
Curing Temperature			Over 5°C





General Characteristics

FIXRITE® Epoxy Adhesive

- Permanently bonds wide variety of materials to themselves and to other rigid surfaces.
- Permanently seals cracks. Once the crack is sealed FIXRITE® acts as a waterproof airtight seal.
- Highly insulative and non conductive.
- Non toxic when fully cured.
- Mouldable to any shape.
- No solvents in the formulation and no shrinkage when curing.
- Cures at room temperature or at elevated temperature. At elevated temperature the curing time is considerably shortened
- Can be used indoors and outdoors.
- Stable at high temperature conditions.
- Extremely durable bond after curing.



Bond Characteristics

Chemical Resistance

- Excellent water and humidity resistance.
- Good petrol, kerosene, engine oil or diesel oil resistance.
- Resistant to most solvents.
- Good alkali or mild acid resistance.
- Resistant to wide range of chemicals including soaps, detergents etc.

Temperature Resistance

- The bond will perform excellently, up to a temperature of 100°C, under different climatic conditions, and under temperature fluctuations. The degree of performance is dependent on the tension or stress applied to the bond.

Pressure Resistance

- The bond will perform well under high pressure conditions and pressure variations.



Directions

Surface Preparation

- Surfaces to be bonded should be clean, dry and free from grease, oil, loose material and all other contaminants. Metal or smooth, glossy surfaces should be preferably abraded. do not touch the surfaces after cleaning.

Application	• FIXRITE® is a two component epoxy adhesive. Mix thoroughly equal volumes of FIXRITE® Resin and Hardener (If not mixed properly the adhesive will not perform well or will not harden at all.) Mixing can be carried out by using a spatula or similar tool. For large quantities use a suitable mixing device. Apply the mixed adhesive to both surfaces, join together and hold firmly with clamp, tape, string, weights etc. for at-least 5 hours. Leave for at-least 10 hours for 70-80% bond strength. Gains full bond strength in 48 hours. Warming the joint shortens the above setting times.
 Other Information	
Coverage	Approximately 4sqm (40 sqft.) per litre of mixed adhesive at 0.25mm. thickness.
Cleaner	Use Petrokem Epoxy Thinner for removal of excess uncured adhesive and for cleaning of equipment etc.
Packaging	Available in 2 kg pack (1 kg of Resin and 1 kg of Hardener) / 1 kg pack (500gms of Resin and 500 gms of Hardener) / 2x20 ml tubes and 2x5.5 ml tubes in a consumer pack.
Shelf Life	Minimum 18 month from date of manufacture when stored in cool, dry environment.



Health & Safety Precautions

FIXRITE® Resin and Hardener are chemicals and care should be taken when handling. For details please read Petrokem epoxy safety and handling information sheet. A copy of this manual will be supplied on request.



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