

G/flex® R650 resin is a toughened, versatile, liquid epoxy, formulated for use with G/flex H650 hardener, which will cure at room temperature for permanent waterproof bonding of fibreglass, ceramics, metals, plastics, damp and difficult-to-bond woods. With a modulus of elasticity of 1075 MPa, it is a bit more flexible than standard epoxies and polyester, but much stiffer than adhesive sealants.

G/flex has the ability to make structural bonds that can absorb the stress of expansion, contraction, shock and vibration, and it is ideal for bonding dissimilar materials.

It can be modified with WEST SYSTEM fillers and additives, and can also be used to wet-out fibreglass reinforcements.

MIX RATIO

1 part hardener to 1 part hardener by volume

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.

UNCURED PROPERTIES		
	R650	H650
Physical State	Clear liquid	Clear pale amber liquid
Viscosity mPas @ 25°C	8000	17000
Specific Gravity g/ml @ 25°C	1.15	1.04

CURE CHARACTERISTICS	
	H650
Pot life -100g @ 25°C (in air)	40 minutes
Thin laminate cure time @ 25°C	12 hours
Minimum recommended temperature	10°C
Mix viscosity mPas @ 25°C	11200
Shore D Hardness - 1 day	75
HDT after 24 hours @ 25°C	41°C
2 weeks @ 25°C	46°C
+16 hours @ 40°C	55°C
+16 hours @ 50°C	65°C

PACK SIZES				
Order Code		Order Code		
Resin		Hardener		PACK
RA650	125 ml	HA650	125 ml	250 ml
RB650	500 ml	HB650	500 ml	1 L

STORAGE

G/flex® R650 resin and hardener will keep for 2 years, if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

HEALTH AND SAFETY

G/flex® R650 resin and hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

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NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 12/10/2010



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