

Technical Data Sheet

GENERAL DESCRIPTION

Fast Cure Thixotropic Epoxy Adhesive

GSP 1354 is a two-part epoxy adhesive that cures at room temperature and forms a thixotropic bead. The material becomes hard in 4 minutes, making it ideal for projects that need a fast gel time. The versatility of **GSP 1354** makes it useful in a multitude of applications on a variety of substrates.

Features are:

- Convenient mix ratio (1:1 parts by volume)
- Contains no solvents. 100% reactive
- 4 Minute gel time
- Good Adhesion to a variety of substrates

COMPONENT PROPERTIES

Property	GSP 1354 Part A	GSP 1354 Part B
Shelf Life	6 months	6 months
Density (lb/gal)	9.93	9.20
Viscosity	~320,000 Spindle RV-7 @ 10 rpm	~14,000 Spindle LV-4 @ 20 rpm
Color	Translucent White	Lt Clear Yellow

HANDLING PROPERTIES

Property	GSP 1354
Mix Ratio by Weight	100A :93B
Mix Ratio by Volume	1A : 1B
Pot Life	1 min
Gel Time	3-4min
Cure Time	10-15 min at room temp.

PHYSICAL PROPERTIES

Property	GSP 1354
Hardness	75 Shore D
Color	Translucent Lt. Yellow

INSTRUCTIONS FOR USE

The recommended method of application for this product is with prepackaged, side-by-side ratio tubes using a dispenser and a static mix nozzle. To ensure an accurate mix ratio when dispensing material through a static mixer, discard the first material extruded from the mixer. Product can now be applied directly to the bonding surface. Static mixers and dispensers are available from GS Polymers. Contact the sales department for further information.

TO MIX BY HAND: Proportion out components according to parts by weight or volume ratio into a non-reactive container (polyethylene, polypropylene, or metal de-rimmed can). Container should be about five times larger than the volume of the mixed material. Mix components very thoroughly, preferably with a metal spatula, scraping the sides and bottom of container to incorporate all material.

Note: Since this material gels in 3-4 minutes, de-gassing (de-airing) will not be practical. Mix thoroughly for no more than 30-40 seconds as this material gels very quickly. Do not mix up large masses (less than 100 grams mixed materials) as this material will exotherm.

Material should be used immediately.

Note: During application, do not scrape sides or bottom of the container used for mixing. Residual amounts of poorly mixed material may be incorporated. Such material may fail to cure completely, and may not achieve full physical properties.

CURING INSTRUCTIONS

Mix Ratio by Volume:

Mix 1 part of **GSP 1354A** to 1 part of **GSP 1354B**.

Pot Life: Do not mix more than can be applied in less than 1 minute. Gel time will vary depending on the mass mixed and the ambient temperature.

READ AND UNDERSTAND MATERIAL SAFETY DATA SHEET (MSDS) PRIOR TO USING THIS PRODUCT.

Notice to User:

The following is made in lieu of all warranties, expressed or implied. Seller's and manufacturer's only obligation shall be to replace such quantity of product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risks and liability whatsoever in connection therewith. The foregoing may not be altered except by an agreement signed by officers/owners of G.S. Polymers, Inc.

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