

## Technical Data Sheet

### GENERAL DESCRIPTION

#### Semi-Thixotropic Epoxy Adhesive Chemical, Temperature, and Adhesive Performance

**GSP 1711** is a two-part epoxy adhesive system. When applied, the semi-thixotropic material forms a slow-flowing, black bead. It provides 15-20 minutes of workable time before it gels. When cured, it has excellent chemical & heat resistance. **GSP 1711** continues to maintain excellent properties to 250-300 F° F. **GSP 1711** provides excellent adhesion to many substrates, including metals and cement materials.

Features are:

- Convenient mix ratio (4:1 parts by volume)
- Contains no solvents. 100% reactive
- 20 minute working time
- Excellent adhesion to metal and stainless steel
- Excellent chemical & heat resistance
- Heat resistance to 250-300 F° F
- Cures in 20 minutes at 250° F

### COMPONENT PROPERTIES

Property	1711A	1711B
Shelf Life	6 months	6 months
Density (lb/gal)	12.23	11.7
Viscosity (cps) @80F Spindle RV-6 @ 20 rpm	42,250	3200
Color	Black	Tan

### HANDLING PROPERTIES

Property	GSP 1711
Mix Ratio by Weight	100A :24B
Mix Ratio by Volume	4A : 1B
Pot Life	10-15 min
Mixed Viscosity (cps) @80F Spindle RV-6 @ 20 rpm	23,900
Gel Time, 150 g mass @ 80F	20 -30 min
Cure Time	2-3 hours at room temp. 20 min at 250° F

## CURED PROPERTIES

Property	GSP 1711
Durometer, Shore D	90 +/- 5
Color	Black

## 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 about 20-30 minutes, mix time and de-airing should be done within 5-10 minutes.

Remove the air entrapped during mixing by placing the container of mixed material into a vacuum chamber. Under vacuum, the level of mixed material will rise and then drop with strong bubble breaking action. Do not allow the contents to rise over the top of the container. Allow the material to de-gas (de-air) until the liquid level drops and bubbling is minimal. Release vacuum. If working time allows, transfer material to a clean container without scraping sides or bottom before applying. If working time does not allow transfer, 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:** 4 parts by volume GSP 1711 Part A to 1 part by volume GSP 1711 Part B.

**Pot Life:** Do not mix more than can be applied in 15 minutes. Gel time is about 20-30 minutes but 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.

Prepared: 6/12/06 r2

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