GS POLYMERS
Polyurethane & Epoxy Products

Product Data Sheet

GSP 1339-1

EPOXY ADHESIVE

Low viscosity, chemical and thermal resistance

GENERAL DESCRIPTION

GSP 1339-1 is a low viscosity, two-part, room temperature cure, epoxy adhesive system designed to accommodate higher temperature applications, while offering excellent chemical resistance and good general adhesion to a wide range of substrates. For purposes of viscosity thinning, small quantities of acetone may be added to the mixed product (acetone is a HAPS exempt solvent). Packaging options vary, including convenient 4:1 ratio dual syringes.

COMPONENT PROPERTIES

PROPERTY	GSP 1339-1A	GSP 1339-1B
Shelf Life	6 months	6 months
Color	Clear	Translucent Yellow
Viscosity (cps)	5400	300
Density (lb/gal)	9.7	8.2

HANDLING PROPERTIES

PROPERTY	GSP 1339-1
Mix Ratio by Volume	100 A : 25 B
Mix Ratio by Weight	100 A : 20.5 B
Mixed Density (lb/gal)	9.45
Mixed Viscosity (cps)	1700 cps

PHYSICAL PROPERTIES

PROPERTY	GSP 1339-1
Color	Translucent Yellow
Hardness	80 – 85 Shore D
Pot Life, 100 g at room temperature	1 hour
Pot Life, thin film at room temperature	24 hours

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INSTRUCTIONS FOR USE

DOUBLE-BARREL CARTRIDGE: The recommended method of application for this product is with prepackaged, side-by-side ratio cartridge using a dual-piston 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.

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 than 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 1339-1 Part A** to 1 part by volume **GSP 1339-1 Part B.**

Mix Ratio by Weight: 100 parts by weight **GSP 1339-1 Part A** to 20.5 parts by weight **GSP 1339-1 Part B.**

Pot Life: Do not mix more than can be applied with pot life. Pot life 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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