

GSP 1326-3LV

EPOXY ADHESIVE

Excellent (Adhesion Profile, Chemical Resistance and Heat Resistance), Semi-Thixotropic, Convenient Mix Ratio

GENERAL DESCRIPTION

GSP 1326-3LV is a two-part epoxy adhesive. When applied, the semi-thixotropic material forms a slow-flowing, black bead. **GSP 1326-3LV** provides 10-20 minutes of workable time (pot life). Once cured, **GSP 1326-3LV** has excellent chemical and heat resistance. **GSP 1326-3LV** provides excellent adhesion to a wide variety of substrates, including metals and cement materials.

COMPONENT PROPERTIES*

PROPERTY	GSP 1326-3LV PART A	GSP 1326-3LV PART B
Shelf Life (from D.O.M.)	6 mos.	6 mos.
Density (lbs./gal.)	12.23	11.70
Viscosity (cps)	100000	6500
Color	Black	Tan

HANDLING PROPERTIES*

PROPERTY	GSP 1326-3LV
Mix Ratio by Weight, A : B	100A:24B
Mix Ratio by Volume, A : B	4A:1B
Mixed Viscosity (cps)	Semi-Thixotropic
Pot Life (minutes)	10:00 - 20:00
Gel Time (minutes)	25:00 - 50:00
Room Temp Cure Time and Conditions	90% within 3 hours at RT cure
Heat Cure Temp and Conditions	20 minutes at 250°F

NOTICE TO USER:

The following is made in lieu of all warranties, expressed or implied. It is the customer's responsibility to determine fitness of use for all GSP products by directly testing the materials first-hand for each application. Please fully evaluate the materials so as to convince yourself of appropriate and adequate performance. Before using, customer shall determine the suitability of the product for the intended use, and customer assumes all risks and liability whatsoever in connection therewith. The only obligation of the seller or manufacturer 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. The foregoing may not be altered except by an agreement signed by officers/owners of G.S. Polymers, Inc.

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CURED PHYSICAL PROPERTIES*, TYPICAL, 25° C (77° F)

PROPERTY	GSP 1326-3LV
Color	Black
Cured Hardness/Durometer	89D
Service Temperature (Operating Limits)	< 380°F

* Values not intended for use in specification preparation

INSTRUCTIONS FOR USE**SIDE-BY-SIDE (SBS) CARTRIDGE:**

The recommended method of application for this product is with prepackaged, side-by-side (SBS) ratio tubes using a dispenser and a static mix nozzle. To ensure an accurate mix ratio when dispensing material from a SBS tube through a static mixer nozzle, follow the steps below:

1. Remove the nozzle tip/cap. Do not discard tip/cap unless all the material in SBS tube is to be used.
2. Extrude enough material until there is an even flow of material from both openings. Discard this material.
3. Attach mix static nozzle. Extrude about ~2-3 cm (~1 inch) of material. Discard this initially extruded material. Cartridge pistons will now be precisely aligned and material on ratio.
4. Apply material from the cartridge directly to the work area.
5. To preserve leftover material in the SBS tube after application, remove and discard the static mix nozzle.
6. Clean the tip/cap thoroughly to prevent cross contamination of the tip openings.
7. Reinsert or reattach tip/cap back onto the SBS tube.

TO MIX BY HAND:

Mix Ratio: Parts by Volume (pbv):..... **100 parts** GSP 1326-3LV Part A to **25 parts** GSP 1326-3LV Part B

Mix Ratio: Parts by Weight (pbw):..... **100 parts** GSP 1326-3LV Part A to **24 parts** GSP 1326-3LV Part B

Pot-Life: Do not mix more than can be applied within the Pot Life of the system. Pot Life is approximate and may vary depending on the mass mixed and the ambient temperature.

Mixing: Proportion out components according to the parts by weight (pbw) or parts by volume (pbv) ratio into a non-reactive container (e.g. polyethylene, polypropylene, or metal de-rimmed can). Select a container about five times larger than the volume of material mixed to allow for expansion while de-airing under vacuum. Mix components very thoroughly, preferably with a metal spatula, scraping the sides and bottom of container to incorporate all material.

De-Air: Remove air bubbles entrapped while mixing by placing mixed material in a vacuum chamber. (Vacuum should be able to achieve 29 inHg.) Liquid level should rise and then fall with some bubbling. Break vacuum partially and reapply as necessary to avoid overflow. De-air material until bubbling is minimal. Do not leave material under vacuum longer than one minute as catalysts may be stripped from the system and effect curing.

Transfer and Application: If working time allows, pour mixed material into a clean container without further scraping the sides and bottom. (In case unmixed material is still present.) Discard the residual material left behind in the mix container. If working time does not allow transfer to a clean container, dispense material taking care to avoid further scraping material from the sides and bottom of the mix container. Apply mixed material to the work area immediately.

CURING PROCEDURES:

Most physical properties develop to 90% within the first 3 hours of cure. Full properties continue to develop over a period of 5 to 7 days at ambient temperature. Cure may be accelerated with the application of heat. To heat cure the system, allow material to gel at room temperature then apply heat 250F for 20 minutes.

STORAGE:

Store both Part A and Part B components between 65°F/18°C – 86°F/30°C in a clean, dry area. If stored below 68°F/20°C, allow the material to reach room temperature in the closed/sealed container prior to use. After using materials, blanket remaining components with Nitrogen gas and securely reseal the containers. This will reduce the likelihood of contamination from atmospheric moisture and extend shelf life.

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