

FLEXCO EPOXY MARINE LAMINATING SYSTEM 4:1 RATIO

Description An ambient curing marine, laminating epoxy system for wet lay-up techniques in wooden boat fibre-glassing. Two distinct hardeners, each combined with the one standard epoxy resin provide differing open time and cure periods for most working situations.

Benefits **Very low viscosity, high functionality, for superior wet out on timber, glass and exotic cloths**

- Low diluent levels in the resin ensure superior cured strengths
- Can be combined with epoxy Glue Powder to form high strength epoxy glue
- Can be combined with epoxy Fairing Powder to form an epoxy fairing compound

Use For

- Timber boat building. Also steel, aluminium and GRP
- Osmosis repair and barrier coating below the waterline
- As a construction epoxy glue
- Marine and construction coving (filleting) hole and gap filling

Note: For a clear bright finish on timber, Flexco Epoxy Varnish 2:1 System
The Fast (winter) hardener can be used during winter months, or when the ambient temperature is below 15°C Not recommended for use below 8°C.
The Slow (summer) hardener is for use when the ambient temperature is above 15°C. Ideally suited for use between 15°C – 25°C

Mixing Ratio	(100gm mass)	Resin	Hardener	Gel Time
	Fast (winter) system	100	: 25 by volume	25 minutes @ 15°C
	Slow (summer) system	100	: 25 by volume	20 minutes @ 20°C

Do not alter the ratios as both systems are optimised for this ratio. A weakening of all physical attributes will occur if altered.

Coverage Will cover approximately two and a quarter square metres when used with 6oz (200gm) glass cloth.
Will cover approximately six to seven square metres when applied without glass cloth.
Note! Never thin with epoxy solvent as this will remain in the cured film and weaken the coating.

Preparation

Timber: Plane and sand surface to a fair condition. Degrease surface if necessary; this is important with oily timbers such as teak. Cross hatch sand with 100 grit paper.

Steel: Degrease surface if necessary. Abrasive blast clean to give a sharp profile. Vacuum away all blasting dust. Alternatively abraid with medium sandpaper. Alternatively, degrease and power wire brush or metal disc clean to bright steel or as best as possible.

Aluminium: Degrease and abrasive blast clean with sand to give a sharp profile. Alternatively use a proprietary aluminium etch cleaner as per the instructions on the bottle.

GRP: Degrease and cross hatch sand with 60-100 grit paper. Polyester must be fully cured. Take special care as surface wax may be present, and must be removed.

Customwood, Particleboard, Bench tops etc) Sand as per timber.

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Mixing & Application

Measure out the correct quantities by volume into a disposable container and mix thoroughly paying attention to combining the material on the sides and bottom. Apply immediately to the clean, prepared substrate. The mixed system will start an irreversible exothermic (heat producing) reaction. This will become noticeable and uncontrollable within the container for product not used within the stated time. The thin film cure on the work piece, not being in mass, is dependant on the ambient temperature and could take 6 – 24 hours. Apply with clean tools. If gluing, clamp lightly together. DO NOT over clamp as glue starvation may result. Discard not required excess as it will polymerise. Coverage is one square metre per litre at one millimetre film thickness. This laminating system, being inert once completely cured, will accept all topcoat systems. Degrease and sand if necessary. Check top coat product instructions for suitability.

Compatibility

Will adhere to all timber types. Oily timbers such as teak should be degreased prior to gluing. Being inert once completely cured, all marine resin & paint systems will adhere. It is recommended the surface is sanded prior to coating.

Pack Sizes

1lt resin + 250ml hardener	=	1.25 litre pack
4lt resin + 1lt hardener	=	5 litre pack
16lt resin + 4lt hardener	=	20 litre pack
20lt resin + 5lt hardener	=	25 litre pack

Clean Up

Use Epoxy Solvent and then soap and water for clean up of uncured resin on brushes and rollers. Use disposable containers and a spatula.

Storage

Will keep in excess of twelve months if stored in tightly sealed original containers. Store in a cool place.

Health and Safety

Do not store near boilers or other sources of heat.
Do not store in direct sunlight.
Epoxy resins and amine resin hardener constitute the reactive components of this system.
Use disposable plastic gloves to avoid skin contamination.
If resin comes into contact with skin, wash uncured resin off with soap and water.
Epoxy cleaning solvent should never be used to wash hands.
Wear safety glasses to avoid eye contamination.
Can cause topical dermatitis if in prolonged contact with skin.

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