

SEASHIELD™ FX-70TNG EPOXY ADHESIVE

Tongue and Groove Epoxy Adhesive

Description

SeaShield FX-70TNG Epoxy Adhesive is a two-component, 100% solids, thixotropic, non-sag adhesive formulated for vertical and horizontal applications. It is used to bond the tongue and groove of fiberglass jackets and other construction materials.

Uses

- To bond the tongue and groove of the SeaShield Fiber-Form jackets
- To bond common construction materials
- To bond dissimilar materials

Features

- Excellent adhesion to fiberglass
- Bonds well to most construction materials
- Thixotropic gel with no sag
- Suitable for saltwater marine applications
- Applied with a dual-cartridge dispensing tool

Surface Prep

Fiberglass jacket surfaces must be sound, clean and free of all contaminants that could impair product adhesion or performance.

Mixing

For best mixing & application, components shall be at a min. 70°F (21°C) prior to use. A dual pneumatic or manual cartridge dispensing tool may be used to inject the SeaShield FX-70TNG. Hold cartridge upright, unscrew the retaining nut and remove the plugs. Attached the Denso mixing nozzle to the top of the cartridge. Insert the cartridge into the.

IMPORTANT: The cartridge must be equalized prior to use. Failure to follow these instructions can result in product not properly curing. To ensure proper mixing ratio, squeeze the trigger on the cartridge dispensing tool until the mixing nozzle is completely full. Once full, dispense three full trigger pulls (approximately ½ fl. oz./30 ml) or until the product dispenses as a uniform color and ensure all air bubbles are out of the cartridge before beginning the installation process. Repeat if necessary.

Application

Use a dual cartridge dispensing tool, apply a uniform bead of SeaShield FX-70TNG into the groove section of the SeaShield Fiber-Form jacket. Apply the SeaShield FX-70TNG at an approximate rate of 20 LF per 600 ml (20 oz.) cartridge. Close the



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jacket by inserting the tongue and groove into the groove of the jacket. Install self-drilling, self-tapping stainless steel screws to secure the tongue and groove joint along the center of the joint every 6" on center.

Storage

Store in a dry, well-ventilated area between 40°F and 95°F (4°C and 35°C) in original, unused cartridges. Shelf life is at least 24 months under these conditions. It is recommended that all components be stored between 68°F and 86°F (20°C and 30°C) for 24 hours prior to use for optimum pumping and productivity.

Cleaning

Clean tools, spills and drips from surfaces with Simple Green, MEK, acetone etc. Cured material can only be removed by mechanical means.

HSE

Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See the safety data sheet (SDS) for further information.

Packaging

Kit Size	Part A	Part B
600 ml (20 oz.) dual cartridge	1 qty - 300 ml (10 oz.) cartridge	1 qty - 300 ml (10 oz.) cartridge
Note - Packaged 16 cartridges per case.		

TECHNICAL DATA SHEET

Tech Data

Properties	Imperial	Metric
Solids Content	100%	100%
Base Component – (Unmixed) @ 77°F (25°C)		
Viscosity	1,000,000 cps	1,000,000 cps
Color	Opaque/Clear	Opaque/Clear
Hardener – (Unmixed) @ 77°F (25°C)		
Viscosity	1,000,000 cps	1,000,000 cps
Color	Beige	Beige
Mixed Material @ 77°F (25°C)		
Viscosity	1,000,000 cps	1,000,000 cps
Color	Beige	Beige
Mixing Ratio (A/B) by Volume	1 parts Base:1 part Hardener	1 parts Base:1 part Hardener
Consistency (ASTM C881)	Non-sag gel	Non-sag gel
Gel Time	15 to 18 minutes	15 to 18 minutes
Tensile Strength (ASTM D63) @ 60°F (16°C)	5,500 psi	37.9 MPa
Elongation at Break (ASTM D63 @ 7days)	1.3%	1.3%
Product Yield	36.09 cubic in./US gal	0.591 cubic dm/L
Adhesion to Fiber-Form (D4541 @ 24 hours) 72°F (22°C)	360 psi	2.48 MPa
Approximate Joint Application Rate	20 LF per 20 oz. cartridge	6.09M per 600 ml cartridge
Application Temperature	40°F to 125°F	5°C to 52°C
Service Temperature	-40°F to 150°F	-40°C to 65°C



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