



**PROBOND
MARINE EPOXY ADHESIVE
FOR
WOOD – COMPOSITES - METAL
Unpigmented**

PRODUCT BULLETIN



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DESCRIPTION

ProBond Marine Epoxy Adhesive is a two-component unpigmented trowelable paste adhesive system. ProBond's convenient one to one mix ratio by volume along with a choice of two hardener options gives the end user an easy to use, strong, water-resistant adhesive. ProBond is uniquely formulated to provide superior adhesion when working with a variety of materials including wood, fiberglass, aluminum, vinyl, ceramics and metals. This versatile epoxy adhesive makes ProBond the clear choice for your adhesive needs.

BENEFITS AND USES

- Non-sagging trowelable system
- Convenient 1:1 mix ratio
- Withstands freeze/thaw cycles
- Pigmentable
- Work life selection of 25 and 80 minutes
- Excellent for bonding marine hardware to decks
- Can be used in wet/dry conditions
- Will bond to all types of wood including Teak
- Ideal for bonding dissimilar products that experience harsh environments

HANDLING CHARACTERISTICS @ 25°C/77°F

	<u>ProBond Resin w/ ProBond Fast Hardener</u>	<u>ProBond Resin w/ ProBond Slow Hardener</u>
Mix Ratio (parts by volume)	1R:1H	1R:1H
(parts by weight)	100R/102H	100R/94H
Resin Density	10 lbs/gal	10 lbs/gal
Hardener Density	10.2 lbs/gal	9.4 lbs/gal
Mixed Density	10.1 lbs/gal	9.7 lbs/gal
Specific Gravity	1.21 g/cc	1.16 g/cc
Mixed Viscosity	Thixotropic Paste	Thixotropic Paste
Work Life @ 77°F (8oz mass)	25 minutes	80 minutes
Resin Color/Hardener Color	Neutral (can be pigmented)	Same
Shelf Life Resin & Hardener (in original unopened containers)	2 years	2 years

TYPICAL PHYSICAL PROPERTIES @ 25°C/77°F

Tensile Strength	1,820 psi
Tensile Elongation	17%
Flexural Strength	2,371 psi
Flexural Modulus	70,000 psi
Compressive Strength	11,568 psi
IZOD Impact Strength	9.05 (in-lbs/in)
PATTI Tensile Adhesion (aluminum sanded to white w/100 grit)	2,645 psi

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APPLICATION INSTRUCTIONS

SURFACE PREP: Thoroughly clean composite, wood or metal surface to remove contaminants before sanding. Composite and wood surfaces should be sanded with 36 to 40 grit paper to promote adhesion. Steel: sandblast or grind to a clean metal leaving a 3-4 mil profile, washed with a metal prep and primed with a commercially approved epoxy primer per manufacturer instructions. Aluminum: sandblast or grind with a 24 grit disc pad to a 3-4 mil profile, follow with a vinyl wash primer and mil/spec corrosion inhibiting primer, followed by an epoxy primer per manufacturer instructions.

MIXING INSTRUCTIONS: Mix by volume 1 part resin to 1 part hardener. Thoroughly mix components together, scraping the sides of container to achieve a uniform mix. Thorough mixing is needed to ensure uniform cure and strong bond. Do not add any solvent to thin the mixture. Not recommended for use at temperatures below 10°C/50°F.

ProBond Series Tech/New 8/7/09
Supercedes E10-001R/H, E10-002H 5/14/09

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