



# EPOXIES

*“The Professional’s Choice”*



## MAXIMUM BOND STRENGTH

**FE-180A** Bonding Epoxy is a flexible epoxy, formulated to achieve *maximum bond strength* between teak and most common structural marine materials, such as wood, fiberglass, aluminum and steel. Its primary purpose is to achieve a high strength bond to less-than-perfectly-prepared substrates.

- Maximum Bond Strength
- Excellent wet-out of bonding surfaces
- Best for gluing teak and teak deck panels
- Flexible strength resists shock and twists
- High viscosity holds profile to fill gaps
- 1:1 mix ratio for easy mixing
- Non-blushing
- High density fillers
- Tinted **brown** to compliment most wood species



## UNIVERSAL FAIRING & BONDING

**FFE-200** Fairing & Bonding Epoxy is a medium viscosity epoxy fairing/bonding compound blended to yield a light weight, flexible and easily sanded system for use as both a fairing compound for uneven surfaces and for bonding teak to faired surfaces.

- Good bond strength
- Excellent fairing material
- Excellent wet-out of bonding surfaces
- Best for vacuum bagging
- Medium viscosity for ease of spreading and leveling
- Flexible strength resists shock and twist
- Light weight fillers for reduced weight and sandability
- 1:1 mix ratio for easy mixing
- Non-blushing
- Good low temperature cure (minimum 45°F, 7°C)



## GENERAL, ALL-PURPOSE BONDING EPOXY

**AP-100** All Purpose Epoxy is a general purpose, high strength adhesive for general marine bonding applications. Ideal for installing plugs in teak decks or bonding wood or fiberglass composites

- Excellent bond strength
- Excellent wet-out of bonding surfaces
- Translucent color blends well with surrounding surfaces
- 1:1 mix ratio for easy mixing
- Non-blushing

For more information, including more technical data, please visit our products page on our web site at: [www.teakdecking.com](http://www.teakdecking.com)

## **SURFACE PREPARATION:**

All surfaces must be clean, dry, and free of any dirt, grease, wax, etc., before beginning any surface preparation. Regardless of the substrate, it is mandatory that a sample adhesion test be performed to the primed/sealed surface at least 24 hours prior to the final glue-down.

### **STEEL**

- Sandblast or grind to clean white metal per SSPC-SP63 to a 3-4 mil profile
- Wash with Metal Prep
- Follow primer instructions to clean surface
- Apply 2-3 coats of a commercially approved epoxy primer such as Awl-Grip High-Build, Devoe Epoxy Primer, Alexseal Primer or equivalent, adequately filling the blast profile.

### **ALUMINUM**

- Sandblast or grind with 24 grit disc pads to a 3-4 mil profile
- Follow primer instructions to clean surface
- Follow with a vinyl wash primer or Alumaprep
- Follow by a mil/spec zinc or strontium chromate corrosion-inhibiting primer
- Follow with AwlGrip High-Build epoxy, Devoe Epoxy Primer, Alexseal Primer or equivalent

### **FIBERGLASS/GELCOAT**

- Grind with 36-40 grit paper until no shiny surface is present
- Wipe down with acetone

### **WOOD**

- Scuff with 36-40 grit paper
- Do not use polyester resin or wood sealers that contain oils

### **FAIRED SURFACES**

- Seal fairing compound with a high-quality, 100% solids epoxy
- After complete cure, aggressively sand before bonding

## **MIXING INSTRUCTIONS:**

- Stir both A & B components before combining
- Mix by volume: 1 part base resin with 1 part activator
- Mixing **MUST** be thorough to ensure a good cure. Scrape the sides of the container until you have achieved a uniform color with no streaks
- **DO NOT ADD ANY FILLERS OR REDUCER**

<b>FE 180A: PROPERTIES</b>	<b>VALUE</b>	<b>FFE 200: PROPERTIES</b>	<b>VALUE</b>	<b>AP 100: PROPERTIES</b>	<b>VALUE</b>
Gel Time (8-oz Mix)	70 Minutes	Gel Time (8-oz Mix)	55-70 Minutes	Gel Time (8-oz Mix)	40-60 Minutes
Open Time – 3/16"	130-170 Minutes	Open Time – 3/16"	120-140 Minutes	Open Time – 3/16"	60-90 Minutes
Film Set Time – 3/16" @ 77°F	6 Hours	Film Set Time – 3/16" @77°F	4 Hours	Film Set Time – 3/16" @77°F	7-8 Hours
Film Set Time – 3/16" @ 40°F	12 Hours	Film Set Time – 3/16" @ 40°F	10 Hours	Film Set Time – 3/16" @ 40°F	16-20 Hours
Adhesion to Teak	Substrate Failure	Adhesion to Teak	Substrate Failure	Adhesion to Teak	Substrate Failure
Adhesion to Phenolic	Substrate Failure	Adhesion to Fiberglass	Gelcoat Failure	Adhesion to Fiberglass	Gelcoat Failure
Adhesion to Aluminum	>400 psi	Adhesion to Aluminum	>300 psi	Adhesion to Aluminum	>300 psi
Adhesion to Steel	>450 psi	Adhesion to Steel	>350 psi	Adhesion to Steel	>350 psi

As with all epoxies, Teakdecking Systems' epoxies can cause skin and eye irritation with frequent or prolonged exposure. Avoid contact with skin and eyes by the use of gloves, goggles, impervious clothing and barrier creams. Our epoxies will be usable for up to 12 months under proper storage conditions (50-95° F) in a sealed container. Prolonged storage may cause the hardener to darken. After prolonged storage, it is advisable to test a small mix to make sure it is viable. Be sure to pre-mix the individual containers before testing. Freezing may cause crystallization in the resin side. If this occurs, warm to 130-150° F and stir to melt crystals. The resin's properties will be unaffected.