

G/flex® 650 resin is a toughened, versatile, liquid epoxy, formulated for use with G/flex 650 hardener, which will cure at room temperature for permanent waterproof bonding of fibreglass, ceramics, metals, plastics, damp and difficult-to-bond woods. With a modulus of elasticity of 1075 MPa, it is a bit more flexible than standard epoxies and polyester, but much stiffer than adhesive sealants.

G/flex has the ability to make structural bonds that can absorb the stress of expansion, contraction, shock and vibration, and it is ideal for bonding dissimilar materials.

It can be modified with WEST SYSTEM fillers and additives, and can also be used to wet-out fibreglass reinforcements.

### MIX RATIO

1 part hardener to 1 part resin by volume  
1 part hardener to 1.2 part resin by weight

*Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.*

UNCURED PROPERTIES		
	Resin	Hardener
Physical State	Clear liquid	Clear pale amber liquid
Viscosity mPas @ 25°C	8000	17000
Specific Gravity g/ml @ 25°C	1.15	1.04

CURE CHARACTERISTICS	
Pot life -100g @ 25°C (in air)	40 minutes
Thin laminate cure time @ 25°C	12 hours
*Minimum recommended temperature	10°C
Mix viscosity mPas @ 25°C	11200
Shore D Hardness - 1 day	75
Heat Deflection Temperature after 24 hours @ 25°C	53°C
Onset of Tg by DSC	59°C
Ultimate Tg	68°C

\*Wait 24 hours before subjecting to high loads

PACK SIZES				
Order Code		Order Code		
Resin		Hardener		PACK
RA650	125 ml	HA650	125 ml	250 ml
RB650	500 ml	HB650	500 ml	1 L
RC650	4 L	HC650	4 L	8 L

### STORAGE

G/flex® 650 resin and hardener will keep for 2 years, if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

### HEALTH AND SAFETY

G/flex® 650 resin and hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.

- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.

- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.

- If swallowed:

**Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

**Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

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