



DeCara, Inc.
dba

Dynamis

1. PRODUCT NAME

EPOXY ADHESIVE

DYNAPOXY
EPO GEL 2004

GEL SYSTEM

2. MANUFACTURER

Dynamis
415 East Venice Ave.
Venice, Florida 34285

3. PRODUCT DESCRIPTION

BASIC USES: EPO Gel 2004 is a 1:1 by volume, non-shrinking epoxy adhesive gel. This adhesive is easy to mix, does not creep and is translucent upon cure. No primers are required unless surfaces are weak or porous. EPO Gel 2004 may be applied vertically, horizontally or overhead.

The pot life of EPO Gel 2004 in a 100 gram mass is 20 – 25 minutes at 75° F. Lower temperatures retard cure and higher temperatures or larger volumes accelerate cure. EPO Gel 2004 provides almost no surface blush upon cure.

LIMITATIONS: Surfaces to be repaired or bonded to must be free of grease, oil, or other de-bonding compounds, including old paint or other contaminants. Surfaces should be clean and dry and 50° F or higher. Adequate ventilation must be provided.

COLOR: Translucent amber.

APPLICABLE STANDARDS: ASTM-C-881-90, Type I, IV, Grade 3, Class A,B,C,D,E,F.

COVERAGE: 40 sq. ft. per quart
1/4" application 231 sq. in. per quart.

4. TECHNICAL DATA

Mix Ratio, by volume	1:1
Mixed Viscosity	Non-sag gel
Mixed Density	10.7 lbs./gal.
Mixed Density, lbs./cu.in.	.046
Specific Gravity	1.28
Sanding Time	1 – 2 hours
V.O.C.	-0-
Color	Translucent amber
Shelf life (unopened at 77°F)	1 year
Complete Cure	7 days
Tensile Strength	6850
Flexural Strength	11,000 – 12,000
Compressive Strength	14,000 – 16,000
Shore D	80
Alkalie Resistance	Good
Mineral Acid Spillage	Fair
Organic Solvent Spillage	Good
Water (tap)	Good
Water (salt)	Good
Food/Organic Compounds	Good
Beverages	Good

5. INSTALLATION

PREPARATORY WORK: Prior to installation of EPO Gel 2004, surfaces must be structurally sound and free from paint, wax, grease, oil, mold releases and other contaminants. Resin surfaces should be solvent cleaned (Acetone or Lacquer Thinner) prior to sanding. To remove exhudation (blush) from cured epoxy surfaces, wet sand with 80 grit sandpaper and wipe clean and dry with clean rags or paper towels. The wet sanding requirements are for application over fully cured epoxy surfaces. This step may be eliminated if epoxy is still tacky when re-coated with more epoxy layers, or when applying directly to wood, concrete or clean metal surfaces.

METHODS: EPO Gel 2004 may be applied with putty knife, trowel, cove tool or plastic applicators. Porous surfaces should be saturated with LAM resin mixed and allowed to cure prior to application of EPO Gel 2004. EPO Gel 2004 may also be applied with suitable automated mixing and dispensing equipment.

MIXING: EPO Gel 2004 should be mixed one part component "A" to one part component "B" by volume. Thoroughly mix both components **before and after** combining them. Scrape sides and bottoms of containers. Care should be taken not to whip too much air into product when using an electric drill and mixer.

EQUIPMENT CLEAN-UP: Clean tools and equipment immediately with Acetone, M.E.K. or Xylene. Do not allow epoxy to set hard on tools or mixing equipment.

PRECAUTIONS: Avoid prolonged contact with skin and breathing of vapor or spray mist. Use with adequate ventilation. Keep out of reach of children. **Do not allow product to freeze. Store at room temperature.**

6. AVAILABILITY

Manufactured by:
Dynamis.
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941/488-3999
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7. GUARANTEE

The manufacturer warrants that the material meets specifications listed and limits any warranty to the replacement of material only.

The information contained in this specification is based on data obtained by our own research and is considered accurate. However, no warranty is expressed or implied regarding the accuracy of this data or the results to be obtained from the use of this data or product. This information is furnished and the product sold upon the condition that the person receiving it shall make his own test to determine the suitability of the material for his particular purpose.