

Six10® Epoxy Adhesive

General Description

WEST SYSTEM® Six10 Thickened Epoxy Adhesive is a pre-thickened, gap-filling epoxy with a smooth, non-sagging consistency that trowels easily—perfect for filling voids and making fillets. Six10 Epoxy has a viscosity high enough to resist sagging but can still saturate and wet-out a surface without pre coating, thanks in part to a property called *shear thinning*. This property also enables it to wet out light to moderate weight reinforcing fabrics such as fibreglass and carbon fibre.

Six10 Epoxy is packaged in a specially designed, self-metering cartridge. A unique piston inside the cartridge simultaneously dispenses the resin and hardener from separate chambers. The moulded chambers and passageways accurately control the ratio and prevent the resin and hardener from contacting each other until they are outside the cartridge passing through the 600 Static Mixer.

The Six10 Epoxy formulation is a good balance between the elongation and toughness of G/flex® Epoxy and the strength and stiffness of our 105 Resin-based epoxies. It has a long open time which means the epoxy will stay workable for 42 minutes in the static mixer and before clamping is required—very practical for long or complicated assemblies. It is ideal for stitch and glue boat construction, fibreglass laminate repair and general bonding. It bonds to a wide range of materials including wood, metals, composites and masonry. Six10 Epoxy is transparent with a straw yellow tint.

Handling Characteristics

Mix ratio by volume	2 parts resin : 1 part hardener
by weight	2.25 : 1
Mix viscosity (at 25°C) Brookfield.....	Gel
Resin Density.....	1.17 gcm ⁻³
Hardener Density	1.04 gcm ⁻³
Pot life (100g at 25°C)	42 minutes
Working time, thin film*	42 minutes
Cure to a solid, thin film*	5 to 6 hours
Cure to working strength	5 to 7 days
Minimum recommended temperature	10°C

**Epoxy cures faster at higher temperatures and in thicker applications.*

Physical Properties of Cured Epoxy

Specific gravity	1.18
Hardness 1 day (Shore D) BS EN ISO 868	72
14 days (Shore D) BS EN ISO 868	81
Compression yield 1 day BS EN ISO 604	27.70 MPa
Compression yield 14 days BS EN ISO 604	66.80 MPa
Tensile strength BS EN ISO 527-2	44.40 MPa
Tensile elongation BS EN ISO 527-2	7.9%
Tensile modulus BS EN ISO 527-2	2.60 GPa
Flexural strength BS EN ISO 178	78.10 MPa
Flexural modulus BS EN ISO 178	2.40 GPa
Heat deflection temperature ASTM D-648	53°C
Onset of Tg by DSC	53°C
Ultimate Tg by DSC	56°C

Storage/Shelf Life

Store at room temperature (above 10°C). Keep cartridge plug in place when not in use to prevent contamination. With proper storage, resin and hardener should remain usable for the duration of the specified self-life.

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