

# RELFIX ADHESIVE



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SOP for RelFix Adhesive for  
RelWood<sup>™</sup>.

## ABOUT RELFIX

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- RelFix is an Epoxy based adhesive which we recommend for bonding RelWood™ to RelWood™ or RelWood™ to other substrates like plywood, metals, concrete, particle board, wood, Bakelite etc.
- This is a solvent free adhesive specially developed for RelWood™ substrates to provide excellent adhesion, strength and durability via structural bonding with the substrates.
- RelFix improves stiffness and prevents warping due to long term outdoor exposure.
- Shelf Life : 1 year from the date of manufacture.
- Relfix is a 2-component epoxy system for bonding with a Mixing Ratio as given below :

**Component A : Component B =100:65  
(By Weight)**

## SAFETY PRECAUTIONS

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- Avoid direct contact of the product with skin or eyes.
- Follow necessary and recommended industrial hygiene procedures whenever products are being handled.
- Please refer technical and safety datasheets for usage instructions.

## PRECAUTIONS

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- Provide sufficient air exchange and/or exhaust in work rooms.
- Avoid inhalation, ingestion and contact with skin and eyes.
- Wear personal protective equipment (respirators, gloves, glasses, etc).
- Persons with a history of skin sensitization problems or asthma allergies, chronic or recurrent respiratory disease should not be employed in any process in which this mixture is being used.
- Keep away from open flames, hot surfaces and sources of ignition.
- Causes skin irritation. Causes serious eye irritation.
- Toxic to aquatic life with long lasting effects. Dispose of contents/container in accordance with applicable regulations.

## METHODOLOGY

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1. Make sure that the Surface should be clean of Oil, Grease, Dust & any other material which will affect the adhesion of RelFix EP Putty to Substrate.
2. The moisture content of the substrate should not be more than 4%. Moisture content will affect the adhesion properties. The application area should be dried well before application if the moisture content is higher than the recommended level. ***We won't recommend the usage of RelFix on moist surface.***
3. Mix the RelFix in the recommended ratio (Resin: Hardener = 100:65 parts by weight) for about 2-3 minutes. ***(Use the mechanical mixer with low stirring speed for better mixing. Mix till the uniform color is achieved.)***
4. You can use the material for about 30-40 Minutes if the surrounding temperature is around 30°C.

## METHODOLOGY

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5. Apply a thin layer on RelFix over both the surfaces which needs to joint together using Spatula or trowel. Now put the RelFix applied surfaces on each other.
6. The coverage of RelFix is 2 Kg for gluing 2 surfaces of 8ft x 4ft to each other. **(i.e. 650-680 gms RelFix per Sq.m or 60-70 gms /sft).**
7. Provide the appropriate support after placing the surfaces in contact with other.
  - *If the application is horizontal, then put the sufficient quantity of weights on the substrate. You can also use screw or fastener for similar purpose instead of weights.*
  - *If the application is vertical or cladding type, then provide the support using screw or recommended fastener.*

## METHODOLOGY

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8. Once you put the weight or provide the appropriate support to the substrate the excess material will come out, wipe out the excess material with the help of trowel before it gets hard.
9. Let it dry overnight. ***(Though the setting time is 4-6 Hours, we recommend overnight drying for better adhesion.)***



