



**PRODUCT NAME**  
**Rotafix CB10T Structural Adhesive**  
400cc pack (3550)

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**Product Description**

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CB10T is a thixotropic, structural two part adhesive based on a combination of epoxy resins and special micro fillers, designed for the bonding of timber, masonry and concrete.

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**Uses**

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As a structural adhesive : for wood , concrete elements, hard natural stone, bricks, masonry steel, Iron, Aluminium, Holes and void filling, may be used for vertical and overhead situations, filling of cracks and shakes and the installation of anchors in most substrates.

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**Characteristics/Advantages**

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CB10T Adhesive has the following advantages: Easy to mix and apply, excellent adhesion to most construction materials. High strength thixotropic adhesive, non-sag in vertical and overhead applications, Solvent Free , Cures without shrinkage , High initial and ultimate strength.

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**Tests**

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Approval/Standards  
Testing according to EN 15274

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**Product Data**

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**Colours:**

Base part : White paste

Hardener : Yellowish Paste

Care must be taken to ensure complete and thorough mixing as both paste's as they are similar in colour

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**Packaging:**

Supplied in 400cc pre batched packs consisting of 2 x plastic screw cap jars with an empty cartridge set and follower plate also supplied in 3ltr packs (no cartridge sets supplied with the 3ltr pack.

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**Storage conditions:**

Shelf Life is 24 months from date of production if stored properly in original unopened, sealed and undamaged packaging, in dry conditions at temperatures between +5°C and +25°C. Protect from direct sunshine, Keep of cold floors and protect from frost.

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**Chemical Type:**

Thixotropic Epoxy Resin including its Curing agent

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**Density:**

1.06 + 0.01 kg/ per pack (base & hardener mixed) (at +20°C)

Compressive Strength  
(According to ASTM D695)

Strength gain	+ 20°C
3 days	20 – 25 N/mm <sup>2</sup>
7 days	40 – 50 N/mm <sup>2</sup>
11 days	50 – 60 N/mm <sup>2</sup>

### Mechanical/Physical Properties

Property	Units	Test Method	Result Mean
Tensile Strength	N/mm <sup>2</sup>	BS EN ISO 527-2	12.75
Environmental Durability	MPa	BS EN ISO 9142	>21
Environmental Conditions	24hrs at 24 °C & 90% RH 72hrs at 24 °C & 90% RH	24hrs at 40°C & 30%RH 48hrs at 40°C & 30%RH	Timber Species tested on tropical hardwood
Bond Strength on adhesive to tropical hardwood 'Jarrah'	MPa	BS EN 1465	>9
Bond Strength on adhesive to common UK structural timber, CLT, Glulam, Douglas Fir	MPa	BS EN 1465	>6

Elongation at break	%	BS EN ISO 527-2	16.03
Crack Extension	mm	ASTM D3762	13.94
Temperature of Deflection Under Load	°C	BS EN ISO 75-2	<23.0
**Pot life 100 G @ 20°C	Minutes	EN 14022	50
**Cure time 100 G @ 20°C	Minutes	EN 14022	300

\*\*Pot life and cure times will vary dependant on ambient temperature and humidity

### System Information

#### Consumption/Dosage:

The volume content's are stated on each pack. As a guide 400cc pack of mixed CB10T at an Adhesive thickness of 1mm thick will cover 0.4m<sup>2</sup> of timber. As a guide for crack injection 400cc pack would fill 5 linear meters of a crack of 3mm wide x 25mm deep.

#### Substrate Quality:

All types of substrate must be clean, dry or surface damp (no standing water) and free from contaminants such as dust, dirt, oil, grease, pre existing surface treatments e.g. coatings etc.. Steel substrates must be de-rusted to Sa 2.5 standard to maximise adhesion. The substrate must be sound and all loose particles must be removed.

#### Substrate Preparation:

Old surface treatments or coatings and all loose or friable particles must be removed to achieve a laitance and contaminant free, open textured surface. Steel: Must be cleaned and prepared thoroughly to an acceptable quality i.e. by blast cleaning and vacuum.

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## Application Conditions/Limitations

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Substrate Temperature: +8°C min. / +30°C max.

Ambient Temperature: +5°C min. / +25°C max.

Material Temperature: CB10T must be applied at temperatures between +5°C and +25°C

Substrate Moisture Content: Avoid dew point conditions. Always check the moisture content of the timber to which you are adhering to, do not fix in timbers that are over 20% M/C – Please ring our Technical Department for specific information.

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## Application Instructions

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### Mixing:

Add the total contents of the smaller container (hardener) to the (base) Mix the pastes thoroughly using a flat end pallet knife.

Place the Follower-plate onto the surface of the mixed material ensuring it fits parallel in the tub with the outer and central lip pointing upwards.

Cut the seal from the front end of the cartridge sleeve. Place the back of the cartridge vertically and centrally over the hole in the follower-plate.

Press the cartridge firmly and continuously down on to the follower-plate until the follower-plate bottoms on the mixing tub base. Carefully remove and invert the now full cartridge.

Screw on the front injection nozzle plus any chosen injection tube assembly. Finally, insert the rear plunger.

Where applicable, install the full cartridge of CB10T Structural Adhesive into the injection gun. Alternatively for spreader application as an adhesive, dispense directly from the cartridge without the aid of the front nozzle or injection tube.

*Mixing knife Ref: 3642. 400cc injection gun Ref: 3667. Available from Rotafix*

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### Mixing Time;

Mix the Base & Hardener parts together for at least 3 minutes with a mixing Knife until the material becomes smooth in consistency and a uniform in colour.

Mix only 1 x pack at a time or the quantity which can be used within its pot life.

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### Cleaning of Tools;

All tools and application equipment can be with thinners or solvent wipes immediately after use. Hardened and or cured material can only be removed by mechanical means.

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## Health and Safety & Legal Information

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The requirements for a Rotafix product(s) may be specific for an individual project. Advice given by Rotafix can only be considered as part of the contract if it is provided in writing.

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Rotafix CB10T Adhesive  
3550

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