



**PRODUCT NAME**  
**Rotafix Timberset Structural Adhesive**

400cc pack (3553)

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**Product Description**

Rotafix Timberset Structural Adhesive is a thixotropic, structural two part adhesive based on a combination of epoxy resins and special graded fillers, designed for the bonding of fixings in all timber engineering repair work.

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**Uses**

As a structural adhesive mostly for the repair to wood , can be used vertical and overhead for filling of cracks and shakes and the installation of anchors.

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**Characteristics/Advantages**

Rotafix Timberset Structural Adhesive has the following advantages: Easy to mix and apply, excellent adhesion to most timber substrates. High strength thixotropic adhesive, low-sag in vertical and overhead applications, Solvent Free, cures without shrinkage, High initial and ultimate strength.

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**Tests**

Approval/Standards  
Testing according to EN 15274

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**Product Data**

Colours:  
Base part : Brown paste  
Hardener : White Paste

Packaging:  
Supplied in 400 cc pre batched packs consisting of 2 x plastic screw cap jars & an empty cartridge set & follower plate

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**Storage**

Storage conditions:  
Shelf Life of 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 off cold floors and protect from frost.

Chemical Type:  
Thixotropic epoxy base including its curing agent

Density:  
1.25 + 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        | 30 – 40 N/mm <sup>2</sup> |
| 11 days       | 40 – 50 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                                | 21.76                                      |
| Environmental Durability   | MPa  | BS EN ISO 9142                                 | >23  |
| Environmental Conditions   | 24hrs at 24 °C & 90% RH<br>72hrs at 24 °C & 90% RH | 24hrs at 40°C & 30%RH<br>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 | 5.77  |
| Crack Extension                      | mm      | ASTM D3762      | 7.05  |
| Temperature of Deflection Under Load | °C      | BS EN ISO 75-2  | <32.7 |
| **Pot life<br>100 G @ 20°C           | Minutes | EN 14022        | 50    |
| **Cure time<br>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 contents are as stated on the packs. As a guide 400cc pack of mixed Timberset as 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 3mm wide x 25mm deep.

#### Substrate Quality:

All types of timber must be clean, dry or surface damp and free from contaminants such as dust, dirt, oil, grease, existing surface treatments and 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.

## Application Conditions/Limitations

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Substrate Temperature: +8°C min. / +25°C max.

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

Material Temperature: TIMBERSET 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 (curing agent) to the (base) Mix the pastes

Thoroughly using a flat end pal let knife, reference 3642. To give a homogenous one colour mix.

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 TIMBERSET 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 Timberset Adhesive  
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