

**Operation manual for mixing small quantities of Gel-Epoxy**

**Material Data:** For main characteristics refer to Data Sheet DS 710

**MSDS:** Note MSDA Data Sheets for resin.

**Safety and Handling:** Usual precautionary measures for handling chemicals must be observed. Ensure good ventilation at workplace.  
Avoid material contact with eyes and skin.  
Wear protection gloves and protective mask as always recommended by using epoxy materials.

**Mixing Ratio:** 75% Hardener  
25% Resin  
Max. tolerance in ratio is +/- 2%

**Mixing :** Pour resin and hardener in a tank in exact ratio and mix slowly using hand stirrer for 4-5 minutes mixing time. Use electrical stirrer if adjustable to very slow speed only.

**Injection Speed:** It is recommended to use very slow injection speed from the bottom to secure removal of even small air bubbles for best injection quality.  
Pump flow rate of 15 liter/minute is recommended.

**Fluidity:** Up to 24 hours at 20°C.  
Best injection conditions are up to 8 hours.  
After approx 8 hours the viscosity will increase and this will influence the injection quality.

**Viscosity:**                      500 Pascal after 5 minutes  
                                         900 Pascal after 5 hours  
                                         5000 Pascal after 24 hours

**Polimersation Time:**    240 Hrs at 0°C  
                                     120 Hrs at 20°C  
                                     72 Hrs at 40°C  
                                     16 hrs at 60°C

**Equipment Cleaning:**    Do not use water !!  
                                     Cleaning by using solvents as MEC (Methyl Ethyl Cetone) or  
                                     XY (Xylene) or a blend of both in ration 50/50.

**Cleaning of others:**        Spillaged steel or galvanized steel parts: Get Gel-Epoxy  
                                     completely polymerized.  
                                     Method 1: Use MEC to swell the polymerized Gel-Epoxy for 6  
                                                                 hours and remove it by sand-blasting  
                                     Method 2: lse CO2 ice-blasting (-78°C)

**Storage Time:**                Used drums:  
                                     If drums are well closed directly after opening, stocking time of  
                                     6 month for hardener and resin should be achievable.  
                                     In general the resin is relatively resistible against atmosphere  
                                     contacts, but the hardener is more sensitive.  
                                     Gel- Epoxy should be stored in dry and sun-protected  
                                     conditions.

**Pot Life Storage Time:**    Minimum of 12 month at stocking temperature of 15-23°C.