

flow RESINS

Technical Data Sheet

Issue Date: 10/01/2022

Product Name:

FLOW 36

Product Description:

FLOW 36 is an easy to use, general purpose casting and laminating system. It is best used for filling the fine cracks, voids and holes in timber. It is suitable for pouring thinner layers up to 10mm thick (at room temperatures of 25°C or below).

FLOW 36 is commonly used as an epoxy-based laminating system in the fibreglass manufacturing industry.

Product Highlights:

Low viscosity, great thermal stability at temperatures 20°C to 70°C, self-releases air bubbles and has good mechanical properties.

Physical Properties:

Part A

Viscosity at 25°C	mPa.s 500 - 1000
Specific Gravity at 25°C (g/cm ³)	1.1 - 1.15
Colour	Clear, light yellow liquid

Part B

Viscosity at 25°C	mPa.s 70 - 100
Specific Gravity at 25°C (g/cm ³)	1.0 - 1.05
Colour	Clear, light yellow liquid

Handling Properties:

Mix Ratio - Part A : Part B (by weight)	100 : 50
Pot Life (200g Sample) @ 25°C	30 - 40 minutes
Peak Exotherm (200g Sample) @ 25°C	110°C
Demould Time	12 - 24 hours
Full Cure	7 days
Hardness	85-90D

Instructions:

FLOW 36 is a 2-part, laminating epoxy system. It can be used for shallow pours to fill knots, cracks and splits in floors, woodwork and timber pieces.

Ensure timber is dry and free from oils, solvents, dust, silicones etc. Prior to pouring, be sure to seal the underside of the timber with tape or silicone to create a watertight cavity. FLOW 36 is a low viscosity system and will usually flow deeper into the timber than we can see. Failing to seal the underside could result in epoxy leaking through the piece.

Mix Part A and Part B **by WEIGHT using scales** exactly to ratio. Use a syringe or small plastic container to pour FLOW 36 into the required areas of the woodwork or timber.

Allow the epoxy to exotherm (heat transfer) for approximately 2 hours before repeating the process to fill the affected area. On larger areas, slightly overfill the cracks to allow for minor shrinkage. Allow to cure for 24 hours at 25 degrees Celsius prior to tooling or sanding. Belt or orbital sand to achieve a smooth, level surface.

Use ART FLOW as a high gloss, self-levelling coating or timber oil after sanding.

Extra care MUST be taken to ensure thorough mixing of Part A and Part B. Ensure casting is performed in a well-ventilated area as some vapours will be released at these curing temperatures. PPE is recommended. Please refer to the safety data sheet for more information.

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Handling Precautions:

This Part A and Part B combination has been formulated with the objective of being as safe as possible however in common with most epoxy resins and hardeners, consistent skin contact with the uncured materials should always be avoided. Materials will become very hot during curing (up to 160°C).

Do not touch in under the specified demoulding time as burns to the skin may occur. Our testing is based on a 200g sample size. Larger amounts of resin and hardener will get hotter during curing, consequently there is potential for shrinking and cracking during the curing process. It is for this reason that we recommend that castings are no larger than 10mm in thickness. Ensure all casting is performed in a well-ventilated area as some vapours will be released at these curing temperatures. Please refer to the safety data sheet for more information.

Storage:

Store the components in a dry place at 18 to 25°C, in tightly sealed original containers.

Disclaimer:

The data presented in this leaflet are in accordance with the present state of our knowledge and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

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