



System Three Resins, Inc.
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 TECHNICAL SUPPORT: 253-333-8118

TECHNICAL DATA SHEET
G-2 STRUCTURAL EPOXY ADHESIVE

DESCRIPTION:

System Three G-2 is a two-component, epoxy/polyamide adhesive. For over 35 years, G-2 has been an excellent adhesive choice for oily, acidic hardwoods like teak and other tropical woods. Use it for gluing oak and cedar, as well as other materials that are difficult to bond. G-2 was developed primarily for waterproof bonding of rot-resistant woods used in fine yacht joinery. Use G-2 for both interior and exterior applications as well as below the waterline. After fully curing it can be machined, drilled, sanded and tapped.

PRODUCT USES:

Marine – Ideal for stitch-and-glue, sheet plywood, strip planking and cold molding. Perfect for laminating stems, ribs and deck beams. Bonds marine woods to fiberglass, ferro cement and steel vessels. Can be mixed with wood flour, silica thickener, to make the adhesive non-sagging.

RESIN PROPERTIES

Viscosity @ 77° F 5000 cps
 Density 9.6 lb/gal
 Color Water-white

HARDENER PROPERTIES:

Viscosity @ 77° F 5000 cps
 Density 8.0lb/gal
 Color Amber

MIXED SYSTEM PROPERTIES:

Mix ratio by weight resin/hardener 100:44
 Mix ratio by volume resin/hardener 100:50
 Mixed viscosity 5500 cps
 Mixed Color Light Amber
 Application Temperature Range 10°C to 32°C (50°F to 102°F)
 Tensile Strength 6,000 psi
 Compressive Strength 12,000 psi
 Elongation 11%
 Coverage @ 250 microns (10 mils) 3.6 m²/L (150 ft²/Gal)
 Maximum Service Temperature -20°C to 72°C (-4°F to 160°F)
 Gel Time @ 25°C (77°F) 90 Minutes (100g mixture)
 Full Cure @ 25°C (77°F) 48 Hours (100g mixture)

For health and safety information concerning this product, please refer to the MSDS sheets for G-2.

Available in the following sizes: 12 oz./1½ pint / 1½ quart / 1½ gallon /

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