

Rapid Cure R90 is a high viscosity, solvent free epoxy resin specifically formulated for use with H90 to provide thin film or glue joint gelation in approximately four minutes at 25°C.

This type of adhesive is used in marine joinery and repair, commercial joinery, furniture manufacture, stone and masonry bonding and home handyman applications.

Rapid Cure R90 will successfully bond to soft woods, hard woods, particle board, custom wood, Formica, glass, leather, ceramics, most metals including stainless steel, and some plastics. Small laminations with fibreglass cloths are also possible.

MIX RATIO

1 part hardener to 1 part resin by volume.

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL composites for specific information.

If using pumps then depress each pump fully the same number of times. Let the pump return by itself to the top of each stroke.

Rapid Cure should be stored above 20°C for optimum pump efficiency.

UNCURED PROPERTIES		
	R90	H90
Physical State	Clear pale yellow liquid/ mild odour	Clear water to light amber liquid/ strong odour
Viscosity mPas@ 25°C	10,000	9,000
Specific Gravity g/ml@ 25°C	1.15	1.12

CURE CHARACTERISTICS	
Pot Life -100g @ 25°C (in air)	4 minutes
Cured to a solid state @ 25°C	5 minutes
Working cure @ 25°C	30 minutes
Cure to maximum strength	1 hour
Mix viscosity mPas@ 25°C	7,400
Shore D Hardness	
@ 1 day	85
@ 2 weeks ambient	86
HDT after 24 hours @ 25°C	41
2 weeks @ 25°C	46
+16 hours @ 50°C	55

Note: Post cure temp or service temp must not exceed 50°C

APPLICATION

The surfaces to be bonded should be dry and free from any contaminants. Fibreglass, painted or metal surfaces should be thoroughly sanded back leaving a matt finish. Apply the mixed epoxy to one or both surfaces and hold firmly together, or apply minimal clamping pressure.

Rapid Cure provides handling strength in 8 to 15 minutes.

Rapid Cure can also be used as an excellent gap-filling adhesive when mixed with WEST SYSTEM® brand 403 Microfibre Blend or can be used as a fast drying putty-filler when mixed with WEST SYSTEM® brand 411 Microsphere Blend.

PACK SIZES				
Order Code		Order Code		PACK
Resin		Hardener		
RA90	125 ml	HA90	125 ml	250 ml
RB90	250 ml	HB90	250 ml	500 ml
RD90	1 L	HD90	1 L	2 L
RE90	4 L	HE90	4 L	8 L

PUMP PACKS	
Order Code	PACK
901D	2L
901E	8L

STORAGE

Rapid Cure R90 resin and H90 hardener will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

HEALTH & SAFETY

Rapid Cure R90 resin and H90 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 27/05/04



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