



## Flowcrete 320

A two component medium cure, thixotropic epoxy adhesive with excellent gap filling properties.



### Adhesion:

A general purpose adhesive for most materials especially in boat building.

### Technical Profile

NO. OF COMPONENTS	2
MIXING RATIO	1:1 by volume
POT LIFE @ 25°C	45 minutes
VOLUME SOLIDS	100%
APPLICATION TEMP.	Min 10°C Max 40°C
MAX SERVICE TEMP.	Dry 65°C Wet 40°C
TENSILE STRENGTH	5mPa
COMPRESSIVE STRENGTH	65mPa
BOND STRENGTH	Concrete breaks before bond Wood breaks before bond
COLOUR	Amber
SHELF LIFE	2 years
CLEANER	W.S.B.C

SPEED OF CURE**	20 °C
Touch Dry	6 hrs
Practical Cure	24 hrs
Full Cure	7 days

\*\*Cure times at temperatures between 0–30 °C can be achieved by altering the quantity of catalyst used. For applications falling outside of this temperature range, please contact your local Flowcrete Technical Department.

## Preparation

All surfaces to be clean, dry and sound.  
Vacuum cleaning and wiping with Flowcrete Epoxy Thinners is recommended.  
Smooth surfaces to be abraded.  
Teak and oil containing woods to be thoroughly treated with oil-free acetone to provide an oil free bonding surface.

## Application

1. Mix on a flat, clean surface such as a board or plate. Measure out quantities in accordance with mixing ratio and thoroughly mix to a homogeneous material using a spatula, paint scraper etc.
2. If a filled material is required add the filler only after mixing is completed.
3. Spread the mixed material on one face, thick enough to extrude when both surfaces are mated and pressure applied.
4. Bonded faces must be kept under pressure until the adhesive is set.

## Substrate Requirements

Concrete or screed substrate should be a minimum of 25 N/mm<sup>2</sup>, free from laitence, dust and other contamination. Substrate should be dry to 75% RH as per BS8204.

## Installation Service

The installation should be carried out by an Approved Flowcrete Applicator. For details of our Approved Applicators, contact your regional Flowcrete office. Detailed application instructions are available upon request.

## Aftercare, Cleaning & Maintenance

Clean regularly using a single or double headed rotary scrubber drier in conjunction with a mildly alkaline detergent.

## Environmental Considerations

The finished system is assessed as non-hazardous to health and the environment. The long service life and seamless surface reduce the need for repairs and maintenance. Environmental and health considerations are controlled during manufacture and application of the products by Flowcrete staff and fully trained application teams.

## Focus on the Floorzone

Flowcrete is a market leader in specialist industrial and commercial flooring. Systems available include: floor screeds, surface damp proof membranes, decorative flooring, seamless terrazzo, car park deck coatings, tank lining systems... to name just a few. Our objective is to satisfy your Floorzone needs.

## Warranty

Flowcrete products are guaranteed against defective materials and manufacture and are sold subject to our standard 'Warranty, Terms and Conditions of Sale', copies of which can be obtained on request. Warranty does not cover suitability, fit for purpose or any consequential or related damages. Please review warranty in detail before installing the products.