

RESOLTECH 2040G

Hardeners 2045G & 2049G

Structural Adhesive Epoxy for wood bonding & Structural Fillet Joints

- Easy 4/1 mixing ratio by weight
- Ambient temperature curing
- Adjustable Pot life
- Applicable in high humidity conditions



Evolution of the **RESOLTECH 2040** system, The **RESOLTECH 2040G** is a structural adhesive paste specifically formulated for fillet joints on wood. It can also commonly used as general purpose structural wood adhesive, specially on vertical or overhanging surfaces thanks to its cohesion and high adhesion properties.

The main improvements of the 2040G over the 2040 is an improved adhesion onto vertical surfaces even in large quantities, an improved density of the product and less odour on the hardener improving work conditions.

The system can be ordered with two different hardeners, standard and fast. Both of them have the same mixing ratio and are fully compatible with each other, offering the possibility to be mixed together in order to obtain intermediate pot life.

The 2040G will obtain 100% of its mechanical characteristics at ambient temperature and can be used in high humidity conditions. The mechanical properties of the 2040G with high resistance in traction/shearing will enable to obtain durable structural fillet joints.

For an increased resistance and durability of the wood, we recommend to prime all woods with our water bond epoxy **RESOLTECH 1010-1014**.

Resoltech 2040G is easy to sand and CNC machineable with a good surface aspect.

Resin 2040G

Hardener 2045G & 2049G

Structural Adhesive Epoxy for wood bonding & Structural Fillet Joints

MIXING RATIO

BY WEIGHT

Resin 2040G	100
Hardener 204XG	25



WARNING:

The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties. The mixture should be thoroughly stirred to ensure full homogeneity. It is important to note that epoxy systems tend to heat up much faster in a pot than as a thin film.

PHYSICAL CHARACTERISTICS @ 23°C

Visual aspect

2040G :	Thixotropic neutral color gel
2045G & 2049G :	Light yellow thixotropic gel
Mix :	Light yellow thixotropic gel

It is possible to obtain all RAL colours by adding pigments to the mix. All RAL pigments are available on demand and are sold separately.

REACTIVITY & HARDENING

Pot life	2040G+2045G	2040G+2049G
Pot life on 100g @ 23°C :	50~60 min	10 min

Hardening

Time to gel in thin film @ 23°C :	9h	3h
Optimum mechanical resistance @ 23°C :	7 days	7days

MECHANICAL PROPERTIES

Traction/Shearing properties

Wood on Wood :	Wood delaminating
Aluminium/aluminium :	6 MPa

Hardness

Shore ASTM 2240-97 :	85 D
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TG

TG (kinetech):	50°C
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Resin 2040G

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REACTIVITY & HARDENING (continued)

Hard & sandable:

2040G resin + 2045G hardener 16 Hours

2040G resin + 2049G hardener 4 Hours

APPLICATION

The standard procedure of working with epoxy systems applies to the RESOLTECH 2040 G.

If mixing large quantities it is recommended to use a mechanical stirrer during 5 effective minutes.

The system can be applied by round trowel for fillet joints, squeegee or notched spatula over most materials.

Application with automatic mixing and dispensing machines is easy due to the density and viscosity of the product

The system can be applied in one or several layers.

In case of application over a cured laminate surface without peel ply, it is required to deglaze, clean and degrease the support prior to applying the fillet joint compound.

For an increased resistance and durability of the wood, we recommend to prime all woods with our water bond epoxy **RESOLTECH 1010-1014**.

For more information, please refer to the applications technical bulletins (TechNotes), available on request.

Coverage

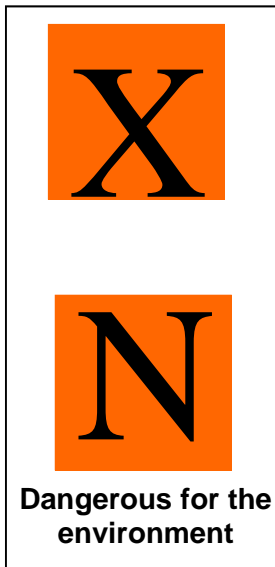
The coverage of the 2040G applied as fillet joint will depend of the radius of the fillet joint. For example the average consumption of a 30 mm radius fillet joint is 200 to 250 g for 1 linear meter applied on 90 degrees surfaces.

Resin 2040G

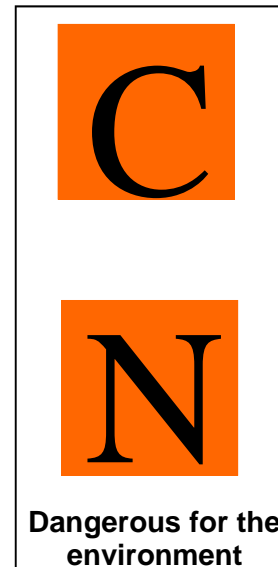
Hardener 2045G & 2049G

LABELLING

2040G



2045G & 2049G



PACKAGING

RESOLTECH 2040G/ 2045G & 2049G

1,25 Kg Kit : 1 kg + 0,25 Kg

5 Kg Kit : 4Kg + 1 Kg

25 Kg Kit : 20Kg + 5 Kg

For non standard packagings please contact us

TRANSPORT & STORAGE

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold preferably between 10°C and 30°C in a well ventilated area.

HEALTH & SAFETY

Although the 2040g is a recent formulation, it is advised to follow basic rules such as avoiding skin contact and wear masks like with any other epoxy resins. Please read our standard health and safety sheet for more information. In case of eye contamination, wash with water and seek medical advice. Please read the Material Safety Data Sheet prior to using this product.

Nota The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.



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