

Product Selection

COMMON USES OF EPIGLASS® EPOXY SYSTEM	HT9000 Epiglass® Resin Mix	HT110 Epiglass® Glue Powder	HT220 Epiglass® Wood Fibres
	<ul style="list-style-type: none"> High strength and durability is suitable for sheathing, laminating, filling, fairing and gluing Low viscosity formula for ease of mixing and wet out 4:1 mix ratio Solvent free, phenol free, and low odour, for a safer, cleaner working environment Good water barrier properties, can be used above and below the waterline 	<ul style="list-style-type: none"> Durable, high strength epoxy glue mix for all applications Viscosity can be adapted to diverse working conditions by varying volume of added glue powder. 	<ul style="list-style-type: none"> White cellulose fibre for adding to glue mixes when bonding, especially suitable for fillet bonding
SEALING FIBREGLASS	YES		
LAMINATING	YES		
SHEATHING	YES		
FILLING & FILLETING	YES	YES	YES (wood fillets)
BONDING WOOD	YES		YES

Type of mix required by volume	HT9000 Epiglass® Resin Mix	HT110 Epiglass® Glue Powder	HT220 Epiglass® Wood Fibres
LOW VISCOSITY GLUE MIX	1	1	
HIGH VISCOSITY GLUE MIX/FILLET MIX	1	1	1

Note: The above chart is parts by volume of additive to mixed resin and hardener. Volume can be altered to suit a particular job.

FILLET BONDING WITH EPIGLASS®

WHAT ARE FILLET JOINTS? – Fillet joints are an extremely simple and effective way of bonding two parts of a structure together. Examples of where a fillet joint may be used are:

- In a bulkhead/hull/joint.
- Angle joints in interior furniture.

Fillet bonding is also useful for joining plywood of less than 6mm in thickness. It can be used on thicker grades, but as the fillet radius becomes larger, the economy and effectiveness of the joint is reduced.

FILLET RADIUS CALCULATION

The fillet is shaped by using a round ended stick or spatula of the same radius as the desired fillet. The formulae below indicate the requirements for the fillet radius as dictated by the filler density.

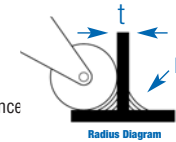
FILLET BONDING MIX

Radius (r) = 2.5 to 5 times timber thickness (t)

FAIRING MIX (LOWER DENSITY ALTERNATIVE)







Radius (r) = 4 to 12 times timber thickness (t)

These formulae act as a guide only, based from our tests and experience. There are many variables depending on the consistency and mix of extenders. We recommend that you construct a test fillet joint and ensure that when loaded to failure after a full cure, the failure occurs in the timber and not the fillet joint. The approximate quantity required per metre length of fillet – including wastage is:



Volume (ml) of fillet mix = radius (mm) x radius (mm) x 0.25 x length (m)

GLUING WITH EPIGLASS®	
1	Prepare surface thoroughly. Sand and...
2	Wipe down with Epiglass Epoxy Solvent.
3	Accurately measure Epiglass Resin and Hardener and mix well.
4	Prime absorbent surfaces with a light coat of Epiglass resin mix.
5	Blend in Glue Powder and any low density fibres until the desired viscosity is achieved. The thicker the glue line, the thicker the glue viscosity required.
6	Clamp and secure components as necessary. Do not overclamp or the joint will become starved of glue.
7	Remove surplus before curing.
8	Allow adequate curing before release of clamping pressure.



IMPORTANT: DO NOT GLUE BELOW 10°C. ALWAYS USE PROPER PROTECTION! ALWAYS ENSURE THAT ALL IMPERFECTIONS IN THE BOND SURFACES ARE FILLED PRIOR TO FILLETING. AFTER SANDING, ALL DUST AND CONTAMINANTS SHOULD BE REMOVED BY WIPING WITH EPIGLASS SOLVENT BEFORE APPLYING THE FILLET MIXTURE.