

Flexco 66/67 Solvent-Free ESD Epoxy Adhesive

DESCRIPTION

Flexco 66/67 Solvent Free ESD Epoxy Adhesive must be used for the installation of the Flexco Conductive and Static Dissipative Solid Vinyl Tile. It is a solvent free, non-flammable, high performance epoxy adhesive for indoor installations over porous and non-porous substrates on grade, below grade or above grade. This adhesive is designed to support the Flexco ESD Solid Vinyl Tile under rolling loads in virtually any environment.

COLOR

Part A: Cream to Gray

Part B: Black

Mixed: Black

PACKAGING

1 Quart Two-Part Units

1 Gallon Two-Part Units

WEIGHT

4 Pounds per Quart Unit

13 Pounds per Gallon Unit

TROWEL SIZE

Smooth Substrates, 1/32" x 1/16" x 1/32" U Notch



Rough Substrates, 1/16" x 1/16" x 1/16" Flat V



COVERAGE

Approximately 120-150 Square Feet per Gallon

MIXING

DO NOT mix partial units of this adhesive, because the ratio of Part A to Part B is not 1:1. Flexco 66/67 Solvent Free ESD Epoxy Adhesive is packaged in two separate containers marked Part A (epoxy resin) and Part B (polyamide resin, hardener). Remove the lids and add all of Part A into Part B. Mix the combined parts using a rotary motion while at the same time lifting from the bottom. A slow speed, 200 RPM maximum drill, with an attached mixing paddle may also be used. Mix for a minimum of 3 minutes with drill or 5 minutes by hand. After mixing, there must be no streaking of the two parts in the adhesive; it will be consistent black color.

Caution: Higher mixing speeds and/or longer mixing time will reduce the open time and can cause premature curing of the adhesive; however, if not mixed long enough, the adhesive will not properly cure. **DO NOT** allow the mixed epoxy adhesive to stand in the container. Immediately after mixing, pour the contents onto the substrate. Immediately spread the adhesive evenly with the proper trowel for the substrate. You will see the substrate between the trowel ridges when spread properly. **Caution:** If too much adhesive is applied, oozing and telegraphing may occur along with adhesive displacement when the tile is rolled or subjected to rolling loads or lateral shear stress, resulting in loose areas and adhesive

telegraphing. **Caution:** "Tack up" time, open time, and curing characteristics will vary upon the type of substrate, temperature of the substrate, ambient temperature, humidity, proper mixing of the adhesive and proper conditioning of the adhesive. Observe the adhesive to ensure the adhesive has not surpassed its open time and started to cure.

RECOMMENDED SUBSTRATES

Recommended for properly prepared Concrete, Wood, Metal and Terrazzo

ADHESIVE WORKING TIME

Flash Time: 15-20 Minutes or until tacky to the touch

Working Time: 45 Minutes

MOISTURE AND PH REQUIREMENTS

ASTM F 1869; Calcium Chloride, 5.0 lbs

ASTM F 2170; Relative Humidity, 75%

pH; 9 or less

PRODUCTS

Conductive and Static Dissipative Solid Vinyl Tiles and Static Dissipative Rubber Tiles

CLEAN UP

If material oozes through the seams, allow the material to dry completely without smearing; then scrape gently to remove. If material becomes smeared, clean gently with mineral spirits to remove as much residue as possible then neutralize the area with warm soapy water to prevent damage to the tile. Any material that remains on the surface after cleaning will be removed during the initial maintenance of the ESD tiles, if performed correctly.

CALCULATED VOCs

VOCs Part A: 9 g/L

VOCs Part B: 20 g/L

VOCs Mixed: 14.3 g/L

LIMITATIONS

Foot traffic after 24 hours

Light rolling loads after 48 hours

Heavy rolling loads after 72 hours

Maintenance after 48 hours

Not for use over existing floor covering or old adhesives

Not for use outdoors

SHELF LIFE

Shelf life is one year when stored at 70° F (21° C) in an unopened container

FREEZE THAW STABILITY

Epoxy components are non-freezing; allow stabilizing to room temperature before mixing

QUALIFICATIONS

CRI Green Label Plus, CHPS and LEED Compliant

As not all information can be covered within this general guide, please refer to the appropriate Conductive and Static Dissipative Solid Vinyl Tile Product Data Sheets, Installation and/or Maintenance Instructions for additional detailed information. Obtain from www.flexcofloors.com by clicking the Technical Support link, emailing installhelp@flexcofloors.com, or by contacting Flexco Customer Service @ 800-633-3131.

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