

# Flexco 77 Solvent-Free Epoxy Adhesive

## DESCRIPTION

Flexco 77 Solvent Free Epoxy Adhesive is a solvent free, non-flammable, high performance epoxy adhesive used for indoor installations over porous and non-porous (including metal, ceramic tile and cementitious terrazzo) substrates on grade, below grade and/or above grade. Use the Flexco 77 Solvent Free Epoxy Adhesive for installations in areas subjecting the flooring to lateral shear stresses and/or rolling loads, in areas subjected to moisture or other liquids, in areas where the substrate or flooring is not maintained within the specified temperature range. Use the Flexco 77 Solvent Free Epoxy Adhesive for all Repel™ Oil and Grease Resistant Compound installations.

## COLOR

Part A: Gray  
Part B: Olive  
Mixed: Olive Gray

## 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 77 Solvent Free 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 olive gray 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, Terrazzo, Wood, Metal and Fiberglass

## 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

Flexco Natural Elements Premium Wood Vinyl Plank, Natural Elements Luxury Vinyl Stone Tile, WoodTones Premium Wood Vinyl Plank, Appeal Vinyl Tile, Contract Vinyl Tile, Health Design Vinyl Tile, Rubber Tile, Vinyl Stair Tread, Rubber Stair Tread, Tufflex Force, Prime Sports Floor, FlexTuft

## 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.

## CALCULATED VOCs

VOCs Part A: .13 g/L Max  
VOCs Part B: 2.4 g/L Max  
VOCs Mixed: 1.21 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 Product Data Sheets, Installation and/or Maintenance Instructions for additional detailed information. Obtain from [www.flexcofloors.com](http://www.flexcofloors.com) by clicking the Technical Support link, emailing [installhelp@flexcofloors.com](mailto:installhelp@flexcofloors.com), or by contacting Flexco Customer Service @ 800-633-3131.

## **COMPANY INFORMATION**

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