



**resoltech**  
ADVANCED COMPOSITE TECHNOLOGY

# 1020T

## WOOD EPOXY ADHESIVE SYSTEM PREGEL VERSION

RESOLTECH 1020T is a pregel wood adhesive system optimised for the manufacture of laminated wood parts and structures. It provides ease of use, low toxicity to the user, good impregnation of the timber surface, high mechanical performance of the cured structure and an adjustable working time. 1020T makes bonds that are stronger than the timber itself, enhancing its mechanical properties and producing long lasting heavy duty structures for marine, building and engineering applications.

### MIXING RATIO

BY WEIGHT: 100 resin + 30 hardener  
BY VOLUME: 3 resin + 1 hardener

**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. It is therefore necessary to only mix the necessary amount usable within the given pot life. Keeping the mixture in flat open containers reduces the risks of exothermic reaction.

### APPLICATION

RESOLTECH 1020T is formulated to be used as an adhesive system to bond wooden parts together. The surface should be clean, dust and grease free prior to bonding. A rough surface will provide better results than a very smooth one. 1020T can also be used to bond other materials such as steel, aluminium and fiberglass laminates.

1020T does not require pressure during curing, although pressure will increase the mechanical properties of the finished structure.

Workshop temperature is best kept from 10 to 25°C.

Sanding is required prior to bonding over a cured surface.

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

### CURING

There are 4 hardeners providing different working times.

Pot life for the different hardeners:

1023	1024	1026	1028
8 hours	4H30	3 hours	35 minutes

Based on a mix of 70g at 22°C.

The structure should be cured for at least 24 hours at ambient temperature prior to being moved.

## **MECHANICAL PROPERTIES**

The following data is based on a cure of 14 days at 20°C.

Tensile modulus: 3200MPa  
Flexural modulus: 3400MPa  
Tensile strength: 65MPa  
Flexural strength: 90MPa  
Elongation at break: 10%  
Impact resistance: 30KJ/m<sup>2</sup>  
Maximum Tg: 70°C

## **PHYSICAL PROPERTIES**

Resin aspect: Pale yellow gel  
Hardener aspect: Clear liquid, 20 to 120mPas viscosity  
Mixture aspect: Pale yellow gel  
Density of the mixture: 1.1  
Viscosity of the mixture: 200 to 350mPas  
1020T is formulated to optimise the wetting out of wood fibres.

## **PACKING & STORAGE**

Pack sizes are 1.3kg, 6.50kg, 39kg.

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold.

## **HEALTH AND SAFETY**

It is advised to follow basic rules such as avoiding skin contact, wear masks when producing dust. Please read our standard health and safety sheet for more information.  
In case of eye contamination, wash with water and seek medical advice.

More information is available on [www.resoltech.com](http://www.resoltech.com).

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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