



# Jointing Compound Specifications Sheet

## PRODUCT DESCRIPTION:

Woodstock Jointing Compound is a two-part, methacrylate adhesive designed for solid surface seaming and assembly. The product is UV stable and non-yellowing. It offers excellent adhesion to a variety of solid surface sheet materials including cast acrylic and cast/densified polyester. It exhibits high resistance to water, impact, wear scuffing, boiling water, high temperature and UV light. Combined with the activator at a 10:1 ratio it has a working time of 8-13 minutes and achieves handling strength in 30 to 40 minutes.

## DISPENSING ADHESIVE:

Woodstock Jointing Compound may be applied manually or with automated equipment. Static mixer selection is critical to the proper mixing and performance of these adhesives. Pre-measured cartridges are also available, as well as the hand-held guns with which to dispense the adhesive. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and clamped. All adhesive application, part positioning, and fixturing should occur before the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. Automated equipment should be constructed of stainless steel or aluminium. Avoid contact with copper or copper containing alloys in all fittings, pumps, etc. Seals and gaskets should be made of Teflon, Teflon-coated PVC foam, ethylene/propylene or polyethylene. Avoid the use of Viton, BUNA-N, Neoprene or other elastomers for seals and gaskets. Clean up is easiest before the adhesive has cured. Citrus terpeneor N-methyl pyrrolidone(NMP) containing cleaners and degreasers can be used for best results. If the adhesive is already cured, careful scraping, followed by a solvent wipe may be the most effective method of clean up.

## CHARACTERISTICS:

Room Temperature Cure

Working Time	8 - 13 minutes
Fixture Time	30 -40 minutes
Operating Temperature	-55°C to 121°C
Mixed Density	1.07 g/cc

## ENVIRONMENTAL RESISTANCE:

Water, Impact, Scuffing, High Temperatures, Ultra Violet Light (UV)

## RECOMMENDED FOR:

Acrylic Sheet, Polyester Sheet, Thermoplastics, GRP / Composites, Gelcoats

## PHYSICAL PROPERTIES:

	Adhesive	Activator
Viscosity	16,000 - 20,000	20,000 - 35,000
Colour	Various	Off white
Density, g/cc	1.07	1.05
Mix Ratio by Volume	10	1
Mix Ratio by Weight	10.05	1



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## MECHANICAL PROPERTIES:

(Cured) - Room Temperature

Butt Joint Tensile MPa	
Strength MPa 4-Point Blend (ASTM D790)	20-24
Strength MPa	41-55

## HANDLING AND APPLICATION

Woodstock Jointing Compound (Part A) is flammable. Contents include Methacrylate Ester. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks, and open flames. Reference the Material Safety Data Sheet for more complete safety information.

**Note:** Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exothermic reaction, resulting from the mixing of large masses of adhesive can result in the release of entrapped air, steam, and volatile gases. To prevent this, use only enough material as needed for use within the working time for the product and confine gap thickness to no more than 9mm.

## EFFECT OF TEMPERATURE

Application of adhesive at temperatures between 18°C and 26°C will ensure proper cure. Temperatures below 18°C will slow cure speed; above 26°C will increase cure speed. The viscosities of Parts A and B of this adhesive are affected by temperature. To ensure consistent dispensing in meter-mix equipment, adhesive and activator temperatures should be held reasonably constant throughout the year.

## STORAGE AND SHELF LIFE

Shelf life of Woodstock Jointing Compound (Part A) is 1 year. Shelf life of activator (Part B), including cartridges that contain activators, is 9 months. Shelf life is based on continuous storage between 12°C and 23°C. Long term exposure above 23°C will reduce the shelf life of these materials.

Prolonged exposure of activators, including cartridges that contain activators, above 37°C quickly diminishes the reactivity of the product and should be avoided. These products should never be frozen. For expiry date see label.

**PRECAUTIONS:** This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

**WARRANTY:** All products purchased from or supplied by Woodstock are subject to terms and conditions set out in the contract. Woodstock warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Woodstock is considered accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Woodstock makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.