

# Tech Tip # 1: Proper Mixing & Handling of Epoxies

Mixing and handling epoxies properly eases the application process and increases the chances of getting a good bond.

For all mixed systems, part A and part B should be mixed separately in their containers before being added out and mixed together. This remixes the fillers in the products which can sometimes settle.

After the products are mixed, weigh out the materials by their proper mix ratios. At least 2 grams of material should be weighed out each time the product is mixed. This will allow for a better mix ratio. If too little product is used, a slight mistake in the weights of A or B will have a larger effect on the entire mixture. One wants to keep the mix ratio +/- 5% on the original ratio. Once the product is weighed out, mix the material for 1-2 minutes in a clockwise fashion, and 1-2 minutes in counter-clockwise fashion. This will give the mixture a great homogeneous state, ready for application.

Proper storage of the materials is also necessary. Once the materials have been weighed, the jar lips should be wiped clean and the caps replaced. If the materials come in the same type of jars, make sure *not to mix the caps of the two jars*. This could cause the material to start to cure or gel within the lid threads, causing the jar to seal shut.

If the material has crystallized during storage, the jar needs to be placed in the oven to remove the crystals. Take the jar and place it in an oven set to 60°C. Make sure the cap is loosened, but keep it on the jar. Check the jar periodically to see if the crystals have all disappeared. Depending on the amount of material that has crystallized, it can take anywhere from 15 minutes to a few hours to remove all of the crystals. Once they are all removed, stir the contents before weighing out.

Hygiene is also important when working with epoxies. Most EPO-TEK epoxies are 100% solids, so there is no vapor coming off the material. It is still necessary to work in a well ventilated area. Also, wear proper gloves in order to reduce the risk of having a material touch your skin. Make sure to replace gloves often and keep work spaces clean.

Still have questions?

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