



Technical Sheet

STRUCTURAL ADHESIVE

Xepox 70.3 Gel

Standard for

Assembly of vertical structural elements and non-flat surfaces.

Thixotropic paste up to 10 mm.

Moderate temperatures.

General		Bicomponent RTC product, formulated as a structural adhesive with an epoxy base.	
Characteristics		Thixotropic paste, with solid loads - filler -, average reactivity, easy use, high adhesiveness against materials of different nature - wood, iron, steel, concrete, etc.; after polymerization, elevated adhesion and cohesion values.	
Employment		Bonding of horizontal and vertical surfaces of structural elements that are generally not flat, through pouring or application as a paste. Suitable for application in structural reinforcements with fiber or preformed metal materials.	
Application		Pourable and applicable as a paste. Thicknesses of up to 10 mm. Application temperature of 5 ÷ 40 °C and max relative humidity of 90 %.	
Provision	Canisters		
		Component a	2 liter canister
		Component b	1 liter canister
Conservation and expiration		The two separated components have a shelf life of at least 12 months, but they must be stored at moderate temperatures.	

Test characteristic	Reference regulation	Unit of measure	Values
Specific weight at 23 ± 2 °C	ASTM D 792-66	kg/dm ³	ca 1.90
Stoichiometric ratio by volume	-	A : B =	100 : 50
Pot life at 23 ± 2 °C for 150 cc	ERL 13-70	Minutes	60 ÷ 70
Working time of the mixture at 23 ± 2 °C	ERL 13-70	Minutes	30 ÷ 35
Coefficient of linear thermal expansion	ASTM D 696	°C ⁻¹	ca 9.5x10 ⁻⁵
Max glass transition	ASTM D 3418	°C	36
Compression breakage unit load	ASTM D 695	MPa	≥ 65
Flexion-traction breakage unit load	ASTM D 790	MPa	≥ 56
Traction breakage unit load	ASTM D 638	MPa	≥ 42
Cutting breakage unit load	ASTM D 732	MPa	≥ 38
Elastic modulus for compression	ASTM D 695	MPa	≥ 6800
Wood compliance (spruce) by extension	ASTM D 1870	Type of break	100% wood cohesion
Wood/iron flexion-traction breakage unit load		Type of break	100% wood cohesion
Shrinkage	ASTM D 2566	%	ca 0.18 x 10 ⁻³

The test values are obtained in the laboratory and are indicative of material usage, but do not constitute a guarantee.

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Application
outline

STRUCTURAL
ADHESIVE

Xepox 70.3

K	how it's composed
γ	what is its mixing ratio
👍	where it is applied
§	how to prepare the structure
B	what equipment
≈	what thicknesses
⌚	hardening time
O	how to protect yourself
#	where to dispose of waste

2 components

component A	2	Litres
component B	1	Litres

(by volume) A : B = 100 : 50

⇒ components have been packaged in pre-measured, ready-for-use quantities

For the gluing of components whose surfaces are to be fitted together and the gluing of structural reinforcements, such as grooved metal bars.

- remove any dust with an air blast or industrial vacuum
- remove grease and/or brush the metal
- dry if wet

Blend with a spatula after having thoroughly mixed the two separate parts. Alternatively, use utensils with a double helicoid mixer. Applicable by spatula.

approximately 1 ÷ 10 mm

Differs according to environmental temperatures. Use is not however recommended in environments with permanent temperatures below 10°C.

It is important to handle products with necessary precaution, wearing the proper protective gear.

Do not litter residue or empty containers but dispose of them in accordance with current regulations.

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