



Six10[®] Epoxy Adhesive

Technical Data Sheet

Specialty Epoxies Six10

General Description

WEST SYSTEM[®] Six10 Thickened Epoxy Adhesive is a pre-thickened, gap-filling epoxy with a smooth, non-sagging consistency that trowels easily—perfect for filling voids and making fillets. Six10 has a viscosity high enough to resist sagging but can still saturate and wet-out a surface without pre coating, thanks in part to a property called *shear thinning*. This property also enables it to wet out light to moderate weight reinforcing fabrics such as fiberglass and carbon fiber.

Six10 is packaged in a specially designed, self-metering cartridge. A unique piston inside the cartridge simultaneously dispenses the resin and hardener from separate chambers. The molded chambers and passageways accurately control the ratio and prevent the resin and hardener from contacting each other until they are outside the cartridge and pass through the 600 Static Mixer.

The Six10 Epoxy formulation is a good balance between the elongation and toughness of G/flex[®] and the strength and stiffness of our 105 Resin-based epoxies. It has a long open time which means the epoxy will stay workable for 42 minutes in the static mixer and before clamping is required—very practical for long or complicated assemblies. It is ideal for stitch and glue boat construction, fiberglass laminate repair and general bonding. It bonds to a wide range of materials including wood, metals, composites and masonry. Six10 is transparent with a straw yellow tint.

Handling characteristics

Mix viscosity (at 72°F) ASTM D-2393	Gel*
Pot life (100g at 72°F)	42 minutes
Working time (in static mixer)**	42 minutes
Cure to a solid**	5 to 6 hours
Cure to working strength	1 to 4 days
Minimum recommended temperature	50°F (10°C)

*Viscosity data for Six10 at various sheer rates is available on request.

**Epoxy cures faster at higher temperatures and in thicker applications.

Physical properties of cured epoxy

Specific gravity	1.18
Hardness (Shore D) ASTM D-2240	80.6
Compression yield ASTM D-695	9,690 psi
Tensile strength ASTM D638	6,440 psi
Tensile elongation ASTM D-638	7.9%
Tensile modulus ASTM D-638	3.71E+05 psi
Flexural strength ASTM D-790	11,300 psi
Flexural modulus ASTM D-790	3.51E+05
Heat deflection temperature ASTM D-648	127°F
Onset of Tg by DSC	127°F
Ultimate Tg	133°F

Storage/Shelf life

Store at room temperature. Keep cartridge plug in place when not in use to prevent contamination. With proper storage, resin and hardener should remain usable for several years.

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