## E-400 OL-30 Epoxy

**Epoxy used to fill plywood defects for overlay applications**

### DESCRIPTION

E-400 OL-30 Epoxy is a two-component polyamine hardened epoxy product specifically designed to repair defects in plywood prior to overlaying with phenolic impregnated papers (MDO & HDO). With the proper application, press cycle and temperature, production of overlaying boards can be made in one step. Although, E-400 OL-30 Epoxy can be mixed by hand, the use of specialized equipment on an assembly line operation is recommended. This product is designed to extend open time so that the epoxy can be worked in assembly before setting up. The set time is dependent on temperature and mass of epoxy. E-400 OL-30 is also free from the irritating odors of other products such as polyester and/or mercaptans.

### WHERE TO USE

- Assembly line in Industrial Applications
- HDO & MDO Plywood Applications
- Upgrading Dimensional Lumber
- Concrete Form Board Manufacturing

### FEATURES AND BENEFITS

- Automated Mixing or Hand Mixing
- Once Cured it can be Sanded, Drilled, Cut and Stained
- Applied in Hot Temperatures – heated press
- Outstanding Adhesion
- Moisture Resistant
- Crack and Shrink Resistant

### PACKAGING

- Cartridges
- 5-gallon pails
- 20-gallon fiber drums
- 55-gallon drums

### SHELF LIFE

6 months when properly stored.

### STORAGE

Store this product in a cool, clean, dry, shaded or covered environment above 45°F (7.2°C). DO NOT FREEZE.

### DURING USE

During use it is recommended to keep material between 80° - 90° F (27 – 32°C).

### TECHNICAL INFORMATION

#### TYPICAL PROPERTIES

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<th>Solids</th>
<th>100%</th>
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| Density – lbs./gallon (kg/Lt) | Part A | 10 (1.2) |
| Part B | 10 (1.2) |

| Viscosity - centipoise | Part A | 77°F (25°C) | 33,000 |
| Part B | 85°F (29°C) | 17,800 |

| Consistency | Thick Fluid |

| Pet Life – at 77°F (25°C) in 100 mls or ½ cup (varies with quantity and temperature) | 13-17 minutes |

| Color (other colors available upon request) | Brown |

| Hardness – Shore “D” (on fully cured material) | 70 |

### CURE TIME

Remember that E-400 OL-30 is exothermic when curing, so the larger the mass the faster it will cure. Thus a large amount of epoxy in one pile on the pallet will cure in a short time (generally 20-30 minutes) while epoxy spread to a thin film on a panel will take an hour to cure. The person applying the epoxy should not mix more than can be used in about 20 minutes.
APPLICATION

Automated Metering: It is recommended E-400 OL 30 Epoxy be applied by a specialized metering system engineered by Willamette Valley Company. Please contact your Willamette Valley Company representative for information on metering systems.

By Hand: E-400 OL 30 Epoxy is a thick fluid designed to flow into cracks, splits and voids. Mix in a cup or on a pallet using a piece of plywood or MDF approximately 18” X 18”. The correct proportions are one to one by volume. The user can be assured of correct proportions by using 2 identical cups to measure the volume to be mixed. When using a pallet place equal amounts of Part “A” and Part “B” on the pallet. To mix, we recommend a 2.5” to 3,” flexible putty knife. Mix by stirring and pressing the mixture. It is important that some downward pressure be exerted as it causes a more complete mix. To ensure complete mixing, scrape the epoxy off the pallet and gather into one pile in the center of the pallet, then continue mixing with side to side motions and downward pressure till the epoxy is one even color.

DO NOT USE additional hardener with the mix for the purpose of speeding up the cure time. Extra hardener has the opposite effect. It just slows down the cure time and softens the patch. Best results are achieved by mixing one to one by volume.

ADDITIONAL FEATURES AND BENEFITS

The E-400 OL 30 Epoxy can be used to repair numerous types of wood products such as:

- Filling defects in plywood prior to overlaying with MDO or HDO to make concrete form boards
- Upgrading dimensional lumber and plywood
- Filling defects in laminated beams
- Correcting imperfections in fir and cedar siding
- Repairing unrouted plywood defects up to 1.5”
- Repairing routed plywood defects up to 2.25”
- Fixing defects in molding and furniture
- Use in construction or repair of wooden boats

Part “A” and Part “B” of E-400 OL 30 Epoxy have similar viscosities and therefore accommodate easy mixing.

Under rigorous tests conducted at mills and in the laboratory, E-400 OL 30 Epoxy performs as well as a matching wood repair. The formula ingredients of this quality product assure outstanding adhesion and resistance to cracking and shrinking.

HEALTH AND SAFETY

Before handling, you should become familiar with the Material Safety Data Sheet (MSDS) regarding the risks and safe use of this product. To obtain an MSDS please call 800-333-9826 or send an email to: msds@wilvaco.com.

CLEAN-UP

Use soap and water before the material solidifies.

CONTACT INFORMATION

Please see the side bar on the front page for the Division nearest to your location.

DISCLAIMER OF WARRANTY

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EACH USER SHOULD CONDUCT A SUFFICIENT INVESTIGATION TO ESTABLISH THE SUITABILITY OF ANY PRODUCT FOR ITS INTENDED USE.

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