



## Two Part PU Modified Hybrid Epoxy Adhesive

**TRUBUILD EFX 666** is two component PU modified hybrid epoxy adhesive for high performance and high adhesion for fixing tiles with no vertical slip-on deformable substrates. It is suitable for metal, plywood, cement board and dry wall construction. Designed for absorbent and non-absorbent substrates.

It Complies to EN 12004:2017 "R2T", "Type-5" TS2 as per IS 15477:2019, CFTRI approved.

### APPLICATION AREAS

- Laying of ceramic tiles, porcelain tiles, marble and natural stone, on floors and walls, on absorbent and non-absorbent, deformable substrates
- Fixing Porcelain tiles- low thickness slabs, ceramic tiles, clinker Bricks, glass and ceramic mosaic, natural stone, marble, granite and recomposed materials & wood, metals, rubber, linoleum Internal and external flooring and walls, in domestic, commercial and industrial applications
- Suitable for Fixing metal sheet used for prefabricated bathrooms, on work sops and kitchens, balconies, terraces, flat roofs and domes
- Can be used for fixing tiles in swimming pool and water fountains.

### ADVANTAGES

- Versatile: Floors and walls, for internal and external use
- Extended open time up to 1 hr
- Suitable for variety of substrates viz. porcelain tiles, dry wall boards ceramics, large formats, low thickness slabs and natural stone
- Ideal for marble and natural stone that tends to form stains and sag in the presence of humidity
- Easy in application
- CFTRI approved

### SURFACE PREPARATION AND APPLICATION

Substrate must be free from dust, oil, algae fungi, efflorescence and grease, rising dampness, with no loose, flaky, or imperfectly anchored parts. The substrate must be sound, without cracks and have already completed 28 days curing period of hygrometric shrinkage. Uneven areas must be treated with suitable Polymer modified mortar & concrete. TRUBUILD EFX 666 is prepared by mixing together parts A and B from the bottom upwards, using a low-rev ( $\approx 400$ /min.) helicoidal agitator, respecting the pre-set ratio of Part A: Part B:: 4:1, (by weight) of the packs. Pour part B into the bucket containing part A, being careful to mix the two parts uniformly until a smooth, even coloured mixture is obtained (Minimum 5-7 minutes mixing).

The user must mix quantity of adhesive which can be consumed within 1 hour at  $+27^\circ\text{C}$  / 65% R.H. TRUBUILD EFX 666 must be applied with a suitable notch trowel, using the smooth part of the spreader, apply a fine layer of product, pressing down on the substrate in order to ensure maximum adhesion. Press down each tile to allow for maximum coverage of the surface. If the substrate is subjected to heavy traffic, in external applications and wherever high-elasticity laying system is required, use the double-spread technique to ensure 100% application of the product to the rear of the tiles. For vertical application it will be ideal to use initial supports as per standard construction practice to hold the tile in its original alignment.

**NOTE-1.** For fixing any plastic / metal / polymer sheets / or any material a patch test is advisable to ensure proper bonding with the substrate before going for the larger application.

**NOTE-2.** Ensure entire tile coverage of chemical ,consumption may vary as per texture, porosity and undulation of substrate.

### TECHNICAL DETAILS

PROPERTIES	STANDARDS	RESULT
Mixing Ratio	-	4:1: Part-A(Resin): Part-B(Hardener) pbw
Appearance	-	Opaque-white paste
Mixed Density of Wet Mix,gm/ml @27 $\pm 2^\circ\text{C}$ Temperature And 65 $\pm 5\%$ RH	-	1.35 $\pm$ 0.10
Pot life (Hr) @27 $\pm 2^\circ\text{C}$ Temperature And 65 $\pm 5\%$ RH	EN 12004-2017/IS 15477-2019	$\geq 1$ Hr
Open time(Hr) @ 27 $\pm 2^\circ\text{C}$ Temperature And 65 $\pm 5\%$ RH	EN 12004-2017/IS 15477-2019	$\geq 1$ Hr
Vertical slip	EN 12004-2017/IS 15477-2019	$\leq 0.5$ mm
Foot traffic	-	Min. After 24hr
Grouting	-	Min.12hr on wall and 24 hr on floor
Interval before normal use	-	Min. 3 days
Shear adhesion after 7 days Dry Condition	EN 12004-2017/IS 15477-2019	$\geq 6$ N/mm <sup>2</sup>
Shear adhesion water immersion	EN 12004-2017/IS 15477-2019	$\geq 5$ N/mm <sup>2</sup>
Shear adhesion after thermal shock	EN 12004-2017/IS 15477-2019	$\geq 6$ N/mm <sup>2</sup>
Tensile Adhesion to concrete	EN 12004-2017/IS 15477-2019	$\geq 2.5$ N/mm <sup>2</sup>
Deformability	IS 15477-2019	$\geq 5$ mm

### THEORETICAL COVERAGE

2-4 kg/m<sup>2</sup> for 1.5 mm to 3 mm bed thickness

**NOTE:** Coverage will vary depending on substrate smoothness and evenness.

### CURING

Allow curing for 24 hr before foot traffic and other work like Grouting between the tile.

# TRUBUILD EFX 666

TECHNICAL DATA SHEET  
VER NO. 1.6



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### LIMITATION & PRECAUTIONS

Strictly keep to the mixing ratio of Part A: Part B:: 4 : 1, (by weight). For partial mixing, weigh the two parts precisely - workability times may vary considerably, depending on environmental conditions and the temperature of substrate and environment. Protect against direct rain for at least 12 hrs after application. Do not lay on substrates subject to moisture rising or which are not completely cured. Before application the substrate should be completely dry condition. Avoid application during rain open to sky. For any special application, please seek the advice of Trubuild Technical service Team.

### CLEANING

Trubuild EFX 666 can be removed from tools and equipment immediately after use with thinner, hardened material can be removed mechanically.

### SHELF LIFE

24 Month from the date of manufacturing, Store in a cool & dry place in temperature +10 °C to +35 °C in unopened condition in its original packing and keep away from direct sunlight/Rain.

### HEALTH & SAFETY INSTRUCTION

- Use mask, nose cover and hand gloves during application.
- Epoxy Resin may cause irritation when it will come into contact of the skin. Hence During application avoid contact with skin and eyes.
- If it comes into contact with skin accidentally then use suitable resin removable cream and then wash the area with soap and water. If irritation continuous then seek medical help.
- In case of contact with eyes rinse it with clean water and seek immediate medical help.
- If swallowed accidentally then take immediate help of medical professional. Do not induce vomiting without advice of any Medical Doctor.
- For more safety related information about the material please refer Material safety data sheet.

### PACKING

4 kg pack

**IMPORTANT:** This technical data sheet replaces all previous versions of it from the immediate effect. The information, and, in particular, the recommendations relating to the application and end-use of Astral Limited construction chemical products, are given in good faith based on our knowledge and experience of the products when properly stored, handled and applied under suitable favourable conditions in accordance with Application instructions recommended in Product Technical Data sheet. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. For the products on which company is offering warranty, please refer to warranty document to know entire terms and conditions. The same can be availed on request or from company website. The values mentioned in the above tables in technical data sheet are obtained in controlled lab conditions when tested properly by competent laboratory. Tolerance up to five to ten percentage on the lower side from the above values are allowable as per standard. Astral Limited. reserves the right to change the properties of its products. The end user of the product must test the product's suitability for the intended application and purpose. Astral Limited will not bear any responsibilities on the product failure if it is wrongly positioned or if improper application methodology adopted by the user or the applicator. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request. No freedom from any patent owned by Seller or others is to be inferred. Because use conditions and applicable laws may differ from one location to another and may change with time, Customer is responsible for determining whether products and the information in this document are appropriate for Customer's use and for ensuring that Customer's workplace, and disposal practices are in compliance with applicable laws and other governmental enactments.



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