



ES6323 Epoxy Adhesive & Patching Compound

DESCRIPTION

WYN-STIK ES6323 is a reddish-brown, two component chemical resistant epoxy system designed for use as an adhesive for clay pipe, concrete and other structures. ES6323 is a two component liquid system which forms a non-sag thixotropic paste consistency upon mixing. This feature allows easy mixing and applying by automatic dispensing equipment, and good resistance to sag once applied. ES6323 is a 100% solids compound, and the cured material has very good resistance to water and chemicals. It is also very resistant to attack by corrosive fumes and sewer gases.

TYPICAL APPLICATIONS

ES6323 has been used extensively for patching holes in damp or dry concrete and vitrified clay products. It is also regularly used to bond these products to each other. The bond produced by ES6323, when properly applied and cured, will be stronger than the material it is bonding.

PRODUCT SPECIFICATIONS

	ES6323 A	ES6323 B	ASTM Method
Color	Off White	Reddish Brown	Visual
Viscosity, centipoise	Thin Paste	Jelly	D2392
Specific Gravity, gms./cc	1.59	1.18	D1475
Mix Ratio	100 : 8.5 By Weight 100 : 11.5 By Volume		PTM&W
Pot Life, 4 fl. Oz. Mass @ 77°F	30 - 45 minutes		D2471

DIRECTIONS FOR USE

PREPARATION: All surfaces to be patched or bonded must be free of oil, dirt and grease. Refer to “WYN-STIK Surface Preparation Guidelines” bulletin for specific recommendations for various surfaces.

MIXING and APPLICATION: Mix A and B components at the proper ratio until uniform in color and consistency. Mix for 1 to 2 minutes, scraping the sides and bottom of the container to avoid leaving unmixed material that will cause soft spots in the cured product. After mixing, ES6323 must be used within 30 minutes. If using automatic meter-mix equipment, warming the ES6323 Part A to 100°F to 120°F is necessary to reduce its viscosity to a pumpable liquid state.

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TYPICAL MECHANICAL PROPERTIES

	ES6323 A/B	ASTM Method
Mix Ratio	100 : 8.5 By Weight 100 : 11.5 By Volume	PTM&W
Pot Life, @ 77°F	30 - 45 minutes	D2471
Color	Reddish Brown	Visual
Mixed Viscosity, @ 77°F, centipoise	Non-Sag Paste	D2393
Cured Hardness, Shore D	90 Shore D	D2240
Specific Gravity, grams, cc	1.55	D1475
Density, lb./cu. Inch lb./gallon	.0560 lb./cu. inch 12.9 lb./Gallon	D792
Specific Volume, cu. in./lb.	17.9 cu. in./lb.	D792
Tensile Strength, psi	9,500 psi	D638
Elongation at Break, %	4 %	D638
Aluminum to Aluminum Tensile Lap Shear Strength	1,200 psi	D1002
Compressive Shear Strength Clay to Clay Bonded Specimens	2,000 psi (Clay Breaks)	PTM&W

PACKAGING WEIGHTS

	17 oz. Kit	1/4 Drum Kit	Drum Kit
ES6323 Part A	1 lb.	170 lb.	518 lb.
ES6323 Part B	38 grams	16 lb.	49 lb.
Kit	1.08 lb.	186 lb.	567 lb.

ES6323 Bulletin / ZW-38 / 011504-C1



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