

Starbond 30-Minute Toughened Epoxy Pro Kit — toughened two-component epoxy adhesive

Document TDS2026-1006-02	Issued 6 October 2026	Version 0 · EN
Mixing ratio 1 : 1 by volume	Working time 30-35 min	Full cure 12 h

1. Identification

Item	Detail
Trade name	Starbond 30-Minute Toughened Epoxy Pro Kit
Type	two-component epoxy adhesive, toughened (part A resin + part B hardener)
Manufacturer	Starbond, 1450 W. 228th St., Suite 11, Torrance, CA 90501, USA
Country of origin	Taiwan
Importer for the Czech Republic	RESIN TABLE s.r.o., Dr. Stojana 351, 765 02 Otrokovice, Czech Republic
Pack size	236 ml — part A 118 ml + part B 118 ml, non-stick mixing palette and spatula

2. Description and intended use

Standard epoxy cures hard and brittle and cracks on impact. Thanks to its **polyaminoamide hardener** this adhesive cures strong and at the same time **slightly flexible** — the bond absorbs impact and vibration instead of breaking under it. **30-35 minutes of working time** leave room to seat, align and clamp even a complex multi-part assembly.

- knife handles — bone, G10, micarta or wood onto a steel tang
- golf clubs and fishing rods — shaft into hosel, cork onto blank
- musical instruments and lutherie — braces, repairs
- structural woodworking joints and multi-material assemblies

Bonds: wood, metal, glass, ceramic, concrete, fabric. The manufacturer does not recommend plastics and rubber without a prior test on a sample.

3. Technical data

Parameter	Value
Mixing ratio	1 : 1 by volume (A : B)
Mixing time	60-90 s, until uniform
Working time	30-35 min
Handling strength	7-10 h (room temperature)
Full cure	12 h (room temperature)
Bond strength	47.6 MPa (6,898 psi) — verified by a TAF-accredited laboratory
Hardener	polyaminoamide — toughened, slightly flexible bond
Colour when cured	light amber, clear in a thin bond line; non-yellowing
Bonds	wood · metal · glass · ceramic · concrete · fabric
Limitations	plastics and rubber only after a test on a sample

Source: Starbond product sheet. Times apply at room temperature.

! The 1 : 1 ratio is by volume — not by weight

The two parts have **different densities** (relative density of the resin 1.16–1.18, of the hardener 0.97 — see section 4). Equal grams of A and B would therefore shift the ratio towards the hardener. **Measure equal volumes**, not equal weights. An inaccurate ratio leaves a permanently tacky, under-cured bond.

i Temperature drives the speed

The stated times apply at room temperature. **Cold slows the cure**, warmth speeds it up. Bond and cure in a heated room — in a cold workshop the joint may stay tacky longer than the values in the table.

4. Physical properties of the components

Property	Part A — resin	Part B — hardener
Physical state	liquid	liquid
Odour	odourless	ammoniacal
Relative density	1.16–1.18	0.97
Melting / freezing point	–16 °C	—
Boiling point	320 °C	—
Flash point	266 °C	234 °C
Solubility in water	6.9 mg/l	insoluble

Source: safety data sheets, version 2 of 6 October 2026 (A) and 5 October 2026 (B), section 9.

5. Processing

- **Prepare the surfaces.** Clean, dry, free of grease. Lightly abrade smooth metal or glass.
- **Dispense equal volumes** of part A and part B into the mixing palette. Do not swap the caps and do not mix the parts inside the bottles.
- **Mix for 60–90 seconds**, slowly with the spatula, until the mix is uniform and streak-free.
- **Apply and assemble within 30–35 minutes** — seat, align and clamp.
- **Let it cure** at room temperature: handle after 7–10 hours, full bond strength after 12 hours.

Cleaning of tools: wipe off uncured adhesive immediately; once cured it can only be removed mechanically.

6. Safety

Both parts are classified as hazardous. **Read the safety data sheets before use**; they are available for download with the product.

	Part A — resin	Part B — hardener
Classification	Skin Irrit. 2 · Skin Sens. 1 · Eye Irrit. 2 · Aquatic Chronic 2	Skin Irrit. 2 · Eye Dam. 1 · Aquatic Chronic 2
Pictograms	GHS07 · GHS09	GHS05 · GHS09
Signal word	Warning	Danger
Hazard statements	H315, H317, H319, H411 · EUH205	H315, H318, H411
UFI	7D1X-N8GJ-700C-4743	991X-48T4-W00U-GVJ1

Source: safety data sheets, sections 2.1 and 2.2.

Wear protective gloves and eye protection. **The hardener causes serious eye damage** — in case of contact rinse the eyes with water for several minutes and seek medical advice. **The resin is a skin sensitizer**: repeated contact may cause a lasting allergy. Wash your hands after work. Keep out of reach of children.

7. Storage and disposal

- Store in a cool, dry place with the bottles tightly closed.
- Uncured parts and contaminated packaging are hazardous waste — do not pour into drains; they are toxic to aquatic life.
- Mix residues at 1 : 1 and let them cure; cured adhesive is disposed of under local regulations.

The information reflects the manufacturer's documentation at the date of issue of this sheet. It is not a legally binding assurance of properties; processing conditions are beyond our control. Carry out your own trial before production use.