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## **G-2 Epoxy Adhesive**

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### **Description**

System Three G-2 is a two-component, epoxy/polyamide adhesive. For decades, G-2 has been a premium adhesive for oily or acidic hardwoods such as oak, teak, mahogany, Ipe, Iroko, Meranti, as well as any other wood which is difficult to glue. Use G-2 for both interior and exterior applications as well as below the waterline. It is also a great all purpose adhesive for other woods, metal, ceramic, glass and many non-polyethylene based plastics. G-2 can be mixed in small or large batches, has a long pot life and cures overnight. After fully curing it can be machined, drilled, sanded and tapped.

Marine Use - G-2 is well suited to stitch-and-glue, strip planking, and cold molding. Or any other laminating project. Can be mixed with wood flour, anti-sag powders, micro-fibers, micro-balloons, or sand, to make marine fillers, gels, putties, fairing compounds, and grout.

Construction - Use for making strong structural joints and laminations. G-2 can be used for laminated wood beams, doors, windows, mill-work, furniture, cabinets, window frames, archery bows, or wooden tools.

### **Packaging**

G-2 is available in the following sizes 12 oz., 1.5 Pint, 1.5 Gallon units.

### **Application**

The most common error is incomplete mixing. Please mix thoroughly, being sure to scrape the sides and bottom well while mixing. Hand mixing is best, as this introduces less air bubbles into the mix. Any suitable container can be used, but we prefer plastic paint containers. These do not break, and any leftover mix can be popped out after it cures.

Apply G-2 by any convenient method. Usually we apply it using chip brushes. These are cheap, natural bristle brushes available from us, or at any quality hardware or home improvement store. Notched trowels, rollers or putty knives can also be used to apply over larger areas.

Normal coverage is approximately 45 sq. ft. per gallon at 1/32" (4.1 sq. m. per 3.8 liters at 0.8 mm.). This is the minimum recommended amount to get a strong glue joint. Any less, and there is a risk of not having enough glue in the joint, commonly referred to as "starving the joint". When bonding rough surfaces it is often necessary to use much heavier applications of glue to avoid starving the joint. In these cases, coverage will be reduced by half or more. Don't over clamp the joint.

## Tips and Techniques

It is best to avoid using solvents to "clean" hardwoods before gluing. The wood can absorb the solvent and compromise the integrity of the glue joint. Scuff sanding and careful removal of sanding dust with vacuum or brush is recommended. Removal with tack rag or solvent wipe might cause problems.

For best results, G-2 Epoxy should be applied to both surfaces to be glued and allowed to sit long enough for the wood to soak up as much as it will, so that when the pieces are assembled the wood will not absorb the glue that would otherwise fill the gaps between the pieces. This is especially important with end grain applications.

Scarf and butt joints are especially prone to soaking the glue out of the joint as it wicks into the end grain of the wood. Edges of plywood are notorious for soaking up liquids. Allow the glue to sit on exposed end grain or wood of exceptional roughness for at least 10 minutes before assembly. If after the 10 minute wait the joint is not "wet" with the glue, add more G-2 before butting the joint for the bonding process.

When clamping glue joints, be careful not to over-tighten the clamps. Over-clamping will force the glue out of the joint. The minimum clamping force to hold the pieces in good contact is all that is required.

G-2 Epoxy Adhesive also makes a fine filler for open joints that need to be closed to the weather.

**NOTE: If you want to use penetrating epoxy such as the S-1 Sealer, please do so AFTER bonding with G-2 Epoxy Adhesive, or lightly sand or scuff the treated surface if S-1 Sealer has been applied.**

## Properties

<b>RESIN PROPERTIES</b>	
Viscosity	@ 77°F (25°C) 5000 cps
Density	9.6 lb/gal
Color	Water-white
<b>HARDENER PROPERTIES</b>	
Viscosity	@ 77°F (25°C) 5000 cps
Density	8.0lb/gal
Color	Amber
<b>MIXED SYSTEM PROPERTIES</b>	

Mix ratio by volume resin/hardener	100:50
Mix ratio by weight resin/hardener	100:44
Mixed viscosity	5500 cps
Mixed Color	Light Amber
Application Temperature Range	50°F to 102°F (10°C to 32°C)
Tensile Strength	6,000 psi
Compressive Strength	12,000 psi
Elongation	11%
Coverage	@ 250 microns (10 mils) 150 ft per square gallon (3.6 m per square liter)
Maximum Service Temperature	-4°F to 160°F (-20°C to 72°C)
Gel Time	@ 77°F (25°C) 90 Minutes (100g mixture)
Full Cure	@ 77°F (25°C) 48 Hours (100g mixture)

***ALWAYS MIX THOROUGHLY!  
IMPROPER MIXING IS THE GREATEST CAUSE OF EPOXY SYSTEMS FAILURE.***

**G-2 Epoxy Adhesive is a hazardous product. Check the [shipping options](#) page for details on shipping hazardous items. For additional information refer to the [G-2 Safety Data Sheet](#).**

## PDF Documents

You will need a PDF reader to view these links, you can download Acrobat Reader for free from [Adobe's website](#).

Safety Data Sheets: [Part A](#) and [Part B](#) (both parts are needed, they are separate sheets)

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**All products ship within 2 business days from both coasts!**  
**Our business hours are 6:30 AM to 5:30 PM Pacific Time, Monday–Friday.**

**Tech support is available over weekends and holidays.**

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