

TWEHA® PREFIX X-TRA REMAINS STICKY? HERE ARE THE CAUSES AND SOLUTIONS

TWEHA® PreFix X-tra is engineered to provide a strong, durable, and reliable bond. When processed correctly, the adhesive delivers excellent mechanical performance and long-term durability.

TWEHA® PreFix X-tra can be processed well in advance and we therefore you are able to follow our recommendation to carry out the application as much as possible in a conditioned circumstance.

If the product remains sticky or tacky after curing, one or more application factors may have affected the curing process.

The Most Common Causes

1. Incorrect Mixing Ratio

For complete curing, the resin and hardener must be mixed exactly according to the prescribed ratio. Even a small deviation can prevent part of the epoxy from reacting fully, resulting in a soft or sticky surface.

2. Insufficient Mixing

Using the correct ratio is only part of the process. The two components must also be mixed thoroughly until a completely homogeneous mixture is achieved. Unmixed material remaining on the sides or bottom of the mixing container can cause localized curing issues.

3. Temperature Too Low

The curing reaction of epoxy adhesives is temperature dependent. Curing time or drying time is partly determined by the ambient temperature. Ideal is about 18-20 °C. (65 °F.). At a lower temperature it is still possible to work fine, but the curing process slows down significantly and may even stop partially. As a result, the adhesive can remain soft or tacky for longer than expected.

We recommend not to process these products at a temperature below approx. 5 °C. (41 °F.).

4. Surface Contamination

Grease, oil, silicone, dust, or moisture on the substrate can negatively affect both adhesion and curing performance. A clean, dry, and properly prepared surface is essential for achieving optimal results.

Still Sticky After 24–48 Hours?

First, check the ambient temperature. If possible, increase the temperature to approximately 20–25°C (68–77°F) and allow an additional 24 hours for curing. In many cases, the curing process will continue and reach full performance.

Only the Surface Feels Sticky?

This may be caused by *amine blush*, a thin wax-like film that can sometimes form during the curing process. This layer can be easily removed using warm water and a non-abrasive scouring pad or Scotch-Brite™ pad.

Is the Entire Adhesive Layer Still Soft or Tacky?

In this case, the most likely cause is an incorrect mixing ratio or insufficient mixing of the components. Unfortunately, full curing is usually no longer possible. The uncured epoxy should be completely removed before a new application is made according to the recommended processing instructions.

Prevention Is Better Than Repair

By carefully measuring the components, mixing thoroughly, working within the recommended temperature range, and ensuring proper surface preparation, TWEHA® PreFix X-tra will deliver the performance it was designed for: a strong, durable, and dependable bond you can trust.

If you have any questions about the application of TWEHA® PreFix X-tra or require technical support for a specific project, the TWEHA® technical team is ready to assist.

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