

### Description

Two parts epoxy based adhesive, high viscosity, solvent free, curing either at room temperature or at high temperature. Suitable to bond metals, ceramics, wood, rubber, foams and many plastics. It forms elastic and semi-rigid joints according to the mixing ratio with its hardener.

It provides good mechanical resistance under static or dynamic loads and provides semi-transparent joints with electrical insulation.

### Physical properties

Related to product extruded through the proper mixer nozzle

	Part A	Part B
Composition :	epoxy resin	amine
Colour :	colourless/transparent	amber
Viscosity (+25°C - Pa s) :	50 - 100 thixo	10 - 25
Specific weight (g/ml) :	1.13	1.02
Flash point		
(Pensky.Martens) :	+210°C	+90°C
Shelf life :	1 year in original unopened packaging at +5°/+25°C	

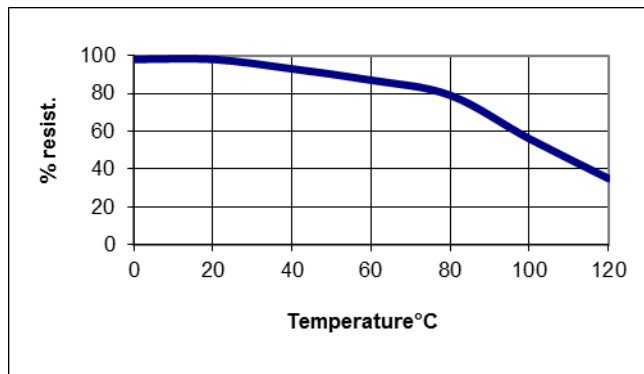
### Curing properties at +25°C (typical)

Temperature range :	-60°C +120°C
Shear strength (ISO 4587) :	10 - 20 N/mm <sup>2</sup>

### Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel - ISO 4587



### Mixing ratio (by weight)

Resin 36T :	100
Hardener 10 :	50

### Implementation

By trowel, by short bristles brush or mechanically by mixing-metering equipment.

### Properties

Simple mixing ratio, curing w/o emission of volatile substances and with no product shrinkage, at temperatures from +20°C to +100°C.

### Pot-life for 100g of product

Temperature	
+20°C	120 minutes
+30°C	90 minutes

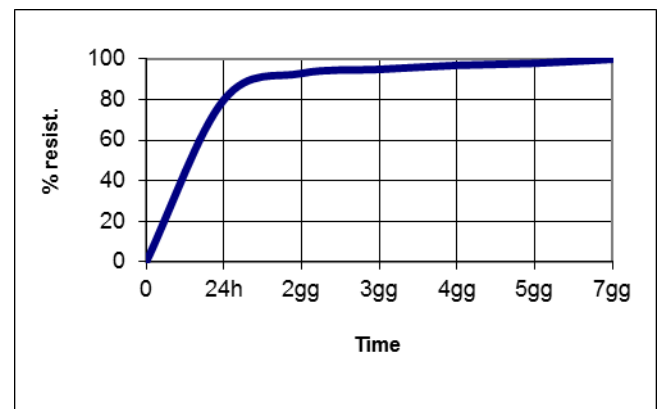
### Adhesive consumption

The consumption expected for medium depth bonding is ab. 200g/m<sup>2</sup> of mixture.

### Strength developed in time

The graph below shows the mechanical strength of the product (in %) in time.

Steel specimen - ISO 4587



### Directions for use

#### 1. Surfaces preparation

For best results we recommend to scratch the surfaces with a tool and then to degrease and clean with Loxeal Cleaner 10 or Acetone and let dry for a few seconds.

#### 2. Mixing

The resin and the hardener need to be mechanically mixed before use in the ratio of weight and/or volume in compliance with technical specifications until a homogeneous colour is reached. Products are available in dual cartridges with static mixers (provided separately) allowing a direct and correct product application on the substrates to bond, completely discarding the first 3/5 cm of the extruded product. Avoid excess of product blend because heating produced by chemical reaction may cause risk and loss of product.

#### 3. Pot life

Pot life of the mixed product may vary from few minutes to some hours at room temperature according to the resin and the hardener used. Higher temperature reduces the pot life. Apply product at temperature higher than +15°C.

#### **4. Assembly**

Parts to be bonded shall be assembled immediately after product application and kept close until full polymerization without providing any mechanical stress.

#### **5. Cleaning**

Excess of product can be removed with Acetone or any other solvent based cleaner compatible with the substrates to bond. Application tools and dosing systems shall be cleaned before the product is hardened. Cured product can be removed only mechanically.

#### **Storage**

Keep product in a cool and dry room at no more than +25°C. To avoid contaminations do not refill containers with used product. For further information on applications, storage and handling contact Loxeal Technical Service

#### **Safety and handling**

Consult Material Safety Data Sheet before use

#### **Note**

The data contained herein, obtained in Loxeal laboratories, are given for information only; if specifics are required, please contact Loxeal Technical Department. Loxeal ensures abiding quality of supplied products according to its own specifics. Loxeal cannot assume responsibility for the results obtained by others which methods are not under Loxeal control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Loxeal disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loxeal products. Loxeal specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.