

BOSTIK ARALDITE® 2012 EPOXY ADHESIVE

TWO COMPONENT, RAPID, MULTIPURPOSE ADHESIVE

ARALDITE® 2012 EPOXY ADHESIVE is a two component, rapid multipurpose adhesive which cures at room temperature to give tough, high strength bonds. After mixing the two parts, the adhesive remains workable for up to about 5 minutes, depending upon the amount mixed and temperature.

The cured, thin - layer adhesive is transparent and shows good resistance to most commonly used solvents. ARALDITE® 2012 EPOXY ADHESIVE is manufactured by CIBA Specialty Chemicals, world leaders in epoxy resin adhesives.

RECOMMENDED USE

ARALDITE® 2012 EPOXY ADHESIVE will bond a wide variety of materials in common use including metals, ceramics, glass, vulcanised rubbers and rigid plastics to themselves and each other. A versatile adhesive, it has many industrial and craft applications.

IMPORTANT: ARALDITE® 2012 EPOXY ADHESIVE is not suitable for bonding rear-view mirrors to car windscreens. Do not use for items which may contain food or drink, as the joint, however secure and clean it may appear, may entrap bacteria from the environment. Not intended for repairs on safety critical items e.g. rotating parts of hover mowers.

BONDING INSTRUCTIONS

1. Ensure the surfaces to be bonded are dry clean and free from grease and dust. For maximum bond strength, mechanically abrade then degrease both surfaces. Chemical pre-treatment may be necessary for some substrates e.g. polypropylene.
2. On first use, remove each cap and carefully replace reversed so as to pierce the metal membrane on each tube. Apply equal volumes of resin and hardener onto a clean disposable surface. A plastic tube key is provided with each tube for controlled delivery of large volumes. Replace the correct colour coded cap on the individual tubes when not in use.
3. Mix the two parts together thoroughly for 15 seconds using the reusable plastic spatula/spreader provided.
4. Apply the mixed adhesive immediately to both surfaces of the joint and assemble carefully. A layer 0.05 to 0.10 mm thick will normally give the best results. Clamp as soon as the adhesive has been applied.
5. Keep the joint supported for at least 10 minutes at room temperature, maintaining an even contact pressure for an optimum cure. Allow at least 1 hour before rough handling. Refer to the leaflet in the box for minimum cure times at different temperatures. **Do not cure at temperatures lower than 20°C as this may result in weak joints.**
6. For a neat finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

CLEANING: Bostik Cleaner/Thinner A (M574) acetone based

Do not use alcohol, petrol or paint thinners (such as white spirit) for degreasing purposes.

Clean tools with soap and hot water before residues of adhesive have cured, then dry before putting away. Once cured, removal of the epoxy from metal tools in particular will be extremely difficult.

The adhesive may be removed from the skin using a proprietary hand cleaner. Contact with the skin should however be avoided. Do not use solvents in contact with the skin.

Always open and use adhesive products over a protected surface, and avoid contact with clothing.

PACKAGING: Code: 95591 2x150G tubes 12 per box

HEALTH & SAFETY Available separately in files named as the packaging code above.

SHELF LIFE: 3 years if stored as directed below

STORAGE & TRANSPORTATION: Store under dry conditions between 5°C and 25°C.

TYPICAL ADHESIVE CHARACTERISTICS

	<u>Resin</u>	<u>Hardener</u>
Physical form:	Liquid	Liquid
Chemical type:	Epoxy Resin	Formulated polyamine
Viscosity:	Slow flowing	Slow flowing
Solids content:	100%	100%
Colour:	Colourless	Pale yellow
Density (SG):	1.17	1.16

TYPICAL PERFORMANCE CHARACTERISTICS

Cured Density (SG)	1.16 approximately.
Temperature:	-50°C to +65°C depending on conditions of use
Water:	Not intended for constant immersion
Oil & Petrol:	Good resistance.
Chemicals:	Good resistance. Excepting ethanoic acid.
Adhesion to metals:	Typical bond strengths 12 – 28 MPa at 23°C depending on metal. Substrates sand blasted before bonding. Cured 16 hours at 40°C before test
Sandability:	Sandable when set. Please wear dust mask.
Paintability:	Good, but confirm by test. Fine sanding helps.

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^a ARALDITE is a registered trademark of Vantico, Basel, Switzerland.

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