

# 50ml Epoxy Adhesive Cartridge



RoHS  
Compliant

## Description

The product is a very fast curing multi-purpose epoxy adhesive. It has been designed for bonding sealing and structural support. This is a rapid curing material with excellent adhesion to many substrates

Properties	Result	Unit
Hardness	75 - 80	Shore D
Dielectric strength (2mm)	20	kV/mm
Tracking Resistance (CTI)	>600	V
Dielectric constant	4.1	50Hz
Volume Resistivity	15 <sup>10</sup>	Ω.cm
Dielectric loss factor Tan delta	0.8	50Hz
Temperature resistance	-55 to +100	°C (application and geometry dependant)

Physical Data (approx. – values)	Resin	Hardener	Mixed
Colour	Clear	Amber	Clear Amber
Specific Gravity	1.16	1.13	1.15
Viscosity (mPas) @ 25°C	11500 - 20000	30000	27000

Mix ratio by weight 1:1  
Mix ratio by volume 1:1

## Lap Shear Adhesion

Pre-treatment Abrasion with 300 grit emery and solvent wipe

Aluminium to Aluminium	14 MPa	PVC to PVC	4.6 MPa
Copper to Copper	9 MPa	Nylon 6 to Nylon 6	2.3 MPa
Stainless Steel	13 MPa	Acrylic to Acrylic	3.2 MPa

## Cure Schedule (50ml)

	Working Life	Gel Time	Light Handling	Full Cure
Temperature	(minutes)	(minutes)	(hours)	(hours)
2g mass @ RT	3	5	60	12
10g mass @ RT	>2	2-5	10	6
100g mass @ RT	>2	2-5		

\*RT is defined as 20-25°C

The above are typical values and will vary depending on the cured mass and application. The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. For maximum properties a post cure may be required

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## Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened.  
Use a suitable non-flammable cleaning agent.

## Storage and Shelf Life

12 months at 25°C.

Cartridges should be stored horizontally

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50°C) aggravate this phenomenon. Heating the individual component to 50 to 60°C while stirring can usually restore products to original state. Storage at 25 ±10°C is optimum for most products. Some epoxy systems are prone to settling due to high filler content and should be inverted every two to three weeks to reduce the accumulation of the fillers on the bottom of the containers.

Inventory should be rotated on a FIFO (first in, first out) basis.

It is essential for best results that the cartridge is 'balanced' before use to ensure correct mixing.

Loading the cartridge into the gun before attaching the mixer element and pumping the gun to push a small amount of the contents forward will achieve this. Wipe the excess from the cartridge tip and add the static mixer.

## Part Number Table

Description	Part Number
50ml Epoxy Adhesive Cartridge	MC001839

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