

Description

This is a two-part product. Fast curing adhesive formulated for toughness.

The product is ideal for gap filling and vertical applications due to the high viscosity. This is used in a number of applications including Battery manufacture and automotive assembly. This unique system can offer excellent tensile and impact strength, even without priming the surface. The advanced macro structure provides the bonded assembly with excellent environmental and chemical resistance in the most demanding applications.

Properties	Result	Unit
Appearance	Thixotropic Gel	
Colour	Yellow/White	MMA
Open Time (@ 20°C)	7	Minutes
Gap Fill	Up to 4	mm
Hardness	75	Shore D
Temperature Range	-50 to +120	°C
Specific Gravity	0.97	g/ml
Viscosity Brookfield T Bar	120000 - 150000	cps
Cure System	Exothermic	
Handling Strength (@ 20°C)	12	Minutes
Flashpoint	11	°C
Shrinkage (after 7 days)	5	%
Elongation at break	2.4	%
Lap shear (ASTM D1002)	Up to 30	Nmm ²
Tensile Strength (ASTM D638)	Up to 30	Nmm ²
Mix ratio by weight	3:1	
Mix ratio by volume	2:1	

The product should be stored in a cool place away from direct sunlight.

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.

50ml Epoxy Adhesive Cartridge



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	MC001842

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