

Technical data sheet

EPOXY



Fitting adhesive

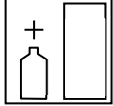
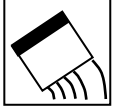
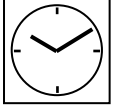
Application:

- Composite industry
 - vessel manufacture (small boats, motorboats, sailing yachts)
 - wind turbines
 - transport (fairings, bodies etc.)
 - other products made of composites (laminates)

Properties:

- perfect adhesion properties
- high connection durability
- application in thick layers is possible (up to 30 mm)
- no sagging

CHARACTERISTICS	EPOXY comp. A	EPOXY comp. B STANDARD	EPOXY comp. B SLOW	STANDARD
Viscosity	45000 - 60000 mPas	10000 - 20000 mPas	10000 - 20000 mPas	PN EN ISO 3219 B
Density	1.2 – 1.3 g/ cm ³	1.2 – 1.3 g/ cm ³	1.2 – 1.3 g/ cm ³	PN EN ISO 2811-1:2002
Gel time at 20°C	--	50 - 70 min	110 - 130 min	--
Colour	white	blue	green	--
Mixing ratio	2 parts by weight	1 part by weight	1 part by weight	--
Tensile strength	--	> 50 MPa	> 40 MPa	PN EN ISO 527
Elongation at break	--	> 3%	> 2%	PN EN ISO 527
Flexural strength	--	> 80 MPa	> 70 MPa	PN ISO 178
Flexural strain	--	> 4.5%	> 4.5%	PN ISO 178
Polish Register of Shipping Type Approval Certificate		TT/1335/710250/22		
SUBSTRATES				
Polyester and epoxy laminates	Degrease with PLUS 780 D degreaser, dry sand with P80 – P120 paper and degrease again.			
Plywood, wood	Dry sand with P80 – P120 paper and then remove dust			
CAUTION				
Do not apply epoxy adhesive directly onto to-wash primers or single-component acrylic and nitrocellulose products.				
APPLICATION				
	Clean and sand the surface			
	Degrease the surface with PLUS 780			

	Use the required amount of hardener. Mix the components thoroughly until a uniform colour is obtained. Weight quantity of components: 100 g EPOXY Comp. A add 50 g EPOXY Comp. B STANDARD; Gel time at 20°C: 50 – 70 min. or 100 g EPOXY Comp. A add 50 g EPOXY Comp. B SLOW; Gel time at 20°C: 110 – 130 min.
	Apply using a long float (maximum layer thickness: 10 mm)
	EPOXY Comp. A / EPOXY Comp. B STANDARD; Curing time at 20°C: 24 h EPOXY Comp. A / EPOXY Comp. B SLOW; Curing time at 20°C: 48 h
EQUIPMENT CLEANING	
THIN 850 acrylic thinner or NC solvent.	
PACKAGE	
EPOXY Component A: 200 kg (DRUM). EPOXY Component B STANDARD: 100 kg (DRUM). EPOXY Component B SLOW: 100 kg (DRUM).	
STORAGE CONDITIONS	
Store in sealed containers, in a cool and well-ventilated room, away from sources of fire and heat.	
SHELF LIFE	
EPOXY Component A: EPOXY Component B: STANDARD EPOXY Component B: SLOW	12 months / 20°C 6 months / 20°C 6 months / 20°C
SAFETY	
See the Safety Data Sheet.	
NOTES	
Intended for professional use only.	
OTHER INFORMATION	
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