

Technical Data & Instruction Sheet

PRODUCT BENEFITS

Multipurpose adhesive system

Excellent bonding strength

High shear and peel strength

Long open time

Enhanced mechanical strength

RECOMMENDED SURFACES

Metal, Wood, Plastics, Ceramics,
Plastics, Vulcanized Rubber

MIXING RATIO

100 pbw Resin and 80 pbw
Hardener

AVAILABLE SIZES

90 gms, 1.8 Kg & 9 Kg.

TECHNICAL INFORMATION

Appearance RER: Clear Liquid

Appearance REH: Amber Liquid

Color RER: Clear

Color REH: Pale Brown

Viscosity RER: 30000-60000 mPas

Viscosity REH: 20000-40000 mPas

Pot Life 100g @ 25^o C: 90 minutes

Mechanical Properties:

Hardness: Shore D/HTP-22/70

Tensile Shear: Kg/ Sq. cm/ASTM
D1002/150

Electrical Properties:

Electrical Strength: kV/mm/

IEC60243-1/18-20

Volume Resistivity: Ω
cm/IEC60093/ 10¹⁴

General Properties:

Glass Transition Temp: ^oC/DSC/45

Temp 100g mix: ^oC/HTP-54/125

Curing Time (Full Cure): 7 Days

Shelf Life: 2 Years

DIRECTIONS

Read entire label before using. Use only as directed. Always test on a small area with a 24 hours curing to check desired results. Make sure surface is clean and free of waxes, dirt and coatings. It should not be applied to wet surfaces. Ensure proper and thorough mixing of resin (PART A) and hardener (PART B) before applying. **DO NOT MIX ANY SOLVENTS.**

1. The substrate must be thoroughly cleaned and should free of moisture, dirt, oil and grease etc. Use Gloves during application. Follow manufacturer's instructions of for using gloves.
2. Mask any surface not intended to be treated.
3. A layer of Resin and Hardener should be applied on substrate to be adhered.
4. Mix part A and B homogeneously and apply it on the substrate. If pinholes reappear, apply another coat.
5. If excess epoxy is not wiped off, residue appears, mechanically remove the cured epoxy.
6. A full cure of a single coat is achieved after 24 hours; foot traffic may begin after 6-8 hours.
7. Clean tools with appropriate solvent immediately after application and allow them dry in a well ventilated area.
8. After 12-20 hours, the treated part can be further processed and transported.
9. Hardener portion more than 80% will reduce adhesion and deteriorate surface drying.
10. Hardener portion less than 80% will delay the hardening and can affect the desired quality.
11. The low temperatures can significantly affect the curing process.
12. The pot life of the product is 90 minutes approximately. So, after mixing use the product within 90 minutes.

METHOD OF APPLICATION

MIX PART A & B IN SPECIFIED RATIO THOROUGHLY & HOMOGENEOUSLY

USE GLOVES, GOGGLES & RESPIRATORS WHILE APPLYING.

STORAGE AND HANDLING INSTRUCTIONS

May be harmful if swallowed. May cause skin, eye and respiratory irritation. Do not spray. Avoid prolong exposure to vapors. Use in a well ventilated area. Do not ingest. **KEEP OUT OF THE REACH OF THE CHILDREN.** Do not freeze or store above 40^o C. Do not mix with other chemicals.

EMERGENCY/ FIRST AID PROCEDURES

Ingestion: Do not induce vomiting. Call a physician

Eye Contact: Flush thoroughly with water for at least 15 minutes. Remove contact lenses, if applicable, and continue flushing. Call a physician if eye irritation persists.

Skin Contact: Wash skin with mild soap and water. Call a physician if skin irritation persists. Wash clothes before wearing again.

Inhalation: Remove to fresh air. Call a physician if respiratory irritation persists.

The above information is based on the latest stage of our development and application technology. Due to multiplicity of influencing factors, this information must be considered as non-binding. Because conditions of use are outside our control, we make no warranties, express or implied, and assume no liability in connection with any use of this information.