TECHNICAL DATA SHEET

2K Epoxy tin solder replacement

2K Epoxy tin solder replacement is a fast curing, easy to use structural 2C Epoxy tin solder replacement which curesby a chemical reaction of the two components forming a durable polymer resistant to elevated temperature, moisture and many solvents and chemicals.

2K Epoxy tin solder replacement is specially designed for repairing surfaces of aluminium or steel. 2K Epoxy tin solder replacement shows offers excellent gap filling properties. Once cured 2K Epoxy tin solder replacement is perfect sandable. Curing time can be reduced by heat. At 45 degrees Celsius the 2C-Epoxy is sandable after 20 minutes. Noshrinkage.

TECHNICAL DATA:

Nominal Components Properties:

	Component - A	Component - B
Chemical base	Epoxy	Amine
Colour	Grey	Off white
Specific Gravity [g/cm³]	1,37	1,33
Viscosity [Pa.S]	118	55
Appearance	Pasty	Pasty

Typical Cure Characteristics:

Working Time	**@ 23° C [min]**	**25**
Sanding Time	@ 23° C [hr]	2,5
Clamp Time	@ 23° C [min]	--

Typical properties of Cured Adhesive:

Shore D Hardness	**EN ISO 868 @ 23° C**	**82**
Tensile Strength	DIN 53504 @ 23° C [MPa]	34
Young's Modulus	DIN 53504 @ 23° C [MPa]	459
Elongation at Break	DIN 53504 @ 23° C [%]	11

The information contained herein are given in good faith based on our current knowledge and experience on the product when pr operly stored, handled and applied under normal conditions in accordance with our recommendations. In practice the differences in materials, substrates and actual site conditions are such that no warranty in respect to merchantability or fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred from this data sheet. The recommendations or suggestions contained in this data sheet are made without guarantee as to results. We suggest that you test the product's suitability for the intended application and purpose prior to use. Our responsibility for claims arising from breach of warranty, negligence or otherwise is limited to the purchase price of the material.

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LAP SHEAR INFORMATION:

	Pre-treatment				
Substrate	**Cleaning**	**Sanding**	**Cleaning**	**Bondline thickness**	**Average strength**
CRS	Acetone	P80	Acetone	1 mm	16 MPa
Stainless steel	Acetone	P80	Acetone	1 mm	13,6 MPa
Galvanized steel	Acetone	P80	Acetone	1 mm	14,3 MPa
Aluminium	Acetone	P80	Acetone	1 mm	10 MPa

USE INSTRUCTIONS:

2K Epoxy tin solder replacement has been designed for ease of dispensing with both hand-held manual and pneumatic applicator tools. To assure an on ratio dispense we recommend levelling the pistons by placing the opened cartridge in the dispenser and purge till material starts to flow from both cartridge chambers prior to attaching the mixer. After attaching the mixer tip (we recommend to only use the mixer tips included in the package) and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both epoxy and amine through the mixer tip. It is recommended to dispose the first 25 to 30 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform grey colour, is creamy, smooth and glossy. The mixer time is 50% of the open time.

After having finished dispensing, leave the mixer in place till 2K Epoxy tin solder replacement shall be used again. The remainder of the adhesive will have a shelf life of several weeks if stored properly. To start using 2K Epoxy tin solder replacement again, remove the static mixer and dispose of properly. Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated. Attach a new mixerand start dispensing.

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SAFETY NOTE:

Please observe the information provided with the Material Safety Data Sheet.

MSDSs are provided to you under RAGS policy of communicating to our customer health, safety and environmental information for safe handling, use and disposal of our products. This information must be made available to health and safety personnel within your organization and to all employees who come in contact with these products.

RECOMMENDED WORKING TEMPERATURE: Between 15-30 °C

STORAGE: Unopened containers stored at a dry place indoors at 15 – 35 °C

SHELF LIFE: 18 Months in the originally sealed cartridge

PACKAGING: 2K Epoxy tin solder replacement is packed in 195 ml u-TAH cartridges for use with a hand-held dispensing tool. Other packaging available on request.

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