



Epoxy Adhesive

Epoxy adhesive is a two component general purpose, versatile Epoxy adhesive system which can be used for bonding various substrates ranging from metals, ceramics, wood, rubber, glass etc.,

Epoxy adhesive has a solvent free Epoxy resin which cures at room temperature when proportionate quantity of Hardener is added to it. Enhanced temperature accelerates curing. The bond obtained gives good impact strength in addition to water and chemical resistance apart from good electrical insulation properties

PRE-TREATMENT OF THE SUBSTRATE:

Substrates to be bonded should be free from traces of oil, dirt etc. Mechanical roughening with emery paper or sanding is recommended in the case of metals. Rubber should be etched with concentrated sulphuric acid for 5-10 minutes and thoroughly washed with water. After washing, the flexed surface should exhibit cracking. Then on the dried surface the adhesive mix is applied.

MIXING PROPORTION:

MIXING RATIO	PARTS BY WEIGHT	
PARTS BY VOLUME		
ADHERE RITE (Resin) 100	100	
ADHERE RITE (Hardener) 80	100	

APPLICATION:

The Adhesive may be brushed or applied by a spatula on the surfaces. Then the surfaces should be held together in position by suitable clamping device maintaining contact pressure through out, while curing.

CURING SCHEDULE:

TEMPERATURE[°C]	40	60	100	120
	150			
CURING TIME [MIN]	310	240	30	15
	5			

To get optimum strength it is ideal to have a curing time of 24 hrs at 30°C.

PROPERTIES OF CURED ADHESIVE (CURED AT 30°C FOR 24 HRS):

TYPICAL PROPERTIES	STD U N I T		
RANGE			
Tensile Lapshear Strength	ASTM D 1002		
	kg/cm ² 140 - 180		
Insulation Resistance	BS 2782	Ohms	>
		1012	
Temperature Resistance	--	--	-
	60°C to 70°C		

SHELF LIFE:

12 months from the date of manufacturing when stored in ideal storage conditions.

PACKING:

Resin 1000 Gms./5 Kgs.
Hardener 800 Gms./4 Kgs.

Note:

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