



Ersätter: 2012-08-06

Datum: 2014-12-03

# Strong Epoxy Professional

Epoxy based, two component adhesive for gluing of metals, pottery, porcelain, crystal, glass, ivory, pearls, precious stones and numerous synthetics (such as polyester, Bakelite, Formica, rigid polystyrene and acrylic glass.

The adhesive joint is resistant towards water, normal household chemicals and solvents of different types.

- **High shear and peel strength**
- **Withstand temperatures up to approximately 60° C**
- **Gap-filling**
- **Good choice when bonding between tight materials**
- **Good resistance towards dynamic loading**
- **Can be over painted**
- **Very good long term performance**

## TECHNICAL DATA

### Basis:

Resin: Epoxy resin

Hardener: modified amine

**Solvent:** None

**Consistency:** Slightly thixotropic

**Density:** Approx. 1170 kg/m<sup>3</sup>

**Dry solid:** 100%

**Appearance:** Light yellow

**Service temperature:** -20°C to +60°C

## APPLICATION DATA

**Application temperature:** +5°C - +35°C.

**Tools:** Plastic spatula for mixing and application.

**Pot life:** After mixing resin and hardener, the mixture must be used within 90 minutes at 23° C.

**Mix ratio:** Equal parts of resin and hardener (by volume or weight).

Do not use the surface which is going to be assembled as mixing underlayer. This will affect correct hardening and also cause bad adhesion.

**Coverage:** 24 ml = approx. 240 cm<sup>2</sup> (coat of 1 mm).

**Handling time:** Approx. 7 hours

**Curing time:** Approx. 24 hours. Curing takes longer at lower temperatures, and shorter at higher temperatures.

**Storage life:** At least 24 months after date of manufacture (can be read on the top of the syringe/syringe holder (4 digit code: week: 01-52 Day:

1-5 Year. 2-

Not sensitive to freezing.

## SURFACE PREPARATION

The surfaces to be glued must be clean, dry and free from grease. For even better bonding; slightly roughen surfaces with sandpaper. Remove the dust. Glass should be washed with an alkaline detergent, rinsed in clean water and allowed to air-dry.

## DIRECTIONS FOR USE

### SYRINGE PACK

Cut the ends from the nozzles where marked. After use – don't forget to seal the nozzles with the cap located in the plunger handle, the cap will only fit in the right way.

### TUBES

The tubes are opened by pressing the points of the caps through the metal membranes. After use; put the caps back on the tubes again. Be sure the caps are not interchanged.

Dispense equal quantities of both parts into enclosed mixing tray. Stir well using a spatula until mixture has a uniform color. At room temperature (+20°C), mixture remains workable for approx. 1,5 hours. Apply a thin layer to one surface. Join immediately and hold in place for 7 hours. Do not move bonded parts until after complete cure. Do not mix resin and hardener unless for bonding.



Full strength is obtained after approx. 24 hours.

Heat-curing will shorten the curing time and make the joint stronger.

Note! The yellowing of the product will increase with heat curing.

#### **TIMES TO MINIMUM SHEAR STRENGTH**

Temperature °C	10	15	23	40	60	100
Cure time to reach LSS > 1 N/mm <sup>2</sup>	35	20	20	5	2	<1
Cure time to reach LSS > 10 N/mm <sup>2</sup>	120	70	61	25	10	2

LSS = Lap shear strength

Note! Professional application with heat, always use an oven with a pressure below that of the atmosphere

#### **LIMITATIONS**

Not suitable for gluing Polyethylene (PE), Polypropylene (PP) and silicone rubber.

#### **HANDLING AND CLEANING INSTRUCTIONS**

When working with adhesive, cleanliness must be observed. Therefore always work carefully and systematically in order to avoid unnecessary spillage.

Clean tools with warm water and soap directly after use.

Cured adhesive can only be removed mechanically.

On skin, uncured adhesive is wiped off with a rag, then wash with soap and water.

Keep out of reach of children.

Do not empty into drains.

#### **ENVIRONMENTAL ASPECTS**

For additional health and safety information consult the Safety Data Sheet.

Our information is based on laboratory tests and practical experience and may, as such, be considered a guide in connection with choice of product and working method. As the user's working conditions are beyond our control, we do not assume any responsibility for the results. Our responsibility covers exclusively personal injury or damage to property which actually have been proved subsequent to faults and defects in one of the products manufactured by us.

#### **Certifierad enligt:**



**Sika Sverige AB**  
163 08 Spånga, Sverige  
Tel: +46 8 621 89 00  
Web: [www.casco.se](http://www.casco.se)