Technical data

Epoxy adhesive E

High-strength structural adhesive for metals and other materials

Description

- **High bond strength**
- **Tough-hard formulation**
- **Free of solvents and fillers**

Owing to their relatively low reactivities, metal adhesives are available with processing times from 90 to 120 minutes depending on the mixing ratio.
The adhesive has a tough-hard formulation, meaning that the bond between metal parts does not split even when heated. The thermal resistance is over 100 °C.

Application

Two-component epoxy resin for aluminium and other metals, wood, ceramics, rigid foams, and many plastics.

Processing

Owing to the polyamino amine hardener this adhesive system can be dosed in a mixing ratio ranging from 100:50 to 100:100 (resin : hardener).The result is different processing times and final strengths.

The adhesive system can be inspissated with fillers such as thixotropy-enhancing agents, cotton flock, milled glass fibres, glass bubbles, etc. (e.g. for repairs and filling gaps).

Set of two components: 0,05 kg - 25 kg order no.158 100-x

Epoxy adhesive E	Unit	Resin	Hardener
State of delivery	-	liquid	liquid
Colour	-	yellow-transparent	-
Colour index	Gardener	-	< 10
Density at 20 °C	g/cm³	1,15	0,96
Viscosity at 25 °C	mPas	43000	700-900
Epoxy value	100/equivalent	0,43	-
Amine equivalent	g/equivalent	-	130
Refractive index	n_D 25	1,447	-
Heat resistance of bonds		> 100	
Gelling time (250 g/23 °C)	minutes	-	110—120
Storage (original packed)	months	min. 12	min. 12

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Determining the bond strength of overlapped single-shear bonds

(lap shear test) as per **DIN 53281, Aluminium (AlCuMg1)**

Mixing ratio	100 : 50	100 : 100
Shear strength	16,2	10,9

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