TYPICAL PERFORMANCE OF CURED MATERIAL

Cured for 30 minutes @ 150 °C, tested at 22 °C. (0.05 mm bond gap).

Lap Shear Strength , ISO 4587:

Mild Steel (grit blasted)	N/mm²	45
	(psi)	(6,530)
Stainless Steel	N/mm²	32
	(psi)	(4,640)
Zinc dichromate	N/mm²	28
	(psi)	(4,060)
Aluminum (abraded) (Silicon Carbide Paper, A166 grit, P400A grade)	N/mm²	40
	(psi)	(5,800)
Aluminum (etched in acidic ferric sulphate)	N/mm²	40
	(psi)	(5,800)
Brass	N/mm²	25
	(psi)	(3,630)
Galvanized Steel (Hot Dipped)	N/mm²	20
	(psi)	(2,900)

IZOD Impact Resistance , ISO 9653, J/m² :

Mild steel (grit blasted)	10

180° Rigid Peel Strength ISO 11339:

Mild steel (grit blasted)	N/mm	9.5
	(lb/in)	(54)

Cured for 60 minutes @ 120 °C

Lap Shear Strength ISO 4587:

GRP (Polyester resin matrix)	N/mm²	6
	(psi)	(870)
Glass Fiber Reinforced Epoxy	N/mm²	24
	(psi)	(3,480)

TYPICAL ENVIRONMENTAL RESISTANCE

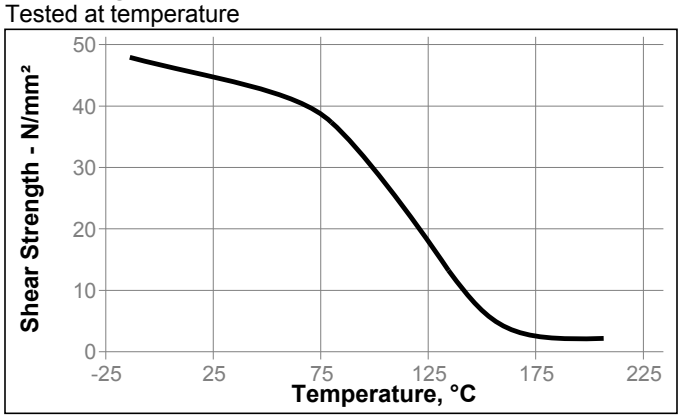
Cured for 30 minutes @ 150 °C (0.05 mm bond gap).

Lap Shear Strength , ISO 4587:

Mild steel (grit blasted)

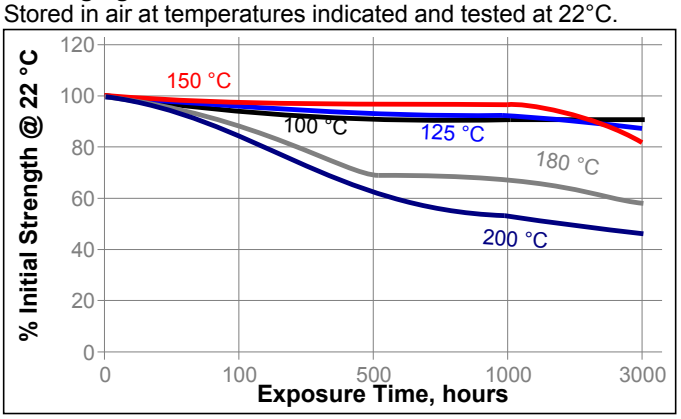
Hot Strength

Tested at temperature



Heat Aging

Stored in air at temperatures indicated and tested at 22°C.



Chemical/Solvent Resistance

Immersed in conditions indicated and tested at 22 °C.

		% of initial strength			
Environment	**°C**	**100 h**	**500 h**	**1000 h**	**3000 h**
Motor oil	22	100	95	95	91
Unleaded gasoline	22	98	97	90	85
50 % Water Glycol	87	64	63	49	30
4% Sodium Hydroxide / Water	22	90	88	76	65
98% RH	40	90	71	63	45
Water	60	72	56	44	44
Water	90	67	63	51	60
Acetone	22	89	86	86	76
Acetic Acid, 10%	22	81	85	71	51
Salt water solution, 7.5%	22	93	76	84	73

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Directions for use

1. For best performance surfaces for bonding should be clean, dry and free of grease. For high strength structural bonds, special surface treatments can increase the bond strength and durability.
2. Product can be applied directly from the cartridge by dispensing through the nozzle supplied.
3. It is recommended that this product is not cured in large quantities as excessive heat build-up and uncontrolled exothermal runaway can occur. Curing smaller quantities will minimize the heat build-up.
4. For maximum bond strength apply adhesive evenly to the surface to be bonded. Parts should be assembled immediately after adhesive has been applied.
5. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).