

## Technical Data Sheet

### Product

Steel Epoxy (326) is a low-odor, two-component, modified epoxy adhesive that cures rapidly at room temperature with exceptional tensile adhesion and peel strength to a wide variety of substrates. In just a few minutes Steel Epoxy (326) forms a tough bond without the need for clamping. Thin sections may take somewhat longer.

### Basic uses

Steel Epoxy (326) may be used as a general purpose adhesive to bond wood, metal, fiberglass, ceramics, glass and many hard plastics. It is tough enough to be drilled, tapped, filed or sanded after final cure and it forms a water-resistant bond.

### Benefits

- Contains no volatile solvents and does not shrink upon curing.
- High peel strength and impact resistance for both industrial and household repairs.
- Fast curing.
- Thixotropic.

### Application limitations

- Does not adhere to polyethylene, polypropylene and Teflon®.
- Maximum temperature range 250°F (121°C) continuous, 300°F (149°C) intermittent.
- Do not mix more than 250g at one time.

### Color

Steel Epoxy (326) is Grey in colour when mixed.

### Application

**Surface preparation:** To achieve optimum adhesion, surfaces should be dry and free of grease or dirt. Scuffing or sanding the surface prior to cleaning helps insure a good bond.

**Mixing and application:** Mix one part A with one part B by weight or volume until uniform. Do not mix more than 250g total (125g Part A and 125g Part B) at one time. Material becomes very hot during cure. Use within 3 minutes of mixing. See **Performance data** on reverse side.

**Shelf life:** One year from date of shipment when stored in original, unopened containers at 75°F (24°C).

### Health precautions

- May irritate sensitive skin. Wash hands with soap and water after use.
  - Eye irritant. In case of eye contact, flush with water and contact physician.
  - May be harmful if swallowed.
  - Keep out of reach of children.
  - Not intended for use in structural applications.
  - When sanding cured epoxy or substrate, use protective eyewear and dust mask.
- For additional health and safety information, consult a Material Safety Data Sheet.

Performance Data*		
Properties	Steel	Test Method
<b>Product Description</b>		
Form	Two-part gel	
Base component color	Steel	
Curing agent color		
Final mixed color	Steel	
Non-volatile content	100%	
Density	1.23 gm/cm <sup>3</sup> 10.24 lb/gal	
Mix ratio, base to curing agent 1:1	1:1.3	
Work life, 3 grams at 75° F	4 to 6 minutes	
<b>Mixed Compound Properties</b>		
Consistency	Thixotropic paste	
Shrinkage	<1%	ASTM D2566
Cure time to lap shear tensile strength=500 at 75°F (24°C)	120 minutes	ASTM D1002
Cure time to full cure at 75°F	16 to 24 min.	
<b>Cured Mechanical Properties</b>		
Hardness, Shore D	45	ASTM D2240
Tensile strength	5,000 psi	ASTM D638
Compression strength	12,000 psi	ASTM D695
Service temperature		
Continuous	250°F (121°C)	
Intermittent	300°F (149°C)	
Lapshre tensile adhesive strength		
Steel to steel	1,300 psi	
Aluminum to aluminum	1,000 psi	
Rigid PVC to rigid PVC	-	
Fiberglass to fiberglass	-	
ABS to ABS	-	
Polycarbonate to polycarbonate	-	
Nylon 66 to Nylon 66	-	
Delrin to Delrin	-	
Phenolic to phenolic	-	
Wood to wood	-	
Nylon 6 to Nylon 6	-	
Glass to glass	> -	
PET to PET	-	
<b>Cured Electrical Properties</b>		
Insulation resistance	30,000 megohms	ASTM D257
Volume resistivity	10 ohm-cm	ASTM D257
Dielectric strength	300 volts/mil	ASTM D149
Arc resistance	50 seconds	ASTM D495
* Typical properties are for information only, not for purposes of specification.		

NON-WARRANTY: ALL RECOMMENDATIONS, STATEMENTS AND TECHNICAL DATA CONTAINED HEREIN ARE BASED ON TESTS WE BELIEVE TO BE RELIABLE AND CORRECT, BUT ACCURACY AND COMPLETENESS OF SAID TESTS ARE NOT GUARANTEED AND ARE NOT TO BE CONSTRUED AS A WARRANTY, EITHER EXPRESS OR IMPLIED. USER SHALL RELAY ON HIS OWN INFORMATION AND TESTS TO DETERMINE SUITABILITY OF THE PRODUCT FOR THE INTENDED USE, AND USER ASSUMES ALL RISK AND LIABILITY RESULTING FROM THIS USE OF THE PRODUCT. MANUFACTURER'S SOLE RESPONSIBILITY SHALL BE TO REPLACE THAT PORTION OF THE PRODUCT OF THE MANUFACTURER THAT PROVES TO BE DEFECTIVE. MANUFACTURER SHALL NOT BE LIABLE TO THE BUYER OR ANY THIRD PARTY FOR INJURY, LOSS OR DAMAGE DIRECTLY OR INDIRECTLY RESULTING FROM USE OF OR INABILITY TO USE, THE PRODUCT. RECOMMENDATIONS OR STATEMENTS OTHER THAN THOSE CONTAINED IN A WRITTEN AGREEMENT SIGNED BY AN OFFICER OF THE MANUFACTURER SHALL NOT BE BINDING UPON THE MANUFACTURER.

301978 / 301979 TDS V2 03-15



Certificate No. 0928752

Cedesa Ltd. Chater Lea Buildings Icknield Way Letchworth Hertfordshire SG6 1WT United Kingdom  
**Tel:** 0044 (0)1462 480764 **Fax:** 0044 (0)1462 480765 **Fax:** 0044 (0)1462 679324 **Web:** www.cedesa.co.uk  
 Registered in England No. 2255194 VAT No. 491138444 For terms and conditions of sale, all purchasers must refer to our website.

