

# Slow Set Epoxy

## Technical Data Sheet

### Product Description

Slow Set Epoxy is a clear, low odour epoxy adhesive, with an extended open time for larger assemblies. This diverse adhesive can join a huge array of different materials, providing a high strength and water resistant bond. In addition, once cured, this toughened adhesive can be machined, sanded and even painted.

### Typical Applications

Wind Blade Ancillary Bonding, Boat Building, Sign Manufacture, Furniture manufacture, Automotive Manufacture, Wood Fillers

### Physical Appearance (Mixed)

Appearance	Pale Straw
Specific Gravity	1.2 (approx)
Viscosity @20°C mPa·s	30,000 to 50,000
Brookfield Helipath < 4Min	
Mix Ratio By Weight	1:1
Mix Ratio By Volume	1:1
Working Time in Nozzle	45 Minutes
Fixture Time	60 Minutes

### Typical Properties Cured Material

Typical Handling Strength	2-3 Hours (Light Duty)
Functional Strength @ 25°C	24 Hours
Full Cure Time @ 25°C	72 Hours
Temperature Resistance	-40°C to 60°C
Gap Fill	up to 2.5mm
Hardness Shore D	60

### Typical ASTM D1002 Results after 72 hours @ 25°C

Steel	18-20 N/mm <sup>2</sup>
Stainless Steel	10-12 N/mm <sup>2</sup>
Aluminium	6-8 N/mm <sup>2</sup>
Polycarbonate	5-8 N/mm <sup>2</sup>
PVC	5-8 N/mm <sup>2</sup>
(Metal Surface Grit-blasted)	

### Example Substrates

Metals, Fibreglass, Most Plastics, Stone, Ceramics, and Wood.

### Terminology

(1) Working/Open Time: The time interval between application of adhesive to substrate, and the possible

assembly/repositioning of the two mating parts @ 20°C

2) Fixture Time: The length of time after the substrate assembly that will allow a joint to support a 1kg dead weight. (Tested on a 12mm x 25mm overlapped joint @ 20°C)

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