

# Fast-Curing 2C-Adhesive



**viscous, self-levelling**  
**very short pot life, fast-curing**  
**transparent**

Fast-Curing 2C-Adhesive can be used on numerous materials such as metal, plastic, fibre reinforced materials, ceramics, glass, stone and wood.

Fast-Curing 2C-Adhesive is suited for construction and assembly work whenever the use of the Easy-Mix System is inefficient.

## Technical Data

Base	Epoxy resin unfilled
Composition	viscous
Colour	transparent
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,15 g/cm³
Viscosity of the mixture at 20°C (+68°F)	8.500 mPa·s
Adhesive gap bridging up to max.	2 mm
Processing temperatur	+10 to +30 °C
Curing temperature	+6 to +40 °C
Pot-life at 20°C (+68°F) for 10ml material	3 - 4 min.
Handling strength (35% strength) after	30 min.
Capable of bearing mechanical loads (50% strength) after	1 h
Final strength (100%) after	24 h
Medium strength of the pure epoxy resin according to DIN 53281-83	
Pressure	9 Mpa
Pull	40 Mpa
Bending	58 Mpa
E-Modul	2.000 - 2.500 Mpa
Shore hardness D	65
Medium shear strength according to DIN 53283 at	
Steel sand blasted	20 N/mm²
Alu sandblasted	19 N/mm²
PVC hard-roughened	13 N/mm²

Linear shrinkage	2,0 %
Temperature resistance	-50 to +80 °C

## Surface pre-treatment

To ensure a perfect bond, the surfaces to be joined must be clean and dry.

## Processing

Fast-Curing 2C-Adhesive can be processed directly from the double cartridge. Reject the first centimetre of the dosed bead. Mix the product thoroughly. Apply adhesive mixture quickly to only one of the surfaces to be bonded. Join both surfaces immediately afterwards.

## Storage

When kept at a constant room temperature of about +20°C and unopened in dry conditions, Epoxy Adhesives will keep for at least 18 months. Avoid direct sunlight. If these storage instructions are disregarded, the storage life will be reduced to 6 months. Epoxy resins are fundamentally liable to crystallise at temperatures of less than +5°C. This effect is accentuated by wide variations in temperature such as can frequently occur during transport in winter. This also has a negative effect on working qualities, curing and technical details, although these effects can be reversed by warming up to a maximum of +50°C (no naked flame). In the case of Epoxy Adhesives, careful selection and combination of the base resins (bisphenol A and F) ensures a reduction of crystallisation.

## Safety and health

When using products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets must be observed.

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