

Description

LETOXIT® LH 145 is a two-component, paste epoxy-based adhesive curing at room or increased temperature. It is designed for gluing of wood, composites (glassfibre, carbonfibre), concrete and brickwork. Bonded joints exhibit very good mechanical properties (strength, impact strength)

Properties

A.component A

Properties of uncured resin

Aspect	visual	grey liquid
Epoxy number	PN-5M-11	1730-1900 mmol/kg

B. component B

Properties of hardener

Aspect	visual	grey liquid
Amine number	PN-5M-06	200 - 240 mg KOH/g

C. Mixture of A/B

Mixing ratio, parts by weight:

Component A	100
Component B	50

Shear strength (tension loading in accordance with ČSN 66 8510):

Curing cycle	Temperature	Shear strength
48 h at 25°C, 10 h at 35°C	20°C	min. 10,0 MPa
	80°C	min. 6,5 MPa
	120°C	min. 3,0 MPa

Compression strength (in accordance with ČSN EN ISO 604):

Curing cycle	Compression strength
48 h při 25°C	min. 115 MPa

absorbability (in accordance with PN-5M-15)

cured for 48 h at 25°C < 0,5 %

glass transition temperature (DSC):

cured for 2 days at 25°C, 7 days 30°C 55°C

Pot life

Considering exothermic reaction of both components after mixing, pot life of the mix depends on weighed amounts, mix temperature and used container.

Surrounding temperature	10°C	20°C	30°C
Pot life	3h	1h	0,5h

Mixing

Mix 100 weight parts of A component with 50 weight parts of B component, mix thoroughly (we recommend to mix the adhesive in original package for component A). To guarantee maximum strength of the bonded joint, the accuracy of + 5% must be kept for B component.

Also an automatic mixer can be employed.

Curing

Curing at 25 °C allows handling with bonded parts after 24 hours, final strength is achieved after 48 hours. It is possible to accelerate the curing cycle by increase of temperature

Surface treatment

Surfaces to be bonded must be free from any mechanical impurities and traces of oil or grease and must be dry. Surface pretreatment of parts to be adhesive bonded is a decisive factor affecting strength of the bonded joint. Some materials require special surface pretreatment techniques.

Package

Component A: tin 5, 10, 20 kg

Component B: tin 2, 5, 10 kg

Storage

Both components of the adhesive should be stored in sealed containers in dry places, apart from each other, at temperatures ranging from +10°C to +25°C. Protect from direct sunshine. At 18 -25°C minimum shelf life is 6 months.

Disposal of leftovers and containers

Leftovers of prepared and not used mix should be cured, leftovers of A component should be mixed with leftovers of B component and also passed to be cured, best in original containers.

Cured adhesive is not hazardous and can be disposed of along with municipal waste.

Producer and Supplier

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LETOXIT® is a registered trademark of 5M s.r.o. company.



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