TECHNICAL DATA SHEET

Version: 4/2012

LETOXIT® LH 167

Application

Letoxit LH 167 is two-component adhesive curing at room or higher temperature. It is compounded from component A an B. This adhesive has good heat and water resistance. It is useful for bonding of fiberglass, metals or some other materials.

Method of use

Mixing ratio A:B 100:44 mass ratio
100:50 volume ratio

Mix component A with component B according the mixing ratio. It is necessary to follow the recommended ratio with accuracy 1 % of component B to component A.. It is important that the side and the bottom of the vessel are incorporated into the mixing process. With advantage it is possible to use a machine applicators.

Pot life

Because of exothermic reaction of both components after mixing, pot life depends on quantity of mixture, temperature of mixture and used containers. Generally is possible determine the pot life of 100 g mixture at temperature 20°C is approximately 15 min.

Preparing materials for bonding

For getting needed properties of bonded joint it is necessary to follow technological and material instructions regarding prepare of bonded material´s surface.

Curing

Adhesive will reach at temperature 25°C sufficient strength for manipulation in 3 or 4 hours and the final strength in 72 hours. The curing is possible to accelerate by the increasing of temperature. At 80°C it is possible to reach full curing after 1 hour.

Technical data

A. Letoxit LH-167 (component A)
Properties of uncured resin

Property	**Norm (method)**	
Color	visual	transparent viscosity liquid
Odor		light
Density	ISO l675 /SN 656l99/	1,10 - 1,15 g/cm^3
Epoxy equivalent	PN-5M-20	0,53 – 0,55 mol/100 g
Viscosity (25°C)	PN-5M-01	9.000 – 11.000 mPa.s

B. Letoxit LH-167 (component B)
Properties of curing agent

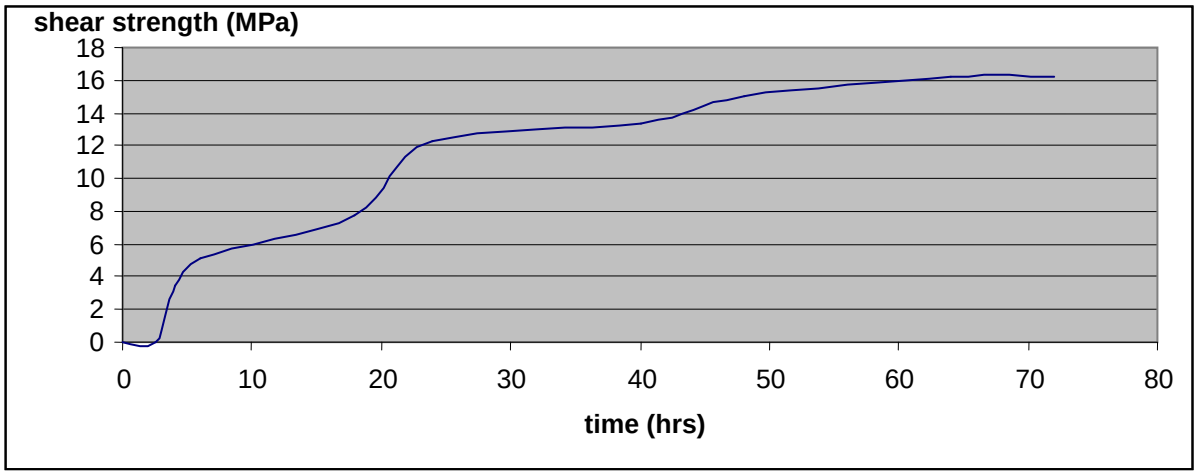
Property	**Norm (method)**	
Color	visual	yellowish liquid
Odor		amin-like
Density	ISO l675 /SN 656l99/	0,94-1,00 g/cm^3
Aminic number	PN-5M-06	640 - 690 mg KOH/g
Viscosity(20°C)	PN-5M-01	600 - 800 mPa.s

5M
Na Záhonech 1177
686 04 KUNOVICE
Česká republika
tel: +420 572 433 711
fax: +420 572 433 700
email: 5M@5M.cz
www.5M.cz

C. Properties of cured bonded joint

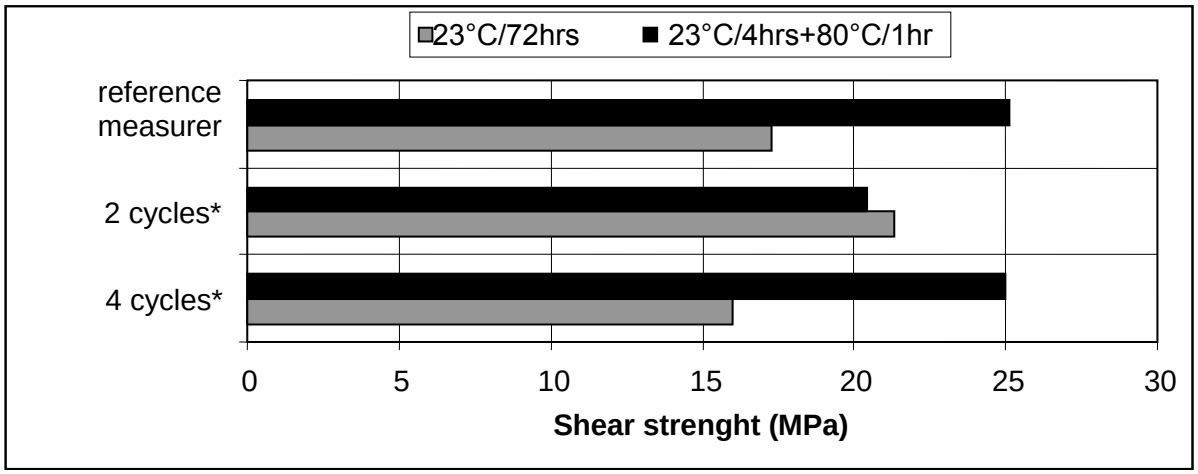
Shear strength	ČSN EN 1465	16 MPa
T_g (22°C/3 days)	DSC	55°C
T_g (22°C/4 hours+80°C/1 hour)	DSC	82°C
T_g max	DSC	87°C

Dependence of shear strength on time of curing at room temperature



Shear strength after cyclic test:

- method: ČSN EN 1465
- curing: 1) 72 hours/23°C
  2) 4 hours/23°C + 1 hour/80°C
- material: aluminum sheet, width 25 mm and thickness 1,6 mm
- tested at 23°C
- humidity: 100%
- execution: sheets packed into cotton clothes wet in water and to PE foil



* +70°C/150 hours + -20°C/16 hours

Packing

Letoxit LH 167	component A:	20 kg cans
	component B:	5, 10, 20 kg cans
	cartridges:	50, 200, 400 ml

5M
Na Záhonech 1177
686 04 KUNOVICE
Česká republika
tel: +420 572 433 711
fax: +420 572 433 700
email: 5M@5M.cz
www.5M.cz

Storage

Component A

Store in properly closed containers on dry and well ventilated place. Store at temperature 15-25°C. Shelf life is 6 months when following the recommended conditions.

Component B

The curing agent has to be stored in tightly closed container, with as lowest as possible exchange of air in production. Store in cold place. Shelf life is 6 months when following the recommended conditions.

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.
Based on Waste Act, leftovers of separate components are classified as hazardous waste and are disposed of by incineration in special plants designed for such purposes.

Producer and Supplier

5M s.r.o.
Na Záhonech 1177
686 04 Kunovice
Czech Republic

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