

**Description**

two-component epoxy adhesive hardens at higher temperature. It is composed from part A and part B. It has good temperature resistance. The adhesive is determined for bonding of metals and applications with high temperature resistance.

**Method of use****Mixing**

- mass ratio: 100 parts of A : 52 parts of B
- volume ratio: 100 parts of A : 50 parts of B

**Application**

The adhesive is prepared for application by mixing A and B components in 100:52 weight ratio or 100:50 volume ratio. It is necessary well mixing up especially along the vessel walls and bottom.

**Pot-life**

Pot-life depends on the weighed amount, on the mixture temperature and the vessel used. Approximate life of 100 g mixture at 20 °C is 120 minutes.

**Preparation of materials for gluing**

Both the bonded surfaces must be clean, dry and free from any grease and dust. Some materials require special treatment.

**Curing**

At the temperature of 25 °C, Letoxit® LH 190 needs 24 hours to achieve sufficient strength for manipulation. For final strength it must be hardening at higher temperature. After obtaining sufficient strength for manipulation (at 25 °C) is recommended to cure gradual increase in temperature, as follows:

60°C/30 min  
100°C/60 min  
120°C/180 min

**Technical data****A. Properties LH-190 (part A)**

Properties of uncured resin

Properties	Norm (method)	
Colour	visual	yellowish tixotropic liquid
Density	ISO I675 /SN 656I99/	1,05-1,10 g/cm <sup>3</sup>
Epoxy equivalent	PN-5M-20	0,9-1,1 mol/100 g

**B. Letoxit LH-190 (part B)**

Properties of curing agent

Properties	Norm (method)	
Colour	visual	colourless liquid
Density	ISO I675 /SN 656I99/	0,95-1,0 g/cm <sup>3</sup>



# TECHNICAL DATA SHEET

Amine number	PN-5M-06	min. 650 mg KOH/g
Viscosity (20°C)	PN-5M-01	100-200 mPa.s

## C. Properties of cured bonded joint

Shear strength	CSN EN 1465	16 MPa
T <sub>g</sub> (max)	DSC	200 °C

## Packaging

Letoxit LH 190	part A:	1, 5, 10 kg drum (and cartridges)
	part B:	520 g, 2,6 kg, 5,2 kg drum (and cartridges)

## Storage

### Part A

Part A should be stored in sealed containers in dry, cold and well ventilated places, at temperature to +8°C. Minimum shelf life at the temperature +8°C is 6 months.

### Part B

The curing agent (part B) should be stored in sealed containers with minimum air exchange. Minimum shelf life at the temperature from +5 to +35°C is six 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. 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.

## Safety during processing

see Material Safety Data Sheet

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