

Description

Two-component solvent free epoxy adhesive with high hardening speed; it hardens at normal temperature. The adhesive is suitable for bonding of metallic materials, laminates, wood, glass, ceramics, and some plastic materials such as PS, ABS, PPO, rubbers, reactoplastics etc. The adhesive hardens in 5 minutes; it reaches high bond strength and chemical resistance.

Method of use

Mixing and application

The adhesive is prepared for application by mixing A and B components in 1:1 weight ratio. After thorough mixing up (especially along the vessel walls and bottom), the adhesive is applied on one bonded surface or on both bonded surfaces as required. Optimum strength of the bonded joint can be achieved at joint thickness of 0.1-0.2 mm, i.e. if amount of approximately 150g/m² is applied. The bonded pieces must join together within 1 – 2 minutes.

When applied from cartridge, it is necessary to squirt off app. 10 cm adhesive strip from the mixer to ensure complete mixing of both components.

Technical data:

Viscosity (mixture) at 25°C: 15 000 – 20 000 mPa.s

Mixing ratio: 1:1 by weight

Specific gravity: 1.1 – 1.2 g/cm³

Pot life: 7 minutes

Color: colorless

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.

Curing

At 25 °C Letoxit LH 193 will achieve

- gel point within about 10 minutes after mixing up;
- sufficient strength for manipulation within an hour;
- 100% strength within 3 hours.

Properties of cured bonded joint

<i>loading temperature</i>	<i>value</i>
Shear strength (at tensile loading as per CSN 66 8510 standard)	
+20°C	min. 23 MPa
Peel strength (T peel test)	
+20°C	min. 3 N/mm ²

Package

Letoxit LH 193 part A: 1, 5, 10 kg drum (and cartridges)
 part B: 1, 5, 10 kg drum (and cartridges)

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.

TECHNICAL DATA SHEET

At 20°C, minimum shelf life is one year.

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.

