

### Description

two-component epoxy adhesive hardens at room or higher temperature. It is composed from part A and part B. It has good temperature resistance. The adhesive is determined for amplifying stone slab penetration and lamination with glass-type materials, especially paragram.

### Method of use

#### Mixing

- weight ratio: 100 parts of A : 33 parts of B

#### Application

The adhesive is prepared for application by mixing A and B components in 100:33 weight 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 30 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 195 needs 24 hours to achieve sufficient strength for manipulation, for final strength 48 hours. It is possible to accelerate the curing cycle by increase of temperature. In such case, full strength can be achieved in 30 minutes at curing at 80°C.

### Technical data

#### A. Properties LH-195 (part A)

Properties of uncured resin

Properties	Norm (method)	
Colour	visual	yelowish liquid
Odour		mild
Density	ISO I675 /SN 656I99/	1,10-1,15 g/cm <sup>3</sup>
Epoxy equivalent	PN-5M-20	0,56-0,61 mol/100 g
Viscosity	PN-5M-01	500-750 mPa.s

#### B. Letoxit LH-195 (part B)

Properties of curing agent

Properties	Norm (method)	
Colour	visual	colourless to yelowish liquid
Odour		aminic
Density	ISO I675 /SN 656I99/	0,94-1,0 g/cm <sup>3</sup>
Aminic number	PN-5M-06	min. 470 mg KOH/g
Viscosity (20°C)	PN-5M-01	70-150 mPa.s



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## C. Properties of cured bonded joint

Shear strength	CSN EN 1465	20 MPa
T <sub>g</sub> (max)	DSC	95 °C

## Packaging

Letoxit LH 195 part A: 1, 5, 10 kg drum (and cartridges)  
part B: 330 g, 1,65 kg, 3,3 kg drum (and cartridges)

## Storage

### Part A

Part A should be stored in sealed containers in dry, cold and well ventilated places, at temperature from +15°C to +25°C. Minimum shelf life at the temperature from +15°C to +25°C is 6 months.

### Part B

The curing agent (part B) should be stored in sealed containers with minimum air exchange. Store in cold place. Minimum shelf life 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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