

Type

Two-component epoxy adhesive with high strength and toughness

- increased thixotropy (preventing the adhesive from soaking in absorbent materials, or preventing the adhesive from soaking through when bonding veneers). The adhesive does not run down from the vertical surfaces.
- the adhesive hardens at normal temperature.

Use

The adhesive is determined for bonding of wooden materials, veneers, foams, laminates and ABS.

Application

The adhesive is prepared for application by mixing A and B components in 2:1 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. The bonded pieces must join together within 1 – 2 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.

Technical data

| | Norm (method) | Component A | Component B |
|----------------------------------|-----------------------|------------------------|------------------------|
| Colour | - | yellowish | tawny |
| Viscosity by 25°C | method: cone-board | 0,6-1,5 Pa.s | - |
| Density by 20°C | ISO 1675 / ČSN 656199 | 1,16 g/cm ³ | 1,00 g/cm ³ |
| Hydrogen equivalent- mass | - | - | - |
| Aminic number | PN-5M-06 | - | - |

Pot life

Considering exothermic reaction of both the components after mixing up, the pot-life depends on the weighed amount, on the mixture temperature and the vessel used. Approximate life of 500 g mixture at 20 °C is 60 minutes.

Hardening temperature

At the temperature of 25 °C, Letoxit® LH 21 needs 24 hours to achieve sufficient strength for manipulation and 48 hours to achieve its final strength. Hardening can be accelerated by increasing temperature. At the temperature of 80 °C, full hardening can be achieved within 15 - 20 minutes.



TECHNICAL DATA SHEET

Packing:

Tin boxes or PE containers: 0.5, 1.5 or 10 kg

Storage:

Six months in a closed container at the temperature from + 5 °C to + 35 °C.

Safety during processing:

see Safety sheet

Producer and Supplier:

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