

Usage

Two component epoxy adhesive without solvents with high speed curing at room temperature. It is suitable for bonding of metal, laminates, wood, glass, ceramics and some plastics as PS, ABS, PPO, rubber, reactoplastics. The adhesive has high strength and chemical resistance.

Mixing and application

The adhesive is prepared for application by mixing A and B components in 1:1 weight/volume 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 optimal bond strength can be achieved when the adhesive thickness is 0.1-0.2 millimeters, approximately 150g/m². The bonded pieces must be joined together within 1 – 2 minutes.

When applying the adhesive from the cartridge mixer, it is necessary to use long min. 10 cm in order to ensure complete mixing of the two components.

Technical data

Property	Charakteristic value
Mixing ratio	1:1
Density	1,1-1,2 g/cm ³
Viscosity	5000-10000 mPa.s
Pot-life	3-5 min
Color	colorless transparent

Preparation of material for bonding

The surfaces to be bonded must be free of any mechanical impurities, oil and grease points and be dry. Surface treatment of parts before bonding affects the strength of bonded joint. Some materials require special surface treatment.

Curing

Letoxit Lh 274 starts to get harder at 25°C in 5 minutes, sufficient strength for handling reaches in 20 minutes and final strength in 5 hours.

Properties of cured bonded joint (24 hours at 20°C)

Shear strength (according to CSN EN 1465)	20MPa
Peel strength (according to CSN ISO 11339)	1-2 N/mm

Packing

Letoxit LH 274 is supplied in 5 and 10 kg PE cans.

Storage

Both components has to be stored in closed containers on dry place, at temperature 10-25°C, resin separately from hardener. Do not expose to direct sunlight. Minimum storage of adhesive at 20 ° C is one year from date of manufacture.

Safety at work

see material safety data sheet

Producer and Supplier



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TECHNICAL DATA SHEET

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