

**Description**

Letoxit PL 50 is a two-component, high-strength, paste epoxy-based adhesive curing at room temperature. It is designed to adhesive bond a variety of metallic materials, honeycombs, fiber-reinforced composites, wood, rubber and glass. Such materials can be even combined and bonded to one another. Bonded joints exhibit very good mechanical properties at temperatures ranging from  $-75^{\circ}\text{C}$  to  $+50^{\circ}\text{C}$ . The adhesive contains a corrosion inhibitor.

**Appearance**

A Component: thixotropic paste of yellow color  
B Component: fluid of blue to purple color

**Mixing**

Mix 100 weight parts of A component with 37 weight parts of B component, mix thoroughly until an even colour shade is achieved. Also an automatic mixer can be employed. To guarantee maximum strength of the bonded joint, the accuracy of  $\pm 5\%$  must be kept for B component.

**Pot life**

Considering exothermic reaction of both components after mixing, pot life of the mix depends on weighed amounts, mix temperature and used container. Approximately it can be said that pot life amounts to

2 hours	for 50g of mix	at $25^{\circ}\text{C}$
1 hour	for 100g of mix	at $25^{\circ}\text{C}$

**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.

**Adhesive application**

Apply the adhesive to both surfaces to be bonded using a spatula, brush, or pressure gun. 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/m<sup>2</sup> is applied.

**Curing**

In 4-5 hours after mixing both components a gel is formed at  $25^{\circ}\text{C}$ , and after 24 hours the bonded parts can be handled. 90% of final strength of the adhesive is achieved after 4 to 5 days. Full strength is achieved within 1 to 2 weeks at room temperature. It is possible to accelerate the curing cycle by increase of temperature. In such case, full strength can be achieved in 4 hours at curing at  $50^{\circ}\text{C}$ , or even in 1 hour at  $120^{\circ}\text{C}$ .

**Properties of cured bonded joint**

	loading temperature	Strength
Shear strength at tensile loading according to CSN 66 8510 standard	$+20^{\circ}\text{C}$	31-36 MPa
Peel strength according to CSN 66	$+20^{\circ}\text{C}$	4-7 N/mm



# TECHNICAL DATA SHEET

8516 standard		
---------------	--	--

## Packing:

The adhesive is supplied in pack size of 1.45 kg and its multiples. The A component is packed in cans or polyethylene containers; the B component comes in polyethylene bottles in a corresponding ratio.

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

## 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 Safety sheet

## 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



Na Záhonech 1177  
686 04 KUNOVICE  
Česká republika

tel: +420 572 433 711  
fax: +420 572 433 700  
email: 5M@5M.cz

www.5M.cz  
LETOXIT® is registered trademark