

# EPOXY METAL

## METAL COLOURED, HARD WEARING, TWO-PART EPOXY ADHESIVE



### PRODUCT DESCRIPTION

Metal coloured, hardwearing, two-part epoxy adhesive.

### FIELD OF APPLICATION

Ideal for hardwearing repairs to metal objects which need to resist extreme conditions (forces, vibrations, (sea) water, heavy strains), such as tools or parts of a car, motorcycle, bicycle or moped, metal (garden) fences or cutlery. Also suitable for filling small holes in radiators. Bonds metal (steel, aluminium, iron) parts amongst themselves or to stone, wood, concrete and various synthetics (such as Formica, polyester and bakelite). Not suitable for Polyethylene (PE), Polypropylene (PP), P.T.F.E. and silicone rubber.

### PROPERTIES

- Hardwearing
- Metal coloured
- Resistant to extreme conditions
- Temperature resistant from -40°C to +60°C
- Filling
- (Sea)water resistant
- High resistance to chemicals
- Can be sanded, filed, drilled and painted after curing

### PREPARATION

**Working conditions:** Use only at temperatures between +5°C and +35°C. Product cures after mixing resin and hardener.

**Personal safety:** Preferably wear gloves during use.

**Surface requirements:** Materials to be bonded should be dry, clean and free of grease.

**Preliminary surface treatment:** Degrease parts to be bonded with Bison Thinner for Bison Kit or acetone. Roughen up smooth materials (sand paper).

**Tools:** Mix and apply with plastic spatula. Clean tools with warm water and soap directly after use.

### APPLICATION

**Mixture ratio:** 1:1

**Coverage:** 24 ml = approx. 240cm<sup>2</sup> (coat of 1mm)

#### Directions for use:

Remove spatula from side of double syringe and cap from handle. Break safety seal of double syringe. Dispense equal quantities of both parts into enclosed mixing tray. Stir well using enclosed spatula until mixture has a uniform colour. At room temperature (+20°C), mixture remains workable for approx. 45 minutes. Apply a thin layer to one surface. Join immediately and hold in place for 10 hours. Do not move bonded parts until after complete cure. After use, clean nozzles with a cloth and place special double cap from handle on double syringe. Do not mix resin and hardener unless for bonding.

**Potlife:** 45 minutes

**Stains/residue:** Remove fresh stains immediately with warm water and soap. Cured adhesive residue can only be removed mechanically.

### CURE TIMES

**Handling time:** approx. 10 hours

**Dry/Cure time:** approx. 24 hours. Curing takes longer at lower temperatures, and shorter at higher temperatures.

\* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

### TECHNICAL PROPERTIES

**Moisture resistance:** Good

**Temperature resistance:** -40°C to +60°C

**Chemicals resistance:** Very Good

**Paintability:** Good

**Filling capacity:** Good

### TECHNICAL SPECIFICATIONS

**Chemical base:** Resin: epoxy resin. Hardener: modified amide

**Colour:** Grey

**Viscosity:** Pasty

**Solid contents:** approx. 100 %

**Density:** approx. 1.2 g/cm<sup>3</sup>

### STORAGE CONDITIONS

At least 24 months after date of manufacture. Limited shelf life after opening. Store in a dry, cool and frost-free place.