PLUS SOFORTFEST

SUPER-FAST, TRANSPARENT TDUAL-COMPONENT EPOXY ADHESIVE

PRODUCT DESCRIPTION

Super-fast, very strong and transparent dual-component epoxy adhesive.

FIELD OF APPLICATION

Super-fast, transparent two-component epoxy adhesive. Not suitable for Polyethylene (PE), polypropylene (PP), PTFE and silicone rubber.

PROPERTIES

· Super-fast
· Very strong
· Universal
· Filling
· Resistant to temperatures between -20°C to +65°C
· (Sea)water resistant
· Chemical resistant
· Paintable after curing
· Applicable for both internal and external use
· Transparent

PREPARATION

Working conditions: Only apply at temperatures between +5°C and +25°C. Product cures by mixing the resin and hardener.
Personal safety: Preferably wear gloves.
Surface requirements: The materials to be bonded must be dry, clean, free of dust and grease.
Preliminary surface treatment: Degrease parts to be bonded with acetone. Roughen smooth surfaces (sandpaper).
Tools: Mix the components by means of the supplied mixing bowl and spatula.

APPLICATION

Mixture ratio: (by volume) 1:1 (other mixing ratios possible)
Coverage: Because of its very fast curing time, only suitable for small bondings which can be joined within 90 seconds. Coverage: for 1 ml = approx 1 cm^2 at a film thickness of 1 mm
Directions for use:
Press out an equal amount of both components onto the enclosed mixing tray. Mix these two equal parts well with a synthetic spatula until a mixture is obtained with a homogeneous colour. Apply the mixture, which at room temperature (+20°C) remains toolable for about 90 seconds, as a thin layer on one of both materials. Join parts immediately and press firmly. Keep in place for at least 10 minutes. Don't move during curing. The bonding is hand tight after approx. 10 minutes. Fully cured after about 1-2 hours (at 20°C).
Open time: 1 - 2 min. (Period of usability at 20°C room temperature)
Stains/residue: Remove wet stains immediately with warm water and soap. Cured adhesive residue can only be removed mechanically.
Advice: Some types of synthetics can not be joined such as polyethylene and polypropylene. This can be tested by holding a glowing copper wire against the synthetics. Does it smell of wax? Then you can not bond it.
Use a piece of adhesive tape in order to keep the parts in place while the adhesive is curing.
Points of attention: Close well after use. For optimum performance it is important to create a larger amount of adhesive and mix it very well. Curing time depends on the temperature. Adhesive does not cure below +5°C.

CURE TIMES

Handling time: approx. Application time (period of usability): The open time depends on the quantity used and the ambient temperature. For a quantity of 3 to 5g, the mix can be worked for up to 2 minutes.
Dry/Cure time: approx. Hardening: At room temperature UHU plus sofortfest hardens so that the join is firm within 5 minutes at the most; after 10 minutes approximately half the final bond strength is reached, and after 1 hour the final bond strength is reached. See chart:

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

TECHNICAL PROPERTIES

Temperature resistance: Between -40 and +80°C (dependent on material and construction; higher temperatures may also be possible - see chart). High temperatures are not necessary for the hardening process, as hardening is exothermic (i.e. it generates its own heat). If a bond is to be subject to long-term exposure to heat, this should not exceed 100°C, although the substance can withstand short-term temperatures of up to 180°C. The adhesive is not affected by even extremely low temperatures. UHU plus sofortfest is resistant to ageing and weathering.
Chemicals resistance: many solvents, dilute acids and alkalis.UHU plus sofortfest joins are substantially resistant to moisture and a range of solvents. Dilute acids, dilute alkalis and mineral oil have little effect on bond strength, even in the event of lengthy exposure. No universally valid data can be given as there are always many factors, such as the possibility of corrosion, duration of exposure and temperature, that affect the assembly. Some solvents, such as methylene chloride, trichloroethylene and chloroform (Warning! Precautions

must be taken!), soften the adhesive over a period of time. This effect can be made use of for dissolving adhesive joins.

TECHNICAL SPECIFICATIONS

Appearance: Colourless, transparent
Chemical base: binder: epoxy resin; hardener: polymer
Bonding technique: Wet adhesion
Consistency: Medium viscosity
Viscosity: binder: 30.000; hardener: 17.500 mPa.s.
Solid contents: approx. 100 %
Density: approx. binder: approx. 1.18; hardener approx. 1.13 g/cm^3

STORAGE CONDITIONS

Store cool, dry, frost-free and tightly closed.