2C Epoxy Resin Adhesives

Epoxy Black

WIKO Epoxy Black was developed for the adhesion of many different materials. With this product, it is possible to bond metals, ABS, polycarbonate, PMMA, rigid PVC, GFRP, CFRP and other materials such as wood or glass.

Trading units	**Item no.:**
50 ml cartridge	EPOS.K50
400 ml cartridge	EPOS.K400

Physical properties (solid state)

	resin	**curing agent**
Basis:	epoxy resin	amine
Colour:	black	white
Texture:	thixotrope	thixotrope
Density [g/ml]:	1.10 – 1.18	1.05 – 1.12 g/ml
Mixing ratio:	2	1

Temperature resistance: to +160°C

Processing time (depending on quantity/mass, temperature and trading unit):

- ca. 60 minutes for 50g *(25°C, 50% humidity)*
- ca. 30 minutes for 100g *(25°C, 50% humidity)*

tensile shear strength	26 – 32 N/mm^2 *(20°C, 50% humidity)*
peel strength	3 – 5 N/mm *(20°C, 50% humidity)*

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Application

The designated surfaces have to be dry and free of dust, oil, grease and other impurities. Generally, we recommend to the use of a suited WIKO cleaner (e.g. AMTR.D500 for metals or AKSR.D500 for plastics).

The adhesion can be optimized by mechanical roughening/grinding of the surface.

Place the cartridge in a suitable glue gun and open the cap. Squeeze a little amount of the adhesive on a piece of paper until both components run fluently.

Clean the outlet and put on a mixing spout. Sqeeze a little amount of the adhesive on a piece of paper until the material has a homogeneous colouring.

Now, put the product quickly on the designated surfaces. Be careful to avoid air pockets and too much material excess.

To achieve the best results, use a joint thickness of 0.1 – 0.2 mm (at an applied quantity of ca. 150g/m²)

Remove the mixing spout after the application, clean the outlet and put on the cap. Be careful not to swap the side of the cap, otherwise the outlet can be sealed.

The parts should be joined within the processing time.

If the bonded parts are stored at 25°C

- the further processing is possible after 5-6 hours
- 90% of the final strength is reached after 3 days
- the final strength is reached after 7 days

The curing can be accelerated by storing the bonded parts:

- at 25°C: final strength is reached after 7 days
- at 60°C: final strength is reached after 2 hours
- at 80°C: final strength is reached after 1hour

The used working materials should be cleaned right after usage (e.g. AMTR.D500 for metals or AKSR.D500 for plastics).

The cured adhesive can only be removed mechanically.

Storage and Storage life

The storage life of the components A and B in unopened packaging is 12 months starting with the date of shipping by Gluetec. The product requires storage at a temperature of +10°C and +20°C to maintain the maximum storage life.