

TECHNICAL DATA SHEET
My-T-Bond® Standard Epoxy
April 2019



METLOK PRIVATE LIMITED
(An ISO 9001 Certified Company)
W- 27, M.I.D.C. Industrial Area,
Kalmeshwar – 441 501, Nagpur

Product Description

My-T-Bond® Standard Epoxy is a two component epoxy adhesive ideal for general purpose applications. This two component epoxy adhesive cure fast at room temperature and when fully cured, the epoxy is resistant to a wide range of chemicals and solvents, and acts as an excellent electrical insulator. It is used for epoxy casting and designed specifically for encapsulation. Other applications include bonding plastic, metal, glass, wood, ceramic, rubber, and masonry materials.

Properties

Technology	:	Epoxy
Components	:	2k - required mixing
Mix ratio by weight	:	1 : 0.8
Part A: Part B		
Appearance	:	Opaque
Cure	:	Room Temperature
Pot life at 25±2 °C	:	90 min
(100 gm)		
Total Cure time at 25±2 °C	:	24 Hrs.
Operating temperature	:	-30 °C to 150°C
Applications	:	General purpose applications

Properties of Uncured Material

Component (A)

❖ Color	:	Clear
❖ Sp. Gravity@25±2 °C	:	1.19
❖ Viscosity, Brookfield @ 25 °C, Spindle No-4, Speed 10 r.p.m.	:	30000-35000 cP

Component (B)

❖ Color	:	Pale yellow
❖ Sp. Gravity @ 25±2 °C	:	1.05
❖ Viscosity, Brookfield @ 25 °C, Spindle No-4, Speed 10 r.p.m.	:	15000 – 20000 cP

Mixture (A) + (B)

❖ Color	:	Opaque
---------	---	--------

Properties of Cured Material

After 24 Hrs@25±2 °C

Hardness, Durometer-Shore D, ASTM D 2240	:	60-70
Tensile Strength, ASTM D 897	:	10-15 N/mm ²
Lap Shear Strength, ASTM D1002	:	10-15 N/mm ²

Directions for use

- ❖ For best performance surfaces for bonding should be clean, dry and free of grease. For structural bonds, special surface treatments can increase the bond strength and durability.
- ❖ To use, Part A and Part B must be blended. Product can be applied directly.
- ❖ Using bulk containers, mix thoroughly by weight or volume in the proportions specified in Properties of Uncured Material section. For hand mixing, weigh or measure out the desired amount of Part A & Part B mix thoroughly. Mix approximately 2 min after uniform colour is obtained
- ❖ Do not mix quantities greater than 4 kg as excessive heat build-up can occur. Mixing smaller quantities will minimize the heat build-up.
- ❖ Apply the adhesive as quickly as possible after mixing. Parts should be assembled immediately after mixed adhesive has been applied.
- ❖ Working life of the mixed adhesive is 15 minutes at 25±2 °C. Higher temperature and larger quantities will shorten this working time.
- ❖ Keep the assembled parts from moving during cure. The joint should be allowed to develop full strength before subjecting to any service loads.
- ❖ Excess uncured adhesive can be wiped away with organic solvent (e.g. acetone).
- ❖ After use and before adhesive hardens mixing and dispensing equipment should be cleaned with hot soapy water.

Pack Size

My-T-Bond® Standard Epoxy is available in 36 gm, 180 gm and 1.8 kg pack.

Storage and Handling

1. Product shall be ideally stored in a cool, dry location in unopened containers at 25±2°C unless otherwise labeled. Optimal storage is at the lower half of this temperature range.
2. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact our Technical Service Centre.

Note

All statements, technical information and recommendations set forth herein are based on tests which Metlok Private Limited, believes to be reliable. However, Metlok Private Limited does not guarantee their accuracy or completeness. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In no case will Metlok Private Limited be liable for direct, consequential economic or other damages.

METLOK PRIVATE LIMITED
(Bonding and Sealing Solutions)
An ISO 9001: 2015 Certified Company
Tel.: 07118-271543/271170/272468
Fax: 07118-272470
Visit us at: www.metlok.in