

TECHNICAL DATA SHEET

My-T-Bond® 2689

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METLOK PRIVATE LIMITED
(An ISO 9001 Certified Company)
W-27, M.I.D.C. Industrial Area,
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Product Description

My-T-Bond® 2689 is high strength adhesive developed for structural applications. It is one component heat curable industrial grade epoxy adhesive. It develops to a tough and strong bond after curing and has good peel strength.

Special features:

- ❖ High Strength
- ❖ High Toughness
- ❖ High Peel strength

Applications:

- ❖ For bonding of sheet metal stiffeners, magnets, magnet core assembly and other structural application where high mechanical strength is desired.
- ❖ For bonding various plastic, metal, glass, ceramic and masonry materials where high strength is required.

Properties

| | |
|----------------------------|--------------|
| Technology | : Epoxy |
| Chemical type | : Epoxy |
| Component | : Single |
| Appearance | : Grey |
| Sp. Gravity @ 25 °C | : 1.16±0.03 |
| Viscosity@25±2°C, | : 5000000 to |
| Brookfield, DV-II, Spindle | 7000000 cP |
| No T-F, Speed 1 r.p.m. | |
| Cure | : Heat Cure |
| Cure Schedule @175 °C | : 25 minute |

Cure

My-T-Bond® 2689 can be cured for 25 minutes at 175 °C. Faster cures can be achieved by using higher temperatures. Cure time will depend upon factors such as part geometry, materials to be bonded, bond line thickness and efficiency of the oven. Cure schedule should be confirmed with actual production parts and equipment. A clamping pressure of 15 psi is recommended to ensure that good contact is maintained during the cure cycle.

Version 1.1

Adhesive Properties of Cured material

Properties after **Heat cure @175 °C for 25 minutes** and cool to room temperature and tested @ 25±2 °C.

Lap Shear Strength, ASTM D 1002

| | |
|-----------|--------------------------|
| Steel | : ≥ 45 N/mm ² |
| Aluminium | : ≥ 20 N/mm ² |

Tensile Strength, ASTM D 897

| | |
|-----------|--------------------------|
| Steel | : ≥ 40 N/mm ² |
| Aluminium | : ≥ 20 N/mm ² |

Peel Strength, ASTM D1876

| | |
|----------------------|------------|
| MS to MS CR- 0.56 mm | : ≥ 8 N/mm |
| AL to Al – 0.8 mm | : ≥ 8 N/mm |
| SS to SS – 0.4 mm | : ≥ 4 N/mm |

Hardness, Durometer- Shore D

| | |
|------------|-----------|
| ASTM D2240 | : 70 – 75 |
|------------|-----------|

**CR-Cold Rolled

Direction for Use

- ❖ For the best performance, the surface should be clean, dry free from oils, paints and dust because the surface preparation is directly depends upon bonding strength and various mechanical properties
- ❖ Apply the adhesive with the help of clean glass rod or suitable means on the substrate
- ❖ To avoid skin contact use safety glove
- ❖ For maximum bond strength apply adhesives on both the surfaces and then wipe of the excessive adhesive
- ❖ During curing process make sure that the substrates remain intact, clamps may be used

Storage and Handling

- ❖ Store product in a cool and dry location in unopened container at 5 °C.
- ❖ My-T-Bond® 2689 will exhibit a shelf life of 3 months from the date of manufacture if stored as indicated above.
- ❖ For longer Shelf life refrigeration must be required.

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- ❖ To prevent contamination of unused product, do not return any material to its original container
- ❖ For further specific information, contact your local Technical Service Center.

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.

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(Bonding and Sealing Solutions)

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