TECHNICAL DATA SHEET
My-T-Bond® 2708
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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® 2708 is an industrial grade general purpose two component epoxy adhesive. My-T-Bond 2708 is a toughened, medium viscosity, Industrial grade epoxy adhesive. Once mixed, the two-component epoxy cures at room temperature to form a tough, off-white, bondline which provides high peel resistance and high shear strengths. The fully cured epoxy is resistant to a wide range of chemicals and solvents and acts as an excellent electrical insulator.

Typical Applications:

The high performance epoxy provides excellent bond strengths to a wide variety of plastics, metals, rubbers and cotton fabric lagging material. Ideal for general purpose industrial applications requiring extended work life for adjusting parts during assembly.

Properties

Technology	:	Epoxy
Components	:	Two component - required mixing
Mix ratio by weight Part A: Part B	:	100 : 50
Mix ratio by Volume Part A: Part B	:	2 : 1
Appearance	:	Off White
Cure	:	Room Temperature
Pot Life @25 ±2 °C(100gm mix)	:	30 minutes
Functional Cure time	:	5-6 hrs
Total Cure time	:	24 hrs
Operating temperature	:	-30 °C to 150°C
Applications	:	Bonding

Physical Properties of Material

Component (A)

❖ Colour	:	Pale Yellow liquid
❖ Sp. Gravity @ 25±2 ºC	:	1.1 ± 0.02
❖ Viscosity, Brookfield @ 25±2 ºC, Spindle 6, Speed 10 r.p.m.	:	60000-90000 cP

Component (B)

❖ Colour	:	Yellow Liquid
❖ Sp. Gravity @ 25±2 ºC	:	1.1 ± 0.02
❖ Viscosity, Brookfield @ 25±2 ºC, Spindle # 6, Speed 10 r.p.m.	:	7000 – 10000 cP

Mixed (Part A + Part B)

❖ Colour	:	Off White
❖ Sp. Gravity @ 25±2 ºC	:	1.1 ± 0.02

Adhesive Properties of Cured Material

Hardness, Shore D, ASTM D2240 : 80±3

Lap Shear Strength, ASDM D 1002, (After 24 Hrs, Cured at 25±2 °C)

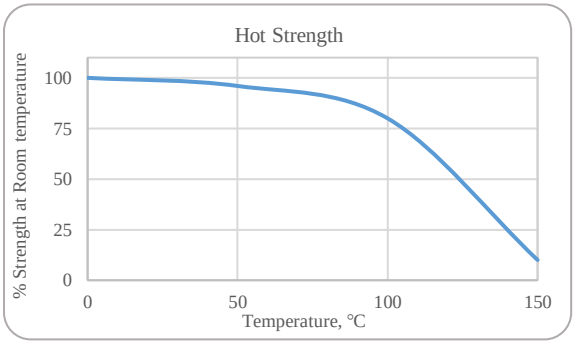
Mild Steel : 20-30 N/mm^2
Aluminium : 13-20 N/mm^2

Impact Strength, ASTM D 950-Mild Steel (After 24 Hrs, Cured at 25±2°C) : >35 N-mm/mm^2

Hot Strength

Test	:	Lap Shear Strength, ASTM D-1002
Substrate	:	Mild Steel
Cure	:	24 hrs @ 25±2 ºC

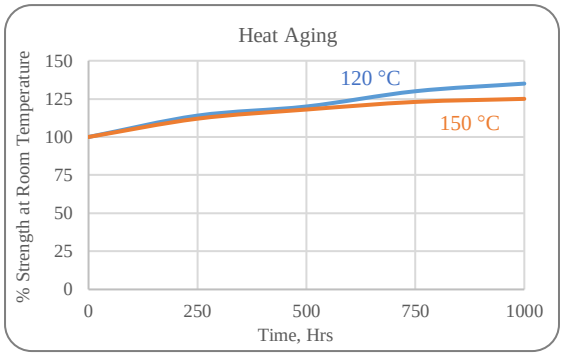
Tested at temperature indicated



Heat Aging

Test	:	Lap Shear Strength, ASTM D-1002

Substrate	:	Mild Steel
Cure	:	24 hrs @ 25±2 ºC



Chemical/Solvent Resistance

Test : Lap Shear Strength, ASTM D-1002
Substrate : Mild Steel
Cure : 24 hrs @ 25±2 ºC

Aged under condition indicated and tested @ 25 ºC

Environment	Temp (^{0}C)	% of Initial Strength
		500 hrs.
Engine oil	120	142
Gear Oil	120	130
Water Glycol (50/50)	87	100

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 easure out the desired amount of Part A and Part B mix thoroughly. Mix approximately 5 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 30 minutes at 25°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 / MEK).
- After use and before adhesive hardens mixing and dispensing equipment should be cleaned with hot soapy water.

Storage and Handling

1. Store product in unopened container in a cool, dry location at 25±2°C.
2. My-T-Bond 2708 will exhibit a shelf life of 12 months from the date of manufacture when stored in above mentioned condition.
3. 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/R&D 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.

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