IX 28201

Two component super clear industrial structure adhesive

Key properties

- Especially suitable for glass,ceramics and other hard transparent material bonding
- Super transparent, Refractive index similar to that of glass
- Excellent resistance to water and oil resistance after cured
- Long operating time
- Low viscosity,Good permeability
- Italian production,Conform to EUR Standards

Description

IX 28201 is a very transparent, two-component, room temperature curing of liquidity liquid adhesive. Resistance to UV and with high strength.Italian production,Conform to EUR Standards.
Particularly suited to solve a variety of transparent structure of hard plastic and metal sealing.
It is a versatile adhesive for the craftsman as well as most industrial applications.

Product data

	28201A	28201B	28201AB mixed
Colour (visual)	Water white	Water white	Water white
Specific gravity	1.12	0.95	1.10
Viscosity at 25°C (mPas)	150	150	150
Pot Life (20 gm at 25°C)	-	-	45 minutes

Processing

Pretreatment

The strength and durability of a bonded joint are dependant on proper treatment of the surfaces to be bonded.At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt.Low grade alcohol, gasoline (petrol) or paint thinners should never be used.The strongest and most durable joints are obtained by either mechanically abrading or chemically etching pickling.the degreased surfaces. Abrading should be followed by a second degreasing treatment

Mix ratio	Parts by weight	Parts by volume
28201A	100	100
28201B	30	35

IX 28201AB should be blended until they form a homogeneous mix.High exothermicity,So every time mixed up to 20 to 30 grams.

Application of adhesive

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces.A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied.Too thick rubber can not bring greater bonding strength.

Equipment maintenance

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation.If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition,avoid skin and eye contact.Used the packing box can't be used again.

Time to minimum shear strength

Temperature	°C	10	15	25	40	60	100
Cure time to reach LSS >1 MPa	hours	24	20	16	3	-	-
	minutes	-	-	-	-	90	15
Cure time to reach LSS >10 MPa	hours	60	48	25	7	-	-
	minutes	-	-	-	-	150	20

LSS =Lap shear strength

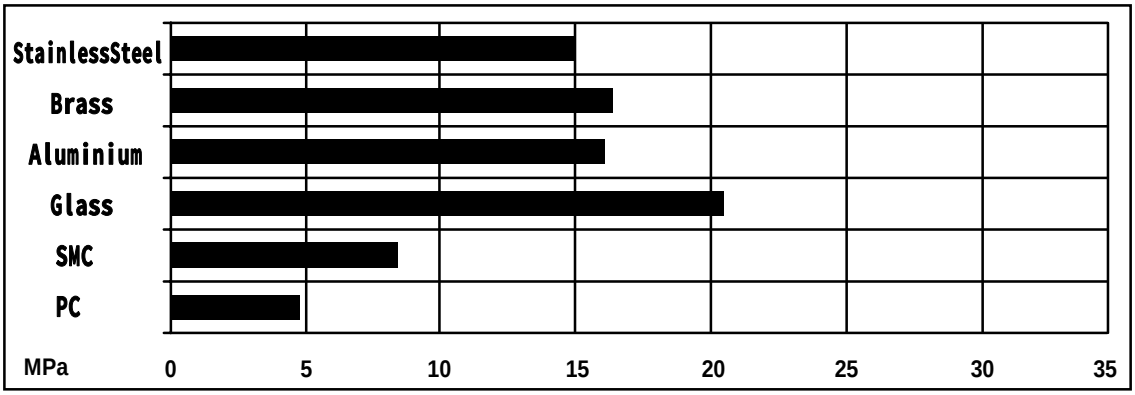
Typical cured properties

Sample standard

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

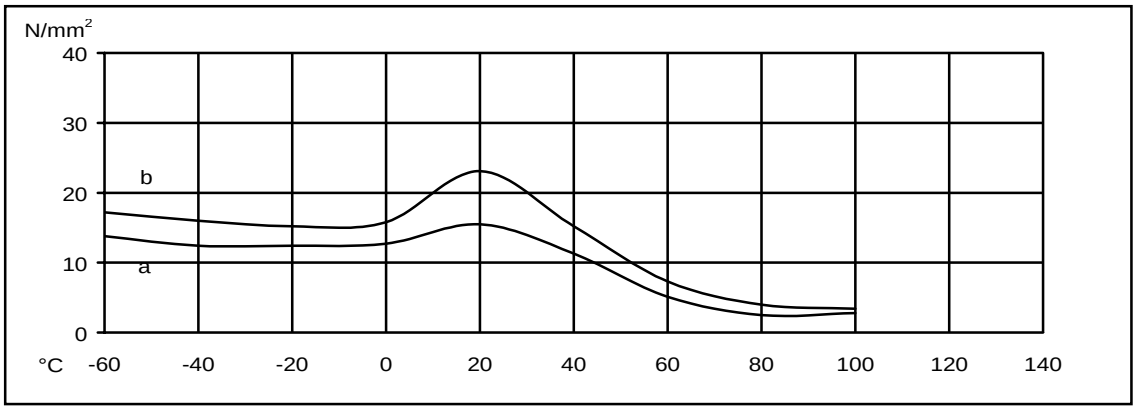
Average lap shear strengths of typical(ISO 4587)

Cure: 72 hour/25°C,tested at 25°C.Metals:Sand blasting,Non-metallic:Lightly abrade.



Lap shear strength versus temperature (ISO 4587) (typical average values)

Cure: a=7 days/25°C,b=24 hours/25°C+30minutes/25°C,tested at 25°C,Sand blasting steel-Sand blasting steel

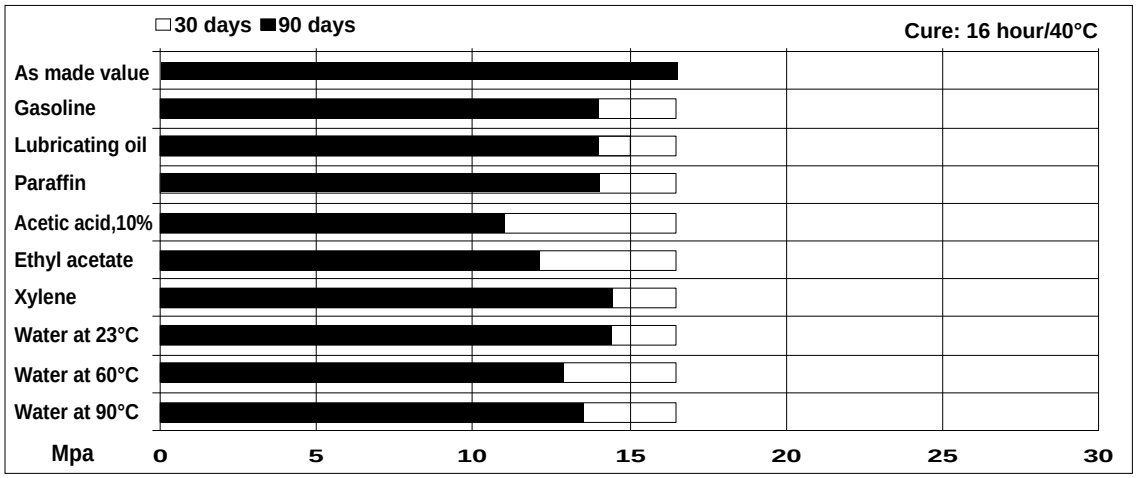


Other typical characteristics

Cure: 72 hour/25°C,tested at 25°C,Sand blasting steel-Sand blasting steel

Water imbibition	ISO62-80	0.6%-0.95%
Water vapour permeability (1mm)	NF41001	13g/m*m/24 hours
Glass transition temperature	ISO4587	55.5 °C
Electrolytic corrosion	DIN50015	A-A/B 1,2
Flexural Strength	ISO178	74.9MPa
Flexural Modulus	ISO178	2467.9MPa
Shear modulus(50 °C)	DIN53445	200MPa
Rollr peel strength	ISO4587	2.21N/mm
100 cycles of 6 hour duration from -30 °C to 70 °C		4.5N/mm²

Lap shear strength versus immersion in various media at 23 °C(typical average values)



Storage

IX 28201 may be stored for up to 36 months at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label.

Handling precautions

Caution

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water.The use of solvents is to be avoided.Disposable paper -not cloth towels -should be used to dry the skin.Adequate ventilation of the working area is recommended.These precautions are described in greater detail in the Material Safety Data Sheets for the individual products and should be referred to for fuller information.

All recommendations for the use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefor. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights.We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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