

# E350

## Steel Epoxy Adhesive 5 Min.

### 1 - Description

AKFIX E350 is a two component, epoxy based, solvent free, fast curing and extremely strong, metal bonding adhesive which develops high strength. The gap filling property makes this adhesive system suitable for rough and poorly fitting surfaces.

### 2 - Properties & Features

- High lap shear strength and durability,
- Very fast cure,
- Cures at room temperature,
- Cures without shrinkage and crack,
- Good gap filling capability,
- Machinable,
- Water and chemical resistant,
- Weather and temperature resistant,
- Easy to mix and dispense,
- Paintable and sandable.

### 3 - Fields of Application

- Bonding for metal, concrete, wood, glass and ceramic.
- Use for repairing machinery, appliances, tools, automotive components, pipes.
- Imbedding bolts and screws into metals, concrete or stone.
- Sealing electrical components.
- Not recommended for polyethylene, polypropylene, nylon, PTFE or flexible plastics.

### 4 - Product Information

<b>Packacking</b>	25 ml Dual Syringe
<b>Shelf Life</b>	21 months
<b>Storage Conditions</b>	Store in cool and dry conditions between +8°C and +30°C
<b>Color</b>	Resin: White, Hardener: Black
<b>Final Color</b>	Dark Gray

## 5 - Technical Data

	Method/Conditions	Value
<b>Basis</b>		Epoxy based
<b>VOC Content (%)</b>	by weight (Resin and Hardener)	0
<b>Mix Ratio</b>	by volume	1:1
<b>Mixed Density</b>		1,15 gr/cm <sup>3</sup>
<b>Density</b>	ISO 1183-1	Resin: 1,16 gr/cm <sup>3</sup> Hardener: 1,13 gr/cm <sup>3</sup>
<b>Set Time</b>	23°C	4-5 min
<b>Handling Time</b>	23°C	20 min
<b>Full Cure Time</b>	23°C	24 hrs.
<b>Gap Fill</b>		Good
<b>Hardness Shore D</b>	after 7 days	80±2
<b>Paintability</b>		Yes (but confirm by test)
<b>Sandability</b>		Yes
<b>Viscosity</b>	ASTM D1084 (25°C)	Resin : 12,000-13,000 cps Hardener: 10,000-11,000 cps
<b>Temperature Resistance</b>		Between -25°C and +100°C
<b>Application Temperature</b>	Ambient and surface	Between +5°C and +25°C

## 6 - Directions for Use

**A. Personal Safety:** Preferably wear gloves during use.

**B. Surface Preparation:** Surfaces must be dry, clean and free from oil, wax and paint. For better bonding slightly roughen surfaces with emery cloth and abrasive paper.

**C. Application:** Remove the end tips of the syringe. Turn syringe end up and pull plunger back slightly allowing air bubbles to rise top. Depress the double piston to dispense equal quantities of both parts into mixing tray. Use mixing stir and mix thoroughly resin and hardener for one minute until homogenous mix is obtained. Apply the mixed adhesive as quickly as possible to one of the surfaces to be bonded by carefully and assemble parts immediately together. Press the two surfaces together and hold in place for 120 seconds. Allow at least 20 min. before handling and for best result do not move the assembled parts until the end of cure duration. The adhesive attains its full strength after 24 hours at 20°C. Working time of the mixed adhesive depends on temperatures and the quantities mixed. Higher temperatures and larger quantities will shorten this working time. Best results are achieved between 20°C and 25°C. After use clean the special cap and close tightly. Always store the adhesive in a vertical position.

**D. Cleaning:** Clean excess uncured adhesive immediately by wiping a clean cloth. Acetone or mineral spirit may be used to assist in removal. Solvents must be always handled with care because they are hazardous and flammable. Follow manufacturer's instructions and test on small area before applying. Cured adhesive can only be removed mechanically; can be cut away with caution using a sharp blade.

## 7 - Safety

Ensure good ventilation of the work station. Wear personal protective equipment. Do not eat, drink or smoke when using this product. Always wash hands after handling the product. Store in a well-ventilated place. Keep cool. Check MSDS guidelines for disposal and further information concerning safety.

## 8 - Disclaimer

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.