EPOXONIC
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EPOXONIC® 382

2-Part-Adhesive
suitable for room temperature curing

EPOXONIC® 382 is a solvent-free 2-part adhesive based on epoxy resin.

Main characteristics:

- Low viscosity
- Room temperature cure
- Transparency

Application:

EPOXONIC® 382 is characterized by very low viscosity and proper curing at room temperature, even in thin layers. Large area bonding of temperature-sensitive substrates can be realized.

Properties:

Specific values measured by standard test specimen at 23 °C, cured 10 h / RT + 12 h / 50 °C.

Operating temperature [1)]	-40 °C to +150 °C	
Colour	transparent, slightly yellowish	
Shore hardness	85 Shore D	DIN EN ISO 868
Density	1.1 g/cm^3	DIN EN ISO 1183-1
Glass transition temperature	65 – 75 °C	DIN EN ISO 11357-2
Shear strength on		EPOXONIC PV 29
Aluminum	45 MPa	
PA 6.6	34 MPa	
PA 6	35 MPa	
PC	41 MPa	
PVC	31 MPa	
ABS	34 MPa	
Bending strength	115 MPa	DIN EN ISO 178
E-modulus	3,200 MPa	DIN EN ISO 178
Outer fibre strain at break	6 %	DIN EN ISO 178

1) Depending on the application, other temperature limits may be reasonable

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Processing:

Mix ratio		Part A : Part B = 100 : 25 parts by weight Part A : Part B = 3 : 1 parts by volume	
Viscosity cone/plate viscometer	 25 °C 25 °C 25 °C	 1,200 – 2,000 mPas (Part A) 10 – 100 mPas (Part B) 200 – 700 mPas (Mixture A + B)	DIN 53019
Pot life	25 °C	20 – 25 min (time to double viscosity, 25g-mixture)	DIN EN ISO 10364
Method of application		e.g. dispenser	
Shear strength increase on Aluminum at 25 °C		Further processing 3 h > 2 MPa Functional strength 6 h > 10 MPa Final strength 24 h 40 MPa Ultimate strength 46 MPa (10 h / RT + 12 h / 50 °C)	
Cure schedule		e.g. 10 h / RT + 12 h / 50 °C Optimum cure schedules have to be determined by the specific application.	

Storage:

The shelf life of EPOXONIC® 382 Part A and Part B is 6 months at temperatures < 25 °C when stored in tightly closed, original containers.
EPOXONIC® 382 Part A may crystallize during storage. This does not affect the resin quality. If crystallization occurs, the entire container must be completely heated to 60 - 70°C, the content liquefied and homogenized. Partly emptied containers should be tightly closed immediately after use.

Health and Safety:

Recommended industrial hygiene procedures should always be followed when handling this product. Please refer to the corresponding Material Safety Data Sheet for details.

Packaging:

EPOXONIC® 382 Part A is delivered in metal cans. The Part B is delivered in cans with a pour spout. Other packaging options are available upon request.

Quality Assurance:

If required EPOXONIC® 382 will be supplied with a Certificate of Analysis.

Disclaimer:

All information herein is based on the present state of knowledge and believed to be reliable. Any suggestions or recommendations are made without liability on our part since we shall have no control over the use of our product. Buyers and users should make their own assessment of this product under their own conditions and for their own requirements.