

## 1-PART STRUCTALIT®

Follow the instructions in our technical and safety data sheet before processing.

### PRODUKT SPECIFICATION

**1-part Structalit® materials are epoxy products that can be thermally cured.**

### PREPARATION

Cold-stored adhesives should be conditioned to room temperature before application.

The parts to be joined should be free of contaminants such as grease, oil, and dust in order to achieve the optimum bond strength. Isopropanol can be used as a cleaning agent. In addition, the parts to be joined should also be conditioned to room temperature if they have been stored in a cool place.

### PROCESSING

Depending on the area of application, dosing can be carried out directly from the original container or after transfer to a dosing system.

The product-specific working life at room temperature can be found in the technical data sheet.

The 1-part Structalit® products are cured by applying heat. A too low curing temperature or time can lead to incomplete curing of the adhesive. As a guide value for the curing times of the pure adhesive at certain temperatures, values are given in the technical data sheet. The heating time of the parts to be joined must be added to the stated time. The curing time can also be influenced by the amount of adhesive and layer thickness.

### STORAGE

Store the supplied adhesives in accordance with the temperatures specified in the technical data sheet. Adhesives and parts to be joined that are stored in a cool place must be conditioned to room temperature before processing. Frequent temperature changes can damage the adhesive, as can frequent opening and closing of the container.

### DISPOSAL

Used cleaning cloths, containers and adhesive residues in uncured form should be disposed of as hazardous waste. They can be collected in a closed container. Once hardened, they can be disposed of as household waste.

### CONTACT

Hoenle Adhesives GmbH | Stierstädter Straße 4 | 61449 Steinbach | Germany  
T: +49 6171 6202-0 | adhesivesystems@hoenle.com

For regional sales and technical support, please refer to our global contact directory  
<https://www.hoenle.com/contact>.