

# PROCESSING INSTRUCTIONS



## 2-PART STRUCTALIT®

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

### PRODUKT SPECIFICATION

**2-part Structalit® products are epoxy products that can be cured at room temperature and at elevated temperatures.**

### 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 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

The two components must be mixed for curing.

Some of the products are available in 50 ml double-chamber cartridges and can be mixed and dispensed using static mixing tubes and a dispensing gun. A dispensed bead of adhesive in the length of a mixing tube should be discarded first, as it may not yet be optimally mixed.

For larger dosing quantities, the components are available individually in cans and drums. These can either be integrated into an automatic dosing system or weighed and mixed manually in the specified mixing ratio.

The exothermic reaction of larger mixing batches can lead to a strong development of heat. Therefore, if in doubt, the batch size should be divided into several portions.

After mixing the products, the pot life specified in the technical data sheet must be observed.

The technical data sheet contains guide values for the curing time of the mixed adhesive. The actual curing time in the application depends on factors such as temperature, quantity and mixing quality.

### 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.

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### CONTACT

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