

KEOL**EPOXY ADHESIVE****K-POXY 261**

261 adhesive from the K-POXY range is a versatile easy to use solvent free epoxy adhesive, which can be used to bond or repair most materials such as wood, metal, glass, ceramic, plastics and rubbers. The product hardens in 5 minutes with high bond strength and chemical resistance.

- WITHOUT SOLVENT
- CHEMICAL RESISTANCE
- STRONG ADHESION

BASE CHIMIQUE	Epoxy
WORKING LIFE	5min
COLOR	Clair
SHORE D	78-80D
VISCOSITY	15000 – 20000

PROPERTIES	K-POXY 261
Mixed Viscosity @ 25 0C	15 000 – 20 000 mPa.S
Mixing Ratio	1:1 vol/vol or wt/wt
Working Life	5 minutes
Specific Gravity	1.1
Percent Solid	100
Adhesive Set-up Time	2-3 Hours
Shore Hardness D	78 – 80 (ASTM D 2240)
Shear Strength (N/mm2))	14 – 18 (DIN 53283)
Peel Strength (N/mm)	3 – 5 (ISO 4578)
Thermal Conductivity (W/mK)	0,1
Coefficient of thermal expansion (1/k)	60 – 120 x 10 E ⁻⁶
Dielectric Strength (kv/mm)	50-90
Volume resistivity (OHM/cm) 3 – 5 x 10 E 12	3 – 5 x 10 E ¹²
Service Temperature -40 °F to 250 °F	-40 °C to 250 °C

KEOL**EPOXY ADHESIVE****LAP SHEAR STRENGTH DATA**

261 adhesive from the K-POXY range formulated to bond wide variety of substrates. Lap shear strength data according to ASTM D 1002 reported for the most common substrates:

Substrates	Shear Strength & Failure Mode
CRS / CRS	2,350 psi – Cohesive Failure
Aluminum / Aluminum	1,950 psi – Cohesive Failure
Copper / Copper	1,850 psi – Cohesive Failure
FRP / FRP	900 psi – Fiber Tear
ABS / ABS	850 psi – Substrate Failure

**CHEMICAL RESISTANCE DATA**

The chemical resistance of **261 adhesive from the K-POXY range** was studied by bonding the Aluminium/Aluminium as per specification and cured for 7 days @ 25o C then kept immersed in the media listed here and tested for lap shear strength.

Effect of immersion in different media.
(Immersion for 7 days in various media)

MEDIA	LAP SHEAR (ASTM D 1002) Strength, in PSI
Gasoline	2550
Acetic acid(10%)	2180
Xylene	2165
Lubricating oil-HD30	2400
Paraffin	2275
Water@23 °C	2355
Water@90 °C	2325

**SURFACE PREPARATION**

To achieve maximum performance from **261 adhesive from the K-POXY range** it is essential that all substrates are clean, dry and free from surface contaminations such as oil or grease. Surfaces may be sanded to get the optimum bond strength.

Mix **261 adhesive from the K-POXY range** of Part A to Part B of equal amounts. Mix two parts thoroughly for optimum performance. The epoxy can be dispensed, metered, mixed and directly applied to the bonding surface.

After mixing, the adhesive should be applied directly to the surfaces to be bonded. If an insert is to be bonded in a socket or curved, surfaces to be fixed slight rotating of the units will eliminate any air entrapment and fully wet out both surfaces.

Edge to edge bonds should be supported. Adhesive thickness of .005 inch (5 Mil) will provide the maximum bond strength.

**APPLICATION OF THE PRODUCT**

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EPOXY ADHESIVE



PRODUCT STORAGE

261 adhesive from the K-POXY range may be stored for up to 3 years at room temperature provided the components are stored in sealed containers.



PRECAUTIONS

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; like wise 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.



NOTE

The information, and particularly the recommendations regarding the application and KEOL products, are given to you in good faith and are based on current knowledge and experience with products which have been properly stored, handled and applied under normal conditions. KEOL cannot take responsibility for the results obtained by others since we have no control over their method.

It is up to the user to determine the suitability of the products for the specific application for any production methods mentioned in this document. Also, it is up to the user to adopt the necessary precautions as recommended for the protection of the establishment and of people against all kinds of risks that may arise during the handling and use of the products.

KEOL cannot assume all the guarantees mentioned or implied, including guarantees of market value or of conformity for a specific reason, arising from the sale or use of KEOL products. KEOL cannot assume responsibility for any incidental consequences or damages of any kind, including lost profits.

Users should always refer to the most recent edition of the technical data sheet for the product concerned. Copies of this document will be provided upon request.