PRODUCT DATA SHEET

Casco® Strong Epoxy Metal

Epoxy-based two-component metal colored hard wearing epoxy adhesive

DESCRIPTION

Suitable for filling small holes in radiators. Bonds metal (steel, aluminum, iron) parts amongst themselves or to stone, wood, concrete and various synthetics (such as Formica, polyester and Bakelite).

USES

Ideal for hard wearing repairs to metal objects which need to resist extreme conditions (forces, vibrations, (sea) water, heavy strains), such as tools or parts of a car, motorcycle, bicycle or moped, metal (garden) fences or cutlery.

CHARACTERISTICS / ADVANTAGES

▪ High resistance to chemicals
▪ Resistant to extreme conditions
▪ Gap-filling
▪ (Sea)water resistant
▪ Metal coloured joint
▪ Can be sanded, filled, drilled and painted after curing

SUSTAINABILITY

For the product's assessment in the different building criteria systems, see MiljöAppen.
Here you will also find information about EC1, M1, link to the building product declaration, safety data sheets etc.
The MiljöAppen, can also be reached by entering www.sikamiljoapp.se in your web browser.

PRODUCT INFORMATION

Composition	Resin: Epoxy resin Hardener: Modified amine
Packaging	2 x 12 ml syringe
Shelf life	At least 24 months after date of manufacture (can be read on the top of the syringe/syringe holder (4 digit code: week: 01-52 Day: 1-5 Year. 2-.
Storage conditions	Cool, frost free and tightly closed.
Colour	Dark grey metal
Density	~ 1400 kg/m³
Solid content by mass	100 %
Consistency	Pasty
Volatile organic compound (VOC) content	None
Service temperature	-40 °C to +60 °C
Chemical resistance	Very good to normal house-hold chemicals and solvents

Resistance to moisture	Very good. Can stand permanent moisture on non- porous materials but in permanent contact with water the adhesive is not suitable. The water resistance is determined by the glued materials water resistance.
Mixing ratio	1 : 1
Consumption	1 ml = approx 1 cm² at a film thickness of 1 mm
Material temperature	+5 °C and +35 °C
Open Time	After mixing resin and hardener the mixture must be used within 45 minutes at +23 °C.
Curing time	~ 24 hours. Curing takes longer at lower temperatures, and shorter at higher temperatures.

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The surfaces to be glued must be clean, dry and free from grease.
Clean the surface with a good degreasing agent such as thinner or acetone.
For even better bonding slightly roughen surfaces with sandpaper.

MIXING

Equal parts of hardener and resin (by volume 1:1). Do not use the surface which is going to be assembled as mixing under layer. This will affect correct hardening and also cause bad adhesion.

APPLICATION METHOD / TOOLS

SYRINGE PACK

Cut the ends from the nozzles where marked.
Remove spatula from side of double syringe and cap from handle. Break safety seal of double syringe. Dispense equal amounts onto a clean disposable surface. Mix well until a homogeneous colour is obtained, however not more than it is expected to be used within approx. 45 minutes.
Apply a thin layer to one surface. Join immediately and hold in place for 10 hours.
Do not move bonded parts until after complete cure. After use, clean nozzles with a cloth and place special double cap from handle on double syringe. Do not mix resin and hardener unless for bonding.
Heat - curing will shorten the curing time and make the joint stronger.

CURING TIME

Temp °C	10	23	40	100
Cure time to reach LSS> 1 N/mm²	17h	4h	90min	6min
Cure time to reach LSS> 10 N/mm²	27h	10h	2h	6min

LSS = Lap shear strength

Note! Professional application with heat, always use an oven with a pressure below that of the atmosphere.

LIMITATIONS

"Greasy" plastics like polyethylene, polypropylene and Teflon cannot be bonded.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Casco products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always

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refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request or on the website www.casco.eu.

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