

PRODUCT DATA SHEET

Casco® Strong Epoxy Professional

Epoxy based, two component adhesive

DESCRIPTION

Epoxy based, two component adhesive joint is resistant towards water, normal household chemicals and solvents of different types.

USES

For gluing of metals, pottery, porcelain, crystal, glass, ivory, pearls, precious stones and numerous synthetics (such as polyester, Bakelite, Formica, rigid polystyrene and acrylic glass.

FEATURES

- High shear and peel strength
- Withstand temperatures up to approximately +60°C
- Gap-filling
- Good choice when bonding between tight materials
- Good resistance towards dynamic loading
- Can be over painted
- Very good long term performance

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 2 x 100 ml tubes
Colour	Light yellow
Shelf life	At least 36 months after date of manufacture (can be read on the top of the syringe/syringe holder (4 digit code: First digit= Year, rest of the digits= day of the year)
Storage conditions	Cool, frost free and tightly closed
Density	Approx. 1170 kg/m ³
Volatile organic compound (VOC) content	None
Consistency	Slightly thixotropic
Solid content by mass	100%

Service temperature	-20°C to +60°C
Mixing ratio	1 : 1
Consumption	1 ml = approx 1 cm ² at a film thickness of 1 mm.
Material temperature	+5°C - +35°C.
Open Time	Approx. 7 hours
Curing time	Approx. 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

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The surfaces to be glued must be clean, dry and free from grease. For even better bonding; slightly roughen surfaces with sandpaper. Remove the dust. Glass should be washed with an alkaline detergent, rinsed in clean water and allowed to air-dry.

MIXING

Equal parts of resin and hardener (by volume or weight). 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. After use – don't forget to seal the nozzles with the cap located in the plunger handle, the cap will only fit in the right way.

TUBES

The tubes are opened by pressing the points of the caps through the metal membranes. After use; put the caps back on the tubes again. Be sure the caps are not interchanged.

Dispense equal quantities of both parts into enclosed mixing tray. Stir well using a spatula until mixture has a uniform color. At room temperature (+20°C), mixture remains workable for approx. 1,5 hours. Apply a thin layer to one surface. Join immediately and hold in place for 7 hours.

Do not move bonded parts until after complete cure. Do not mix resin and hardener unless for bonding. Full strength is obtained after approx. 24 hours. Heat-curing will shorten the curing time and make the joint stronger.

Note! The yellowing of the product will increase with heat curing.

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

TIMES TO MINIMUM SHEAR STRENGTH

Temp °C	10	23	40	100
Cure time to reach LSS> 1 N/mm ²	24h	7h	2h	6min
Cure time to reach LSS> 10 N/mm ²	36h	10h	3h	7min

LIMITATIONS

Not suitable for gluing Polyethylene (PE), Polypropylene (PP) and silicone rubber.

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 re-

serves 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 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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