

PRODUCT DATA SHEET

Casco[®] Strong Epoxy Rapid

Epoxy based, two component adhesive ideal for fast, strong and invisible repairing

DESCRIPTION

The adhesive joint is resistant towards water, normal household chemicals and solvents of different types. Can be over painted.

USES

Ideal for fast, strong and invisible repairing of pottery, porcelain, glass, leather, wood, stone, metal and ceramics to themselves or to each other.

FEATURES

- High shear and peel strength
- Withstand temperatures up to approximately 100°C
- Ideal for filling cracks thanks to filling capacity
- Good choice when bonding between tight materials
- Rapid curing
- Very good long term performance
- Crystal clear

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
Shelf life	At least 36 months after date of manufacture
Storage conditions	Cool , frost free and tightly closed.
Colour	Transparent
Density	Approx. 1160 kg/m ³
Solid content by mass	100%
Consistency	Liquid
Volatile organic compound (VOC) content	None
Service temperature	-40°C to +100°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	After mixing resin and hardener, the mixture must be used within 5 minutes at +23°C.
Curing time	~1 hour. 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. 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

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 – do not 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.

Remove spatula from side of double syringe and cap from handle. Break safety seal of double syringe. Dispense equal quantities of both parts into enclosed mixing tray. Mix well using enclosed spatula. At room temperature (+20°C), mixture remains workable for approx. 5 minutes. Apply a thin layer to one surface. It is important that the adhesive covers the whole surface to be glued. For this reason a thin layer of adhesive is recommended to be applied on the two surfaces to be glued. This is especially important if the surfaces are uneven.

Join immediately and hold in place for 20 minutes. 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. Resin and hardener should not be in contact when not in use. Full strength is obtained after 16 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.

Temp. °C	10	23	40	100
Cure time to reach LSS> 1 N/mm ²	35	20	5	<1
FCure time to reach LSS> 10 N/mm ²	120	60	25	2

LSS = Lap shear strength

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

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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 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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