



Technical Datasheet

HOLDIT EPOX

Revised Date: June 2011

Description

A fast curing, two part epoxy adhesive packed in an easy to use double syringe dispenser containing 24ml of adhesive. The correct ratio of hardener and resin is guaranteed on each application. EPOX contains a specially formulated epoxide resin/hardener system designed to provide rapid setting and strength development when mixed.

Applications

EPOX is an effective adhesive for wood, metals, ceramic, fibreglass and most plastics. Typical applications include repairs and renovation of metal castings, ceramic tiles, vessels or ornaments, wooden, metal or plastic furniture, stone or concrete paving slabs or copings.

EPOX is particularly useful for securing household fittings to brick, plaster, wooden or plastic surfaces, laminating melamine surface sheet to wood or block board, modelling and test rig manufacture.

EPOX is an ideal adhesive for most plastics but is not suitable for polythene, polypropylene or plasticised PVC. If in doubt, carry out a small trial with the adhesive before using on a large application.

Once the pack has been opened, the cap (which is contained within the plungers) should be removed and placed over the open ends of the syringe. The cap will fit in only one way to avoid contamination.

Instructions for Use

1. Materials to be repaired should be clean, dry and lightly roughened to provide a good mechanical key.
2. Cut off nozzle tip from each barrel of the syringe. Extrude the required amount and mix the two components for approx. 30 seconds until an even colour is achieved.
3. Where large repairs are being carried out, it may be necessary to hold the work piece together for a short time with adhesive tape. The piece can be handled gently after 30 minutes.
4. Remove any excess resin before it cures with cellulose thinners, paint brush cleaner or nail varnish remover. Methylated spirit or white spirit are less effective but may be used if no other solvent is available.

Technical Features

Resin	Epoxide
Colour	Amber
Specific Gravity	1.08
Shelf Life	12 months

Performance of Cured Material

Gel Time	5 Minutes
Full Cure Time	8 Hours
Temperature Range	-40°C to 93°C
Lap Shear Strength	17 N/mm ²



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Properties

After mixing, EPOX starts to gel within 5 minutes @ 20°C. Strength gain is rapid and sufficient for most applications within 30-60 minutes at 20°C. Full cure is achieved within 8 hours at this temperature. The fully cured material will withstand occasional short term contact with hot water, i.e. For cleaning purposes. Immersion in hot water for extended periods may impair the bond and should be avoided.

Health & Safety in Use

EPOX contains epoxy resin and may cause skin irritation in sensitive individuals. Unnecessary skin contact should therefore be avoided. If skin contact occurs, wash with a proprietary hand cleanser such as Swarfega, followed by washing with soap and water. In case of eye contact, flush with clean water for at least 15 minutes, then seek medical attention. When fully cured, the product can be considered non-toxic.

Storage

Store in cool conditions, preferably away from direct sunlight or excessive heat. Shelf life 12 months.

Presentation

Epoxy is available in a 25ml, and 50ml cartridges.

Conversions

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$