

TECHNIGLUE-HP R15 is a soft, thixotropic, solvent-free, epoxy paste, specifically formulated for use with H15 hardener to cure at room temperature and produce a high strength structural adhesive for bonding of metals, particularly aluminium and steel.

H15 has been formulated to overcome the problem of peeling failure at the metal-resin interface, by increasing the peel strength of the bond, with negligible reduction in other adhesive properties.

TECHNIGLUE-HP R15 offers high chemical resistance, high compressive & tensile strengths, and also has excellent adhesion to all normal substrates.

MIX RATIO

1 part hardener to 1 part resin by weight or volume.

Take care to ensure that the components are thoroughly mixed to a uniform colour before applying.

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.

UNCURED PROPERTIES

	R15	H15
Physical State	White thixotropic paste	Beige thixotropic gel
Viscosity mPas @ 25°C	soft gel	80,000 to 100,000
Specific Gravity g/ml @ 25°C	1.18	1.18

CURE CHARACTERISTICS

	H15
Pot Life -100g @ 25°C (in air)	35 minutes
Cured to a solid state @ 25°C	4 hours
Working Cure	10 hours
Shore D hardness @ 1 day	75
@ 2 weeks ambient	77
HDT after 24 hours @ 25°C	40°C
2 weeks @ 25°C	52°C
+16 hours @ 50°C	62°C
+ 8 hours @ 60°C	62°C

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 20/10/06

APPLICATION

All surfaces should be clean and free from grease and/or loose particles. For best results and high-strength bonds to occur, the adhesive must be capable of wetting both surfaces, this is best achieved by a uniformly, finely roughened (matt) finish.

PACK SIZES

Order Code		Order Code		PACK
Resin		Hardener		
RA15	500 ml	HA15	500 ml	1 L
RB15	1 L	HB15	1 L	2 L
RC15	4 L	HC15	4 L	8 L
RD15	20 L	HD15	20 L	40 L

STORAGE

TECHNIGLUE-HP R15 resin and H15 hardener will keep for one year if kept in original containers at room temperature (15°C to 32°C) and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

HEALTH & SAFETY

TECHNIGLUE-HP R15 resin and H15 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.

- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.

- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.

- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.

Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.



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