

TONGXUE ADHESIVE -GLUE CATALOGUE



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7.1. Epoxy Composite Adhesive F104



Product introduction:

F104 modified epoxy composite adhesive is a high performance two-component solvent-free structural adhesive. It is formaldehyde-free, benzene-free, safe and environmentally friendly. Because it is obtained by modifying epoxy resin, it has certain toughness, high bonding strength, long construction time, easy to squeegee, temperature resistance, water resistance, heat and humidity aging, acid and alkali corrosion resistance, etc. . The main agent (A) and the curing agent (B) are mixed and used in a weight ratio of A:B=2:1.

Due to its good resistance to high and low temperature, it can be used for a long time at -30 °C - 90 °C, and higher than 90 °C is not recommended for long-term use. Compared with polyurethane adhesives, it is better in temperature and humidity resistance, and can be used in high temperature and high humidity places for a long time, such as shower room and bathroom.

Scope of application:

Mainly used for bonding various sandwich composite boards (such as aluminum honeycomb panels, aramid paper honeycomb panels, plywood, fireproof panels, etc.), widely used in metal composite panel curtain wall and other products, for metal, wood, stone, ceramics, glass, etc. Both have excellent adhesion properties. For PP, PE, PET, PS, PVC and other common plastics, it is difficult to form a good bond. It can not be used directly. It needs to be surface treated and activated before bonding. Other types of plastics are difficult to determine accurately because of their variety, and the composition may be slightly different, resulting in different bonding effects. To use this product, please perform sample bonding beforehand to determine whether the adhesive is suitable.

Technical parameters (the following parameters are tested at 23-25 °C)

Indicators	Component A	Component B
State	Fluid	Fluid
Color	Gray to light beige	Beige
Density (g/cm ³)	1.53±0.05g/cm ³	1.35±0.05g/cm ³
Viscosity	15500±2500mPa s	13500±2500mPa s

Mixing ratio (by weight)	2 : 1
Mixed density	1.41±0.05g/cm ³
Usage time	40--60 minutes (after mixing) can be adjusted according to production needs
Mixed state	Easy to apply scraping fluid
Sizing amount	300 -500g/m ²
Initial adhesion formation time:	6-8 hours
Full adhesion formation time	5-7 days
No exothermic peak	20 days
Glass transition temperature Tg	75--80°C
Roller peel strength	>50(N.mm)/mm
Steel shear strength:	>15MPa
Plane tensile strength	>2MPa
Hardness (Shao D):	80
Environmental performance:	TB 3139/GB18583
Applicable temperature after curing:	-30--90°C

Precautions:

1. Before mixing the mixture, separately mix the main agent (A) and the curing agent (B) in the barrel as appropriate.
2. When using, the amount of glue should not be too much, so as to avoid accelerated heating due to exothermic reaction, shorten the pot life, and make the unused glue quickly thicken and solidify in the barrel, resulting in waste.
3. Pay attention during use, pay attention to ventilation on site, avoid direct contact with uncured glue, so as to avoid skin allergies. Wear protective gloves.
4. The main agent and curing agent will become viscous when it is below 15 °C. It must be heat treated (heating temperature is 40-60 °C) to make it have certain fluidity for construction.

5. Recommended operating environment: 10-35 ° C, humidity 0-80%.

6.F104 can be used at room temperature; below 15 °C, the curing speed is slow and the curing is incomplete (if you want to speed up the curing speed, it can be heated and cured); it can be heated and cured, 60-70 °C curing time is 60 minutes, 80 °C curing The time is 15-25 minutes.

7. The bonded substrate must be surface treated: decreasing, drying, dust removal (and other contaminants), rust removal, such as: must be polished before use to remove the oxide film on the surface of the aluminum, and Pay attention to the timeliness of the current grinding; or purchase the epoxy-coated aluminum plate; if the conditions and requirements can be anodized, the primer or anodizing can significantly improve the bonding strength and durability.

8. F104 must be mixed according to the mass ratio A:B=2:1, and mix evenly (the A and B glues are mixed and the color is no longer changed). The machine speed should not be too fast when stirring. It is recommended to use a speed mixer and the speed is controlled at 100r/min. Then, the evenly mixed gel is coated, smoothed and smoothed on the required plate with a scraper. The amount of glue is 0.4-0.5kg per square meter. The recommended dosage is 0.45-0.5kg/m².0.5KG.

9. Storage must be in a dry indoor environment, protected from light, the original packaging should be sealed and moisture-proof after opening. It is recommended to store at 5--30 °C; avoid storage under direct sunlight, high temperature, frost, and humid conditions..

10. Shelf life: 12 months in original packaging.

11. Packing: main agent (A) 25 kg plastic drum, curing agent (B) 25 kg plastic drum, can also be canned according to customer requirements.