

BOSTIK ARALDITE® PRECISION SYRINGE

TWO PART, MULTIPURPOSE, EPOXY RESIN ADHESIVE

ARALDITE® PRECISION is a two-part adhesive supplied in a double syringe. It is a tough adhesive with a long pot life for precision positioning. It is solvent free, room temperature curing, high strength adhesive.

RECOMMENDED USES

ARALDITE® PRECISION will bond a variety of materials around the home including metal, wood, ceramics, masonry, glass, dry concrete, chipboard, leather, cardboard and most hard plastics, fabrics and rubbers.

IMPORTANT: ARALDITE® PRECISION is not suitable for bonding rear-view mirrors to car windscreens. Do not use for items which may contain food or drink, as the joint however secure and clean it may appear, may entrap bacteria from the environment. Not intended for repairs on safety critical items e.g. rotating parts of hover mowers. Please note that some items are moulded from polymers such as polythene or polypropylene, for example, and are simply not designed for repair. Repair may not be viable or would need specialist chemical treatment to achieve a bond.

BONDING INSTRUCTIONS

1. Make sure surfaces are dry, clean and free from dust, dirt and grease. For even better bonding slightly roughen surfaces with sandpaper.
2. Remove the cap from centre of the 'plunger' so that the syringe may be sealed after use.
3. Following the instructions on the back of the blister card, dispense equal volumes of resin and hardener onto a clean disposable surface. Mix well for 30 seconds, by stirring and folding, with the plastic palette knife provided. It is important to ensure a thorough mix.
Reseal the syringe as directed on the blister card as soon as possible.
4. Apply the mixed adhesive to both surfaces of the joint and assemble carefully. A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint.
5. Keep the joint supported until set. A rubber band or sticky tape is ideal. An approximate guide to support and handling times at room temperature is given below:

Pot life: 2 Hours, approximately at 23°C (RT)
Support time: 6 Hours at RT (4 Hours at 40°C)
Handling time: at least 16 Hours.

Setting times may be shorter in hot weather. In cold conditions the rate of curing of the mixed adhesive may be slowed down significantly and weak joints may result. For best results use between 20°C and 25°C.

6. For a perfect finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

CLEANING

- ◆ Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners or acetone. Solvents must always be handled with due care as they may be hazardous or flammable.

Methoxypropanol is an alternative solvent which significantly reduces the flammability hazard. Please note that solvents may attack some rubbers, plastics, painted surfaces, fabrics, etc.. Bear this in mind if intending to use solvent to remove excess adhesive, and carry out a preliminary test first.

- ◆ Cured adhesive residues can usually be dissolved from tools by soaking in commercial paint stripper. Refer to the paint stripper manufacturer's instructions for use and safe handling.
- ◆ The adhesive may be removed from the skin using a suitable proprietary hand cleaner. Contact with the skin should however be avoided. Do not use solvents in contact with the skin. Always open and use adhesive products over a protected surface, and avoid contact with clothing.

PACKAGING Code: 80807 SYRINGE x6

HEALTH AND SAFETY Available separately in files named as the packaging code above.

SHELF LIFE: 3 years if stored as directed below

STORAGE & TRANSPORTATION: Store under dry conditions between 5°C and 25°C.

SPECIAL INFORMATION

- ◆ Thorough mixing is the key to getting a good cured product. Simply stirring leaves unmixed materials at the margins. Always fold in the edges then re-stir.
- ◆ Cured adhesive may yellow if exposed to sunlight for long periods.

TYPICAL ADHESIVE CHARACTERISTICS

	<u>RESIN</u>	<u>HARDENER</u>
Physical form:	Liquid	Liquid
Chemical type:	Epoxy Resin	Polyaminoamide
Viscosity:	Slow flowing	Slow flowing
Solids content:	100%	100%
Colour:	Colourless	Pale yellow
Density (SG):	1.15	0.95
Colour mixed:	Pale yellow	

TYPICAL PERFORMANCE CHARACTERISTICS

Cured Density (SG):	1.05
Temperature:	-50°C to +65°C depending on conditions of use
Water:	Not intended for constant immersion
Oil & Petrol:	Good resistance.
Chemicals:	Good resistance.
Sandability:	Sandable when set. Please wear dust mask.
Paintability:	Good, but confirm by test. Fine sanding helps.

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