



2K Metal Epoxy Adhesive

A two-component, modified epoxy adhesive with shiny steel finish for strong repairs on many substrates.



Features & Benefits

- High peel strength – excellent adhesion properties
- High impact resistance – withstands high shocks over short periods of time
- Thixotropic – for vertical and overhead applications
- Fast curing – reducing the downtimes
- May be machined, drilled, tapped or sanded – for a wide range of applications
- Excellent resistance to many chemicals – for applications in harsh environments

P/N	Product	S/C	Packaging
86490	2K Metal Epoxy Adhesive	2KMEA	50 ml cartridge with nozzle
86031	Nozzles	-	Pack of 6 short mixer nozzles
84005	Dispensing gun	-	1 unit

Applications

2K Metal Epoxy Adhesive has been designed to make fast repairs to damaged metalwork such as castings, pipes, valves and engines.

Typical uses include: door skins, bumper assemblies, automotive spoilers, vents, housings, mouldings, signs and displays.

2K Metal Epoxy Adhesive can be machined, drilled, tapped or sawn in the same way as solid metal. This adhesive can be used on all common metals to provide an almost invisible repair on the darker surfaces like iron and steel.

Instructions

When components are mixed together, heat is generated. The amount of heat will depend on the thickness of the bond line.

1. Abrade surface to be bonded with medium grit paper, then wipe clean. Cleaning with KENT Acrysol or Soft Surface Cleaner is preferred.
2. Balance cartridge.
3. Attach correct nozzle and insert into dispensing gun.
4. Apply 2KMEA to one surface, press parts together with finger pressure. Ensure that the bond gap is completely filled when the two parts are joined. Allow for squeeze out at the edges of the bond, to ensure even filling. Do not apply excessive pressure that may cause an excessively thin bond line.
5. Working time is 3-6 minutes.
6. Use a sharp paring tool to remove excess adhesive, partially cured adhesive can be removed with sharp knife, cured material can be removed by sanding/scraping.



Technical Information

Base material:	Modified epoxy adhesive
Consistency:	Thixotropic paste
Colour:	Shiny steel
Shelf Life:	12 months
Customs Tariff Code:	3506 1000 (adhesive) 3923 50 90 00 (nozzles)
VOC:	0 g/l

Cure mechanism:	Exothermic	Tensile strength :	35 MPa (ASTM D638)
Mixing ratio:	1:1	Lap shear steel/steel:	9 MPa
Specific gravity:	1.23 g/ml	Lap shear alu/alu:	7 MPa
Working time:	3 - 6 min	Compression strength:	83 MPa (ASTM D695)
Fixture time:	16 - 24 min	Elongation at break:	<5%
Full strength:	24 hours	Insulation resistance:	30000 megohms (ASTM D257)
Gap fill:	tbd	Volume resistivity:	10 ohm.cm (ASTM D257)
Hardness:	Shore D 45	Dielectric strength:	300 volts/mil (ASTM D149)
Volume change:	<1% (ASTM D2566)	Arc resistance:	50 seconds (ASTM D495)
Application temp:	+15°C to +25°C		
Temp resistance :	- 40°C to +120°C (+150°C intermittent)		



SDS available on www.kenturope.com

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