

Product Description:

DF-R135 resin is a modified epoxy resin. DF-H235 is suitable to cure epoxy resin at ambient temperature. It is also suitable for bonding a variety of materials including metal, ceramic, and concrete.

Advantages:

1. High shear and peel strength
2. Good electrical insulation properties
3. Long working Time
4. Water resistance
5. Long open time
6. Easy to apply

Application:

1. Metal
2. Ceramics
3. Concrete
4. Marble joining
5. Electronic speakers

Material Properties:

Premium DF-R135 Resin

Property	Unit	Value
Description	---	Translucent Viscous Liquid
Color	GS	Max 1
Viscosity@25oC	mPas	25000-35000
Specific Gravity	---	1.01-1.1

Premium DF-H235

Property	Unit	Value
Description	---	Brown Viscous Liquid
Color	GS	Max 8
Viscosity@25oC	mPas	25000-35000
Specific Gravity	---	0.9-1.0

Processing Properies:

Process	Unit	Properties / Value
Mixing Ratio	w/w	100 : 80
Pot Life@25°C	minutes	35-45
Surface Dry of Thin Film @ 27°C	minutes	60-90
Touch Dry of Thin Film @ 27°C	minutes	150-180
Hard Dry of Thin Film @ 27°C	minutes	250-400
Tensile Shear Strength Al-Al joint, after 24 hours @ 27°C	Kg/Sq. cm	90-120

Application Instruction:

STEP 1: Surface Preparation

The adherents must be thoroughly degreased with a good degreasing solvent (e.g. toluene, acetone tri-chloroethylene) and abraded with coarse emery paper or chemically etched. Inadequately pre-treated substrates may not bond satisfactorily.

STEP 2: Application

Mix the resin and hardener until it forms a uniform mass. Apply thin coat of the mixture on both the surfaces, the mixed mass can be applied by brush or spatula on the surface to be adhered. Join the surfaces and apply pressure using tapes, clamps or bands. Remove the pressure after 6 -8 hours. Full strength is achieved within 24 hours. The mix must be used within its pot-life

For best results: Roughen, dry and degrees surfaces to be bonded.

STEP 3: Curing

Curing normally takes place at room temperature within about 24 hours depending on the ambient temperature but may be accelerated by the application of heat.

Available Packings

1.800 kg Packing (1Kg Resin + 0.800Kg Hardener)

9 Kg Packing (5Kg Resin + 4Kg Hardener)

90 Kg Packing (50kg Resin + 40kg Hardener)

Safety Feature

1. Store the container with the lid tightly closed in an upright position, in a cool, dry place
2. Keep out of reach of children and away from eatables
3. May be harmful if swallowed. In case of ingestion seek immediate medical attention
4. Wear eye protection during application. In case of contact with eyes, rinse immediately with plenty of water and if required seek medical advice

Storage and Handling

The resin and hardener, when stored in their original containers and not exposed to undue heat or humidity as in outdoor open shades, will have a minimum shelf life of 2 years. As far as possible, direct contact of resin and hardener with the skin should be avoided as they might cause irritant on sensitive skins. It is advisable to wash off immediately in case of skin contact. Special barrier creams and cleansing creams are available commercially as additional safe guards. Please refer MSDS for detail safety instruction.

*All recommendations for use of our products, whether given by us in writing, verbally are to be implied, from the results of tests carried out by us, based on the current state of our knowledge. Although the information contained in this sheet is accurate to the best of our knowledge, no liability can be accepted in respect of such information and no warranty or conditions are intended in respect of the products described, as the conditions of application are beyond our control.

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