

TECHNICAL DATA SHEET FOR LOCKFAST LF220

Product Description

Fast set epoxy adhesive is a highly reactive adhesive system intended for use in the mix pack cartridge and exhibits good room temperature cure. The product is suitable for use in bonding metal and metal alloys, casting impregnating and potting system, gap filling, trimming bonding, crack casting or hole repair, tools ornament, knobs, ceramic, glassware, fibreglass repair etc.

Technical Information

Characteristic	Resin	Fast Set Hardener
Appearance	Clear	Slightly coloured/transparent
Colour - Gardner	1 - 2	3.0 max
Moisture, Karl Fisher		0.3 Max
Viscosity 25 °C	8000 – 10000 mPas	10000 – 16000 mPas
Density (g/cm ³) at 25 °C	1.16 – 1.17	1.138
Flash point	> 200 °C	> 200 °C
Declaration	Irritant	None

Typical properties of the cured system

Tensile strength (psi)	10800
Break strength (psi)	9600
Flexural strength (psi)	16200
Compression yield strength (psi)	15700
Heat Distortion Temperature (°C)	113
Temperature resistance (°C)	- 40 to +60 °C *
Working time (min)	< 3 @ 22°C
Curing time (min)	4 - 6
100% curing time	24 hours

*NB. Temperature resistance refers to the limits beyond which the adhesive performance deteriorates.

Mixing ratio

1:1 by weight or volume.

Curing

System will cure down to 5°C although at this temperature a longer curing time than at room temperature (20 - 25°C) should be expected. The influence of heat is to accelerate the curing rate.

Important Note

Whilst all reasonable care is taken in compiling technical data on the company's products, all recommendations or suggestions regarding the use of such products are made without guarantee, since the conditions of use are beyond the control of the Company. It is the customer's responsibility to satisfy himself that each product is fit for the purpose for which he intends to use it, that the actual conditions of use are suitable and that in the light of continued research and development the information relating to each product has not been superseded.