

Basis	Adhesive EP 138 LD
Resin	Adhesive EP 138 LD resin
Hardener	Adhesive EP 138 LD hardener
Colour	light blue

Applications

- Bonding of epoxy boards

Properties

- high heat resistance
- medium curing speed
- low density
- easy sandable

Processing data

Product		Mixture Adhesive EP 138 LD	Resin Adhesive EP 138 LD resin	Hardener Adhesive EP 138 LD hardener
Colour		light blue	blue	white
Mixing ratio	p. b. w.		100	20
Viscosity at 25°C	mPas	35400 ± 1000	54000 ± 1200	1600 ± 150
Density at 20°C	g / cm ³	0,82 ± 0,03	0,75 ± 0,03	1,07 ± 0,03
Pot life 150 g / 20°C	min	40 ± 5	-	-
Curing time at RT	hrs.	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Heat resistance (HDT)	DIN EN ISO 75 B	°C	117 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	70 ± 2

Sales units (packages)

Units	Resin	Adhesive EP 138 LD resin	0,600 kg, 3,500 kg
	Hardener	Adhesive EP 138 LD hardener	0,120 kg, 0,700 kg

Processing instructions

Mix EP 138 DL resin with EP 138 DL hardener. The material should be processed within 20 minutes. Apply 200-250 g of Adhesive EP 138 DL with a notched spatula (teeth A2) on both panel sides which have to be glued together. For gluing two boards EP 138 together thus you need 400-500 g of Adhesive EP 138 DL. For gluing one m² you need 400-500 g as well.

After gluing the blocks have to be kept at room temperature for at least 6-7 hours, then they can be milled. If the blocks are exposed to higher temperatures gently heat up the glued blocks at about 5°C/ hour and keep them at a minimum of 80°C for 10 hours. For higher processing temperatures accordingly give a higher heat treatment. Leave it in the oven for one more hour at the highest temperature for every 100 mm thickness of the block."

After cooling down at a rate of 5°C/ hour the block should remain at the autoclave with closed doors overnight, till he reaches room temperature also in the core.

Take the same procedure for curing prepregs on the mould. When taking the block out of the autoclave don't lay it on a cold surface. An isolating layer may be placed in between. Depending on the geometry of the tool different parameters may be necessary.

In General

For mixing and application of the material, clean and dry tools are essential. Mix according to mixing ratio, please also see front label of the cans.

Mix carefully and apply immediately. Material temperature when mixing not below 15°C.

Storing

Storage at room temperature 18-25 °C.

Already opened containers should be closed immediately after use and should be used as soon as possible.

Information about the expiration date you find on the sales packages.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.