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| Basis | Adhesive EP 138 LV |
| Resin | Adhesive EP 138 LV resin |
| Hardener | Adhesive EP 138 LV hardener |
| Colour | opaque |

Applications

- Bonding of epoxy boards

Properties

- fast curing
- very high heat resistance

Processing data

| Product | | Mixture Adhesive EP 138 LV | Resin Adhesive EP 138 LV resin | Hardener Adhesive EP 138 LV hardener |
|-----------------------|---------------------|-------------------------------|-----------------------------------|---|
| Colour | | opaque | opaque | yellowish transparent |
| Mixing ratio | p. b. w. | | 100 | 20 |
| Viscosity at 25°C | mPas | 5300 | 1300 | 66 |
| Density at 20°C | g / cm ³ | 1,11 ± 0,02 | 1,13 ± 0,02 | 0,99 ± 0,02 |
| Pot life 200 g / 20°C | min. | 50 ± 5 | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|-----------------------|--------------------|---------|---------|
| Heat resistance (HDT) | DIN EN ISO 75 B | °C | 157 ± 2 |
| Shore hardness | DIN ISO 7619-1 | Shore D | 85 |

Sales units (packages)

Processing instructions

Mix Adhesive EP 138 LV resin with Adhesive EP 138 LV hardener. The material should be processed within 25 - 30 minutes. Apply 250-300g of Adhesive EP 138 LV with a notched spatula (teeth A2) on both panel sides which have to be glued together. For gluing two **ebaboard** EP 138 together thus you need 500-600 g of Adhesive EP 138 LV. For gluing one m² you need 500-600g as well.

After a heat treatment of 10 h at 140°C an HDT of 157 °C is obtained. Lower post curing temperatures give a lower HDT.

After gluing the blocks have to be kept at room temperature for at least 5-6 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.