

H 8973 Resin

H 8973 Hardener

ADHESIVE FOR HIGH TEMPERATURE EPOXY
TOOLING BOARDS

BUILDING TRUST



APPLICATIONS

Dedicated adhesive system to bond LAB 973 or LAB 975 NEW boards to each other.

PHYSICAL & THERMAL PROPERTIES					
Composition		RESIN H8973	HARDENER H8973	MIXING	
Mixing ratio by weight		100	14		
Aspect		pasty	liquid	pasty	
Colour		blue	transparent	blue	
Specific gravity @ 25°C	ISO 1675 : 1975 ISO 2781 :1988	0.78	0.95	-	
Specific gravity of the cured product @ 23°C				0.78	
Pot life @ 25°C on 115g (min.)	-			50	
Open time (min.)				60	
Consumption (g/m ²)				530	
Coefficient of linear expansion (C _{LTE}) [0, +90]°C (1)	T.M.A - Mettler	10 ⁻⁶ K ⁻¹		50	
Temperature (°C)		23	80	100	120
Hardness (1) Shore D (1 s)	ISO 868 : 85	74	69	67	66

(1) : Average values obtained on standard specimens / Hardening 24 hr @ 23°C + 4 hr @ 80°C + 4 hr @ 120°C.

STORAGE - PRESERVATION

Shelf life for the resin is 12 months and 24 months for the hardener in a dry place and in original unopened containers at a temperature between 15 to 25°C.

PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- ensure good ventilation
- wear gloves and safety glasses

For further information, please consult the product safety data sheet

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PROCESSING

1-Preparation of the Lab973 or Lab975New surface to bond:

- Sand the boards with 80 grit sandpaper to improve mechanical grip
- dust off with compressed air
- degrease (eg: Iso propyl alcohol-IPA)

2- The consumption of mixture necessary for gluing boards must be based on 530g / m² consumption. The use of a kit (0.491g) will cover almost 1m². In this case the mixture can be done by adding the hardener inside the resin can and thoroughly stir until homogenous aspect. Above 1 m² the quantity must be adjusted respecting the indicated ratio and the mixture made in a proportionate container. Make the mixture using a metal spatula.

3- Remove and spread the mixture on the 2 treated surfaces striping with a notched spatula (3mm) to allow a homogeneous distribution of the mixture between the assembled boards. Manually adjust the positioning of the boards together by sliding them on top of each other. Remove excess mixture squeezing out from the bonding lines between the boards.

4- Apply and maintain a pressure using a clamping tool during a period of 16H00 at room temperature. At the end of this time the assembled boards can be machined on a CNC.

PACKAGING

Resin 2 x 6 x 0,43	Hardener 12 x 0,061 kg
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GUARANTEE

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