

MANUAL SECTION	ISSUE DATE	AUTHORISED	REPLACES	PAGE
----------------	------------	------------	----------	------

Construction Products Aug 2011 PM July 2009 1 of 2

K138

(also known as K2004)

Based on Nuplex
Epoxy Technology

PERFORMANCE EPOXY ADHESIVE

DESCRIPTION:

K2004 epoxy is a structural adhesive exhibiting high temperature **in-service** performance and good metal bonding properties.

FEATURES

- High temperature resistance
- Bonds metals
- Cures at 5°C
- Chemical resistant

BENEFITS

- Extreme condition performance
- Specific
- Condition tolerant
- Condition tolerant

NORMAL END USES:

- Bonding metals
- Hi temperature moulds
- Industrial assembly operations

TYPICAL PROPERTIES:

	<u>RESIN</u>	<u>HARDENER</u>
Appearance:	Beige colour paste	Grey coloured paste
Specific Gravity:	1.70	1.70
Flash Point:	>110°C	>104°C
Shelf Life:	>24 months	>24 months

MIX RATIO:

	<u>by weight</u>	<u>by volume</u>
Resin	100	100
Hardener	40	40

POT LIFE:

(Usable Life)

<u>@ 12°C</u>	<u>@ 15°C</u>	<u>@ 20°C</u>
60-70 minutes	40-60 minutes	30-40 minutes

ARALDITE K138 (cont'd)

<u>CURE TIME:</u>	48 hours at 5°C 24 hours at 23°C 1 hour at 60°C
<u>COVERAGE:</u>	Use as volume required (0.001m ³ = 1Lt). Use at 3m ² /Lt for normal bonding
<u>SURFACE PREPARATION:</u>	(a) Metals: Grind to clean bright surface. Degrease with Solvent HA. (b) Timber and Composites: Abrade to roughen and clean. Degrease composites.

MIXING INSTRUCTIONS:

Carefully mix the product according to the stated mix ratio. The mix ratio is the only acceptable formula. Increased hardener levels result in a **weaker** product. Mix until uniform and no streakiness is evident. Mixing by **weight** is recommended due to the differential mix ratio.

APPLICATION:

Apply mixed adhesive with spatula. Clamp while curing at the above schedules. Only fully cured adhesives will exhibit the advised heat resistance (120°C). Inadequate mixing, incorrect mix ratios or movement before cure are the normal reasons for joint failure.

HEALTH AND SAFETY:

Use gloves wherever possible. Wash hands with warm, soapy water after any skin contact. Re-seal all container tightly. Clean up with Solvent HA.

CURED PROPERTIES:

Maximum Operating Temperature:	120°C
Density kg/L:	1.70
Lap Shear Strength N/mm²:	17

OTHER EPOXY PRODUCTS:

K80	Pourable Grout	K214	General Purpose Adhesive
K102	H.V. Mortar	K36	Clear Laminating Resin
K125	Paste	K78	Crack Repair
K230	Fast Set Paste	K85	Rapid Set Pourable
K273	Low Temp Paste		Fairing Cream Sandable Smoothing Paste
K268	Rapid Set Paste		
K219	Structural 24 hour Adhesive		
K106	Structural 5 minutes Adhesive		
K238	High Strength, Structural Heat Resistant Adhesive		
K2005	High Peel Strength, Structural Adhesive		
Repikit 310	Concrete Crack Repair Tube and Kit		