



ASSYST sprl / A.S.O.W. sprl
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EPOXY GLUE DM10

Fast and strong

DESCRIPTION:

Epoxy glue DM10 is a two component unfilled epoxy system, solvent free, fast and stiff.
 Excellent resistance to alkalis, good to dilute acids, poor to solvents.
 Structural bonding for assembly of heterogeneous materials.
 Fast repair, even at low temperature (near 0°C).

PROCESS:

Manual application or with mixer/doser. Apply within a short time. Curing at room temperature. Final properties and maximum resistances are achieved at full cure, after 24 hours. Good adhesion is achieved within 2 hours; the last part can be cured after 30 minutes. If the curing is carried out at high temperature, the best performance is obtained with a bonding at 40°C during several hours.

TYPICAL APPLICATIONS:

Wood, hardwood, metal, ceramic, glass, stone, pottery, concrete, marble.

Not suitable for polyethylene, polypropylene, hard PVC and PTFE.

For other plastics, the performance of the adhesive must be tested before use: it may be necessary to pre-treat the substrates with mechanical or plasma treatment.

TYPICAL SYSTEM CHARACTERISTICS:

Resin:

- ✓ Colour: Pale yellow
- ✓ Viscosity (25°C): 6,500-10,000 mPas (EN13702-2)
- ✓ Density (25°C): 1.13-1.17 g/ml (ASTM D 1475)

Harder:

- ✓ Colour: Pale yellow
- ✓ Viscosity (25°C): 20,000-30,000 mPas (EN13702-2)
- ✓ Density (25°C): 1.11-1.15 g/ml (ASTM D 1475)

DATA PROCESSING:

Mixing ratio by weight: 1: 1
 Mixing ratio by volume: 1: 1
 Processing time (25°C, 2 mm): 2 - 3 min
 Yellowness (25°C, 2 mm): 3 - 4 min
 Curing time (25°C): 6 - 7 min

TYPICAL HARDENED SYSTEM CHARACTERISTICS

Properties determined on cured samples: 16h at 40°C

Density (25°C) (ASTM D 792)	g/ml	1,12 - 1,16
Hardness (25°C)	1h	Shore D/15 65-70
	24 hours	Shore D/15 75-80
	7 days	Shore D/15 78-83
Glass transition (Tg) (ASTM D 3418)	7 days	KT (*) 27-32°C
	16 hours	40°C 27-32°C
	3 hours	80°C ° 33-38°C

Shear strength through tension: (ASTM D 1002)

Stainless steel AISI 316, 7 days KT (*)	MPa	9.0-11.0
Stainless steel AISI 316, 16h 40°C	MPa	11.5-13.5



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Stainless steel AISI 316, 3h 80°C	MPa	15.0-18.5
Aluminium, 7gg KT(*)	MPa	8.5-10.5
Aluminium, 16 hours 40°C	MPa	10.5-12.5
Aluminium, 3 hours 80°C	MPa	16.0-18.0

INSTRUCTIONS:

The surfaces must be clean and dry. In general mechanical sanding or sanding followed by degreasing with solvent (e.g. Acetone) is sufficient. No specific preparation is required for pre-preg assembly. Add the correct amount of hardener to the resin, mix carefully. Use a slow mixer or mix by hand with a spatula. Once applied, the system is moisture and carbon dioxide sensitive: cover the junction quickly or harden in the oven. Final cleaning of the equipment can be carried out with normal solvents such as acetone, nitro, etc.

STORAGE:

Epoxy resins and their hardeners have a shelf life of two years in the original sealed containers in a cool, dry place.

PRECAUTIONS:

Consult the safety data sheet and follow the instructions concerning industrial health and waste disposal.