



ASSYST sprl / A.S.O.W. sprl
 Hellegatstraat 13a - 2590 Berlaar - Belgium
 Tel: +32 495 50 61 14 / +32 496 83 70 27
 Website: www.assyst.org / www.artsuppliesonweb.com
 Email: ao@assyst.org / vera.opsommer@assyst.org

EPOXY GLUE DM120 **Slow and strong**

DESCRIPTION:

Epoxy adhesive DM120 is a two-component epoxy system, solvent free, fast and solid. Slightly thixotropic. The product cures also at high humidity and the final bond is resilient.

PROCESS:

Brush application or spatula with mixing / dispensing equipment. Room temperature or hot cure.

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: Milky white
- ✓ Viscosity (25°C): 10,000-20,000 mPas (EN13702-2)
- ✓ Density (25°C): 1.14-1.18 g/ml (ASTM D 1475)

Harder:

- ✓ Colour: Amber
- ✓ Viscosity (25°C): 10,000-20,000 mPas (EN13702-2)
- ✓ Density (25°C): 0.96-1.00 g/ml (ASTM D 1475)

DATA PROCESSING:

Mixing ratio by weight:	1: 0.8
Mixing ratio by volume:	1: 1
Processing time (25°C, 2 mm)	30 - 40 min
Initial viscosity mixture at 25°C:	10,000 - 20,000 mPas
Gelling time (25°C, 2 mm):	4 - 5 u
Curing time (25°C):	5 - 7 u

TYPICAL HARDENED SYSTEM CHARACTERISTICS

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

Density (25°C) (ASTM D 792)	g/ml	1.08-1.12	
Hardness (25°C)	24 hours	Shore D/15	78-82
	7 days	Shore D/15	81-85
Glass transition (Tg) (ASTM D 3418)	7 days	KT(*)	50-55°C
	16 hours	40°C	45-50°C
	3 hours	80°C °	53-58°C
Shear strength through tension: (ASTM D 1002)			
Stainless steel AISI 316, 7 days KT (*)	MPa		15.0-17.0
Stainless steel AISI 316, 16h 40°C	MPa		14.5-16.0
Stainless steel AISI 316, 3h 80°C	MPa		19.0-21.0
Aluminum, 7gg KT(*)	MPa		17.0-19.0
Aluminum, 16 hours 40°C	MPa		17.5-19.5
Aluminum, 3 hours 80°C	MPa		22.0-24.0



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INSTRUCTIONS:

The surfaces must be clean and dry. In general mechanical sanding or sanding followed by degreasing with solvent (e.g. Acetone) is sufficient. Add the correct amount of hardener to the resin, mix carefully. 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.