

## Set-Bond 1895

### Base:

- Two part epoxy resin

### Curing:

- At room temperature
- Higher temperatures accelerate curing

### Use:

- High strength structural adhesive
- Universal use
- Checked on biocompatibility and fulfills the requirements of USP XXII, Class VI
- Complies with KTW recommendations (plastics in field of drinking water) for hot and cold water (up to 90C)

### Application:

- Components A and B have to be well mixed resp. homogenized in the mixing ratio indicated below
- Supplied ready to use and best applied from original containers
- Especially advantageous processing with the AUTOMIX System
- Surfaces to be bonded must be dry, free of dust and grease as well as other contaminants

### Technical data

Filler		Minerals
Mixing Ratio		
(A:B) by weight		5 : 6
(A:B) by volume		1 : 1
Color		Grey
Density [g/cm <sup>3</sup> ] at room temperature		1.33
Viscosity at 23°C Brookfield		
Component A (mPas)		100,000 thix
Component B (mPas)		130,000 thix
Mixture (mPas)		100,000 thix
Pot life		Water absorption (%) 0.1
In 100 g preparation at 23C (min)	60	DIN 53495, 24h at RT
Gelling Time		Coefficient of elongation (1/K) 60xE-6
In 100 g preparation at 23C (min)	90	acc to DIN 16946
Curing Time		Shore Hardness D 80

Read Warranty on Back of Technical Data Sheet.

At room temp (Hours)	24	DIN 53505
At 80C (min)	60	
Maximum reaction temp		Indentation hardness (Mpa) 80
In 100 g preparation (c)	80	DIN 53456
Firmness to touch (h)	4.5	Temperature solidity (Mpa) 5.0
Tensile/shear strength 1-2 Mpa		DIN 53286, sand-blasted
		Joint part material: al/al
Functional stability (h)	8	thickness: 1.6 mm
Tensile/shear strength >10 Mpa		
Tensile/Shear strength DIN 53283, EN 1465		Temperature Stability (C) 200
Joint part material: al/al (Mpa)	21	Specific volume 5.2xE15
Sand-blasted		VDE 0303, part 3
Joint part thickness: 1.6 mm		
After 24 h at room temperature		
DIN 54451		Surface resistance R 2.3xE12 VDE 0303, part 3
Joint part material: Al/Al (Mpa)	26	
Sand-blasted		Breakdown voltage E (kV/mm) 21
Joint part thickness: 6mm		VDE 0303, part 2
After 72 h at room temperature		
		Dielectric constant 4.1
Floating roller peel	3.5	VDE 0303, part 4
Resistance (N/mm) Din 53289 acc to EN 1464		Creep resistance CTI >600M
Joint part material: st/st sand-blasted		VDE 0303, part 1, IEC 112
Thickness:	1.5 mm	
Chemical stability		very good
Tensile strength (Mpa)	38	DIN 53455
Storage life		12 months After delivery at room temperature in unopened original container
Elongation at tear (%)	1.4	DIN 53455
Modulus of elasticity (Mpa) 3200		DIN 53457

**Recommendations for maintenance of industrial health and safety standards:**

For safe handling information on this product, consult the Material Safety Data Sheet.

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**Silicone & Epoxy Technology**

Phone: 631-920-5079 Fax: 631-920-0503

**Place Orders To: SalesSET@optonline.net**

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