



Macroplast EP 3250 / EP 5250

9 June 2010

PRODUCT DESCRIPTION

Macroplast EP 3250 / EP 5250 provides the following product characteristics:

Technology	Epoxy
Product Type	Epoxy adhesive
Cure	Polymerisation
Components	Two-component
Application	General assembly
Appearance (Component A)	White
Appearance (Component B)	Off-white
Appearance (Mixture)	White
Mixing Ratio, by weight Part A: Part B	3 : 1
Mixing Ratio, by volume Part A: Part B	3 : 1

Application Areas

Macroplast EP 3250 / EP 5250 is a two-component paste adhesive with controlled rheology. A good bond is achieved with a wide variety of surfaces including wood, metal, glass, ceramic, GRP and some plastics. Performance at high temperature and excellent chemical resistance are important features of this product.

TECHNICAL DATA

Component A

MACROPLAST EP 3250:

Viscosity, mPas	30,000
Specific Gravity, g/cm ³	1.66

Component B

MACROPLAST EP 5250:

Viscosity, mPas	90,000
Specific Gravity, g/cm ³	1.72

Mixture (Component A + B):

Viscosity at 25 °C, mPas	45,000
Specific Gravity, g/cm ³	1.68
Cure Time at 25 °C, hrs.	
Potlife (100 ml):	9 (min.)
Potlife (thin Film):	16 (min.)
Initial setting time:	12 (min.)
Full strength:	24
Cure Time at 40 °C, hrs.	
Full strength:	12
Cure Time at 60 °C, hrs.	
Initial setting time:	4 (min.)
Full strength:	4

The cure speed of 2 part epoxy resins is generally affected by the ambient temperature. A fall of 8°C will roughly double the cure time; a rise of 8°C will tend to halve it.

*On Composites this adhesive is capable of strengths similar to that achieved on steel but in most cases delamination on the composite will occur before this load is reached. On Aluminium & Copper alloys the modulus and thickness of the metal will define the ultimate bond strength achieved.

DIRECTIONS FOR USE

Preliminary Statement:

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed.

Pretreatment:

The substrate should be clean, dry, free of dust, oil, grease and other contaminants. An improvement of the adhesion can be achieved by grinding or sandblasting the surface.

Application:

The adhesive is only to be used within a limited time (pot life). Therefore only the amount that can be applied within the time of pot life should be mixed. Thoroughly mix resin (A) and hardener (B) in the correct proportion.

Generally the recommended service temperature range for this product is -55 to +80°C. However experience has shown that higher temperatures, of around 200°C, may be endured for short periods providing the adhesive is not unduly stressed.

Cleaning:

Uncured mixed adhesive or the hardener alone, on tools or brushes can be cleaned off with hot water. The resin component alone requires a solvent (e.g. Acetone).

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations

Storage:

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 12 months.

ADDITIONAL INFORMATION

Disclaimer:

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

This datasheet replaces all former versions.

Reference 0.0

