

**Zepoxy 2011** is an all-purpose epoxy adhesive useful for bonding of materials such as metal, wood, ceramic, FRP, concrete, textile, glass, leather, etc. It has higher bonding power as well as higher mechanical strength making this system a higher performance version of **Zepoxy 2011**.

## TECHNICAL DATA

Property	Test Method	Result
Appearance Part A	Visual	High viscosity, translucent liquid
Appearance Part B	Visual	High viscosity, yellow to brown liquid
Mix ratio (Part A: Part B)	Theoretical	100: 80
*Mix viscosity @ 25°C	ASTM D 2196	30,000 – 55,000 cPs
*Flash Point	ASTM D 93	>135°C
*Pot life (300g mix) @ 30°C	-	30m @ 28°C
*Gel time (18g mix) @ 30°C	-	2h @ 28°C
*Hardening time	-	24 hours
*Full Cure	-	7 days
*Flexural Strength	ASTM D 790	66.9 MPa
*Compressive Strength – Yield	ASTM D 695	65.4 MPa
*Compressive Strength – Ultimate	ASTM D 695	116.2 MPa

\*Typical results under laboratory conditions.

## NOTE

At 40°C gel time will be reduced to half, in case of increased temperatures, pouring should be planned accordingly.

## GENERAL INFORMATION

**Substrate preparation:** The substrate of the substrate must be clean and dry. Remove all dirt, grease and foreign material by cleaning with suitable solvent, sand blasting, mechanical abrasion, or acid etching.

**Mixing:** To obtain good results, thorough mixing of the ingredients is essential. Usually the resin and hardener are mixed in small quantities to extend the working time and prevent high exothermic reaction and pre-gelling.

**Application:** To ensure good adhesion between the substrates, it is recommended to apply rich layer of homogenous blend uniformly on the surface and fill the dents and pinholes. Adequate curing normally takes place within 24 hours, post curing at temperatures more than 40°C is recommended.

**Cleaning and maintenance of equipment:** Tools and equipment used during the process are best cleaned immediately after use since removal of cured resin is difficult and time consuming. It is recommended that the bulk of the resin be removed using a scrapper and the remainder washed away using solvents such as toluene, xylene or acetone.

## PACKAGING

Zepoxy 2011 is available as follows:

Mini set	180g	Part A: 100g Part B: 80g
Half Set	900g	Part A: 500g Part B: 400g
Full Set	1.8 KG	Part A: 1 KG Part B: 800g
Commercial Pack	54 KG	Part A: 30 KG Part B: 24 KG

## HEALTH AND SAFETY

Dispose containers of the materials as per local laws, rules, and regulations. Use gloves, safety masks and other safety apparel as per health and safety laws. For further assistance, please refer to the MSDS of the product for further health and safety information.