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Based on Araldite™  
Epoxy Technology

**K106**  
**(previously known as K2001 - also as 2011)**  
**HIGH STRENGTH EPOXY IN CARTRIDGE FORM**

**DESCRIPTION:**

K106 is a high strength 24 hour cure epoxy. Higher performance than standard epoxies (eg: K214). (Available in twin cartridge as 2011.)

**FEATURES**

- Simple 1/1 mix ratio
- Easy mix and application
- Gap filling
- Bonds many materials

**BENEFITS**

- User friendly
- User friendly
- Many applications
- Many applications

**NORMAL END USES:**

- Bonds metals, timbers, composites, some plastics
- Boat building
- Construction/industrial uses
- Golf club heads
- Electronic assemblies

**TYPICAL PROPERTIES:**

	<b><u>RESIN</u></b>	<b><u>HARDENER</u></b>
<b>Appearance:</b>	Viscous opaque liquid	Viscous pale yellow liquid
<b>Specific Gravity:</b>	1.15	0.9
<b>Flash Point:</b>	>100°C	>100°C
<b>Shelf Life:</b>	>24 months	>24 months

**MIX RATIO:**

	<b><u>by weight</u></b>	<b><u>by volume</u></b>
Resin	100	100
Hardener	80	100

**POT LIFE:**

**(Usable Life)**

<b><u>15°C</u></b>	<b><u>(a), 20°C</u></b>
150 minutes	120 minutes

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**ARALDITE K106** (cont'd)

<b><u>CURE TIME:</u></b>	15 hours at 20°C 3 hours accelerated at 40°C
<b><u>COVERAGE:</u></b>	Use as volume required ( $0.001\text{m}^3 = 1\text{Lt}$ ). For bonding substrates an adhesive spread of $3\text{m}^2/\text{Lt}$ is normal depending on gap filling required.
<b><u>SURFACE PREPARATION:</u></b>	(a) Metals: Grind to clean bright surface. Degrease with Eposolve 70. (b) Timber and Composites: Abrade to roughen and clean. Degrease composites.

**MIXING INSTRUCTIONS:**

Carefully mix the product according to the stated mix ratio. The 1 : 1 mix ratio is the only acceptable formula. Increased hardener levels result in a **weaker** product. Mix until uniform and no streakiness is evident.

**APPLICATION:**

Apply mixed adhesive with spatula or notched trowel. Clamp surfaces together for curing period, or hold without movement for cure time. Inadequate mixing, incorrect mix ratios or movement before cure are the normal reasons for joint failures. Water resistant when cured.

**HEALTH AND SAFETY:**

Use gloves wherever possible. Wash hands with warm, soapy water after any skin contact. Re-seal all container tightly. Clean up with Eposolve 70.

**CURED PROPERTIES:**

<b>Maximum Operating Temperature:</b>	60°C
<b>Density kg/L:</b>	1.05
<b>Lap Shear Strength N/mm<sup>2</sup>:</b>	16
<b>Water Vapour Permeability (1mm thick):</b>	16g/m <sup>2</sup> /24hour

**OTHER EPOXY PRODUCTS:**

K80	Pourable Grout	K214	General Purpose Adhesive
K102	H.V. Mortar	K36	Clear Laminating Resin
K125	Paste	K78	Crack Repair
K230	Fast Set Paste	K85	Rapid Set Pourable
K273	Low Temp Paste		Fairing Cream Sandable Smoothing Paste
K268	Rapid Set Paste		
K106	Structural 24 hour Adhesive		
K219	Structural 5 minutes Adhesive		
K138	High Strength, Structural Heat Resistant Adhesive		
K2005	High Peel Strength, Structural Adhesive		
Repikit 310	Concrete Crack Repair Tube and Kit		