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Based on Araldite™  
Epoxy Technology

## **K2005**

### **SYNTHETIC MATERIAL ADHESIVE**

**DESCRIPTION:**

K2005 is a structural epoxy adhesive designed for high shear/peel strength application.

**FEATURES**

- Bonds many plastics
- Simple 2:1 mix ratio
- Water and chemical resistant

**BENEFITS**

- Versatile
- Easy use
- Versatile

**NORMAL END USES**

- Industrial adhesive applications
- Bonds plastics, timber, metals
- Suitable for active joints

**TYPICAL PROPERTIES:**

	<b><u>RESIN</u></b>	<b><u>HARDENER</u></b>
<b>Appearance:</b>	Opalescent paste	Straw coloured paste
<b>Specific Gravity:</b>	1.10	1.05
<b>Flash Point:</b>	>100°C	>100°C
<b>Shelf Life:</b>	>24 months	>24 months

<b><u>MIX RATIO:</u></b>	<b><u>by weight</u></b>	<b><u>by volume</u></b>
Resin	100	100
Hardener	44	50

<b><u>POT LIFE:</u></b> <b>(Usable Life)</b>	<b><u>@ 15°C</u></b>	<b><u>@ 20°C</u></b>
	120 minutes	90 minutes

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**NUPLEX CONSTRUCTION PRODUCTS**

PO Box 12841, Penrose, Auckland Telephone 0-9-579 2029 Fax 0-9-579 3709 www.nuplexconstruction.co.nz email: bpdsales@nuplex.co.nz

<b>HAMILTON</b>	<b>PALMERSTON NORTH</b>	<b>WELLINGTON</b>	<b>CHRISTCHURCH</b>
Telephone 0-7-847 8658	Telephone 0-6-353 3685	Telephone 0-4-477 7040	Telephone 0-3-366 6802
Fax 0-7-847 3766	Fax 0-6-353 3632	Fax 0-4-477 7039	Fax 0-3-379 0279

**ARALDITE K2005** (cont'd)**CURE TIME:**

48 hours at 5°C  
 24 hours at 23°C  
 1 hour at 60°C

**COVERAGE:**

Use as volume required ( $0.001\text{m}^3 = 1\text{Lt}$ ).  
 Use at  $3\text{m}^2/\text{Lt}$  for general bonding

**SURFACE PREPARATION**

(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 mix ratio is the only acceptable formula. Increased hardener levels result in a **weaker** product. Mix until uniform and no streakiness is evident. Mixing by **weight** is recommended in critical industrial applications.

**APPLICATION:**

Apply mixed adhesive with spatula. Clamp while curing at the above schedules. K2005 is recommended when shear and/or peel strength flexing is encountered. Inadequate mixing, incorrect mix ratios or movement before cure are the normal reasons for joint failure.

**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>	<b>80°C</b>
<b>Density kg/L:</b>	<b>1.05</b>
<b>Lap Shear Strength N/mm<sup>2</sup>:</b>	<b>29</b>
<b>Peel Strength KN/m:</b>	<b>2.8</b>

**OTHER ARALDITE BASED 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		
K2001	Structural 24 hour Adhesive		
K2002	Structural 5 minutes Adhesive		
K2004	High Strength, Structural Heat Resistant Adhesive		
K2005	High Peel Strength, Structural Adhesive		
Repikit 310	Concrete Crack Repair Tube and Kit		