



MANUAL SECTION	ISSUE DATE	AUTHORISED	REPLACES	PAGE
<i>Construction Products</i>	<i>July 2005</i>	<i>PM</i>	<i>Oct 2001</i>	<i>I of 2</i>

Based on Araldite™ Epoxy Technology
--

**K219**  
**(previously known as K2002 - also as 2012 in cartridge form)**  
**5 MINUTE GEL - 2 HOUR CURE**

**DESCRIPTION:**

K219 is a rapid curing industrial grade adhesive. Available in twin cartridge as 2012.

**FEATURES**

- Simple 1/1 mix ratio
- Easy mix and application
- Very rapid cure
- Gap filling
- Low temperature cure

**BENEFITS**

- User friendly
- User friendly
- Short process times
- Versatile
- Versatile

**NORMAL END USES:**

- Industrial rapid process applications
- Bonds many materials

**TYPICAL PROPERTIES:**

	<b><u>RESIN</u></b>	<b><u>HARDENER</u></b>
<b>Appearance:</b>	Cream paste	Opalescent paste, strong smell
<b>Specific Gravity:</b>	1.10	1.10
<b>Flash Point:</b>	>100°C	>100°C
<b>Shelf Life:</b>	>24 months	>24 months

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

<b><u>POT LIFE:</u></b>	<b><u>@ 0°C</u></b>	<b><u>@ 15°C</u></b>	<b><u>@ 20°C</u></b>
<b>(Usable Life)</b>	Long	8 minutes	5 minutes

No warranty either expressed or implied or statutory is made by NUPLEX in this document except as expressly stated in any sale and purchase agreement entered into between NUPLEX and the buyer. This document is a technical data information sheet. The description of the product or products and the properties of the product or products contained in this document is for the sole purpose of identifying the product or products and describing their property or properties and does not constitute a warranty that the product or its properties shall conform to that description; nor is the description of the product and/or its properties a warranty by NUPLEX that the goods are suitable for a particular purpose.

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>H A M I L T O N</b>	<b>P A L M E R S T O N N O R T H</b>	<b>W E L L I N G T O N</b>	<b>C H R I S T C H U R C H</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 K219** (cont'd)

<b><u>CURE TIME:</u></b>	8 hours at 0°C 4 hours at 10°C 2 hours at 23°C
<b><u>COVERAGE:</u></b>	Use as volume required (0.001m <sup>3</sup> = ILt). Bonding normally requires 3m <sup>2</sup> /Lt
<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:**

Work rapidly due to short pot life. Apply mixed adhesive with spatula or notched trowel. Clamp while curing. Inadequate mixing, incorrect mix ratios or movement before use 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>	40°C
<b>Density kg/L:</b>	1.10
<b>Compressive Strength MPa:</b>	30 - 60
<b>Lap Shear Strength N/mm<sup>2</sup>:</b>	15
<b>Water Absorption (%/24hrs):</b>	1.1 - 1.5%

**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		
K106	Structural 24 hour Adhesive		
K219	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		