

Technical Data Sheet

K2005 Synthetic Material Adhesive System



DESCRIPTION:

K2005 is a versatile rapid curing structural adhesive designed for high shear/peel strength applications and exhibiting good handling properties for many applications.

TYPICAL FEATURES | BENEFITS:

- Simple 2:1 Mix.
- Interior | exterior application.
- User friendly.
- Low temperature cure.
- Water and chemical resistant
- Cure above +5°C.
- Bonds to many surfaces.
- Gap filling.
- Suitable for active joints.

PERFORMANCE DATA:

Minimum Application Temperature: Air	+5°C
Flash Point:	>100°C
Lap shear strength: N/mm2:	29
Peel Strength KN/m:	2.8
Maximum operating temperature:	+80°C
Adhesion Properties to correctly prepared surface:	
~ Composites	Excellent
~ Concrete	Excellent
~ Metal	Excellent
~ Rubber	Very Good
~ Timbers	Excellent
Appearance:	
~ Resin	Opalescent paste
~ Hardener	Straw coloured paste

RECOMMENDED USES:

- Bonds Concrete | Metals | Timbers | Composites | Some plastics.
- Suitable for active joints
- Construction | Industrial uses.

NOT RECOMMENDED:

- Application below +5°C air temperature.
- Bonding Polypropylene and polyethylene.
- Application to incorrectly prepared surfaces.

HEALTH & SAFETY: Refer safety data sheets (SDS).

- Wear gloves wherever possible.
- Wash hands with warm, soapy water after any skin contact.
- Re-seal all containers tightly.

SURFACE PREPARATION:

The surface to be filled/repared must be clean and sound.

Remove all dust, dirt, oil, scale, laitance, paint or any other contaminates.

Concrete: Acid etch | Shot blast | Diamond grind | Needle gun.

Metals: Degrease with Acetone > Abrade with medium grit abrasive paper > Degrease with Acetone again.

Timber: Prepare by way of mechanical sanding using 80 grit paper.

Composites: Degrease > Mechanically abrade > Degrease.

PRODUCT PROPERTIES:

Pot Life (Usable Life) Pot life is based on 100gram samples. Large quantities of mixed epoxy will generate heat and the pot life may be significantly reduced.	15°C– 50%RH 20°C– 50%RH	120 minutes 90 minutes
Cure Time	5°C –50%RH 23°C– 50%RH 60°C– 50%RH	48 hours 24 hours 1 hours
SG kg/litre ~ Resin ~ Hardener	1.10 1.05	
Density Kg/Litre -cured	1.10	
Coverage ~ General Bonding	Use as required: (0.001m ³ = 1 Litre) e.g. 1 litre covers 1m ² @ 1mm thick. 3m ² /Litre is normal depending on gap filling required.	
Clean up	Wash hands with warm soapy water after any skin contact Solvent HA for tools	
NZ Dangerous Goods Class ~ K2005 Kit	Hazard Class 8 Packing Group II	
Packaging ~ K2005 Kit	1.5 litre Kit	
Shelf Life	24 months from date of manufacture. (After this period consult with allnex).	

K2005 MIXING RATIO: By weight

Resin	100 parts
Hardener	44 part

K2005 MIXING RATIO: By volume

Resin	100 parts
Hardener	50 parts

**** Note**** Refer Cautions Section.

The mix ratio must not be altered.

The mix ratio is the only acceptable formula.

Adding more hardener will make the mix softer and it will be uncured.

Increased hardener levels will result in a weaker product.

MIXING METHOD:

Carefully mix the product according to the stated mix ratio. Mix until uniform and no streakiness is evident.

APPLICATION METHOD:

Notched Trowel | Spatula

General bonding:

Apply the mixed adhesive to the substrate with a notched trowel or spatula at the recommended spread rate.

Clamp surfaces together for curing period, or hold without movement for required cure period.

CAUTION:

K219 is a two part epoxy that is mixed in the specified ratio. Only this ratio will produce a hard, non-softening product. Adding more hardener (with the aim of making the product cure faster) will not work and will only result in making the product softer. The more hardener that is added, then the softer it will become. No matter how long it is left, it will never harden.

Only the stated mix ratio will work and exhibit the stated performance data.

****Note****

Inadequate mixing, incorrect mix ratios or movement before cure are the normal reasons for joint failure.

OTHER EPOXIES AVAILABLE:

- K36 - Clear Laminating Resin.
- K78 - Crack Repair.
- K80 - Pourable Grout.
- K83 – Machinable Epoxy Grout
- K102 - High Viscosity Mortar.
- K106 - Structural 24 hour Adhesive.
- K125 - Concrete Repair Paste.
- K130 - Control Joint Filler.
- K138 - High Strength, Structural Heat Resistant Adhesive.
- K214 - General Purpose Adhesive.
- K219 - Structural 5 Minute Adhesive.
- K2005 – High Peel Strength Structural Adhesive.
- Fairing Cream - Sandable Smoothing Paste.
- Truestik EA - Flexible Adhesive – Multipurpose.

EPOXY SELECTION CHART:

http://www.allnexconstruction.com/pdf/Epoxy_Uses.pdf

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Replaces: Sept 1997

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