



DIY Products

ARALDITE CRYSTAL

Technical Data Sheet

Reviewed: 06.06.2015



DESCRIPTION

ARALDITE CRYSTAL is a crystal clear, fast setting 2 component epoxy adhesive supplied in tubes. It is perfect for jobs that require invisible joints or high transparency. It is a strong, long lasting, solvent free adhesive which is water resistant and can be painted or sanded. **Sets in 5 minutes.**

ADVANTAGES

- Extra strong bonding
- Specially formulated for glass and jewellery
- Transparent - invisible
- Rapid set
- Easy application
- Temperature resistant (-30°C - +80°C)
- Humidity resistant
- Sandable and paintable
- Fills uneven breaks
- Withstands rough handling
- 100% solid content
- Solvent free

APPLICATIONS

ARALDITE CRYSTAL bonds glass, jewellery, crystals, china, porcelain, ceramics and also many other materials such as metal, wood, masonry, dry concrete, chipboard, leather, cardboard, most hard plastics, fabrics and rubbers (not suitable for polyethylene, polypropylene, Teflon, expanded polystyrene).

IMPORTANT: ARALDITE CRYSTAL is not suitable for bonding rear-view mirrors to car windscreens. Do not use for items, which may contain food or drink, as the joint however secure and clean it may appear, may entrap bacteria from the environment. Not intended for repairs on safety critical items e.g. rotating parts of hover mowers. Please note that some items are molded from polymers such as polythene or polypropylene, for example, and are simply not designed for repair. Repair may not be viable or would need specialist chemical treatment to achieve a bond.

INSTRUCTIONS FOR USE

1. Make sure surfaces are dry, clean and free from dust, dirt and grease. For even better bonding slightly roughen surfaces with sandpaper.
2. Remove caps from the tubes.
3. Dispense equal volumes of resin and hardener onto a clean disposable surface. Mix well for 30 seconds, by stirring and folding with a plastic palette knife. It is important to ensure a thorough mix. Reseal tubes with their correct caps as soon as possible.
4. Apply the mixed adhesive within 5 minutes to both surfaces of the joint and assemble carefully. A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint.
5. Keep the joint supported until set. A rubber band or sticky tape is ideal. An approximate guide to support and handling times at room temperature is given below:

Pot life: 5 minutes, approximately at 23°C

Support time: 20 minutes at 23°C

Full strength: 2 hours at 23°C

Setting times may be shorter in hot weather. In cold conditions the rate of curing of the mixed adhesive may be slowed down significantly and weak joints may result. For best results, use between 20°C and 25°C.

6. For a perfect finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

CLEANING

- Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners or acetone. Solvents must always be handled with due care as they may be hazardous or flammable. Please note that solvents may attack some rubbers, plastics, painted surfaces, fabrics, etc. Bear this in mind if intending to use solvent to remove excess adhesive, and carry out a preliminary test first.
- Cured adhesive residues can usually be dissolved from tools by soaking in paint stripper Mercola STRIPP & CLEAN.
- The adhesive may be removed from the skin using a suitable proprietary hand cleaner. Contact with the skin should however be avoided. Do not use solvents in contact with the skin. Always open and use adhesive products over a protected surface, and avoid contact with clothing.

REMARKS

Thorough mixing is the key to getting a good cured product. Simply stirring leaves unmixed materials at the margins. Always fold in the edges then re-stir. Cured adhesive may yellow if exposed to sunlight for long periods.

TYPICAL ADHESIVE CHARACTERISTICS

Resin

Physical form: Liquid

Chemical type: Epoxy resin

Viscosity 18000 – 45000 mPa·s (25°C)

Solids content: 100%

Colour: Transparent

Density: 1.15 g/cm³ (25°C)

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Hardener

Physical form: Liquid

Chemical type: Formulated Polyamine

Viscosity: 15000 - 35000 mPa·s (25°C)

Solids content: 100%

Colour: Almost colorless

Density: 1.16 g/cm³ (25°C)

TECHNICAL CHARACTERISTICS

Colour mixed: Transparent

Cured density: 1,16 g/cm³ (25°C)

Temperature: -30°C to +80°C depending on conditions of use

Water: Not intended for constant immersion

Oil and petrol: Good resistance

Chemicals: Good resistance

Sandability: Sandable when set. Please wear dust mask

Paintability: Good, but confirm by test. Fine sanding helps.

STORAGE

Store under dry conditions between 5°C and 25°C

SHELF LIFE

3 years if stored as directed above

PACKAGING

2x15ml

PACKAGING	CODE	BARCODE
2x15ml	00677	7610594000084

HEALTH AND SAFETY INFORMATION



Causes serious eye irritation. Causes skin irritation. May cause an allergic skin reaction. Toxic to aquatic life with long lasting effects. Read label before use. Keep out of reach of children. If medical advice is needed, have product container or label at hand. Wear protective gloves: > 8 hours (breakthrough time): butyl rubber, Ethyl Vinyl Alcohol Laminate (EVAL). Wear eye or face protection. Avoid release to the environment. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. IF ON SKIN: wash with plenty of soap and water. Dispose of contents and container in accordance with all local, regional, national and international regulations. Hazardous ingredients: reaction product: bisphenol A-(epichlorhydrin); epoxy resin (number average molecular weight < 700), N'-(3-Aminopropyl)-N,N-dimethylpropane-1,3-diamine N,N-4- trimethylpiperazine-1-ethylamine. Contains epoxy constituents. See information supplied by the manufacturer.

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.



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