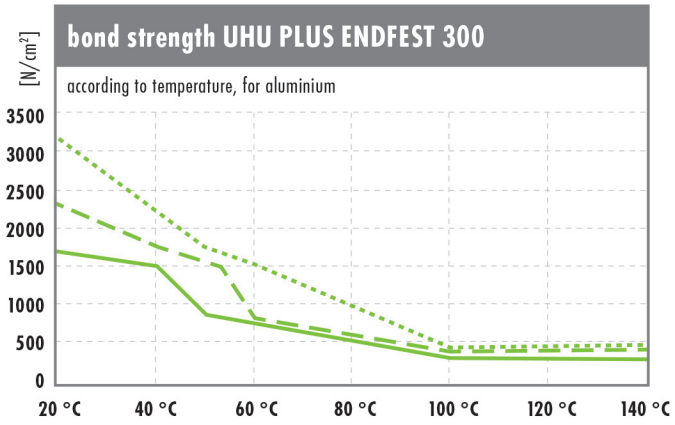
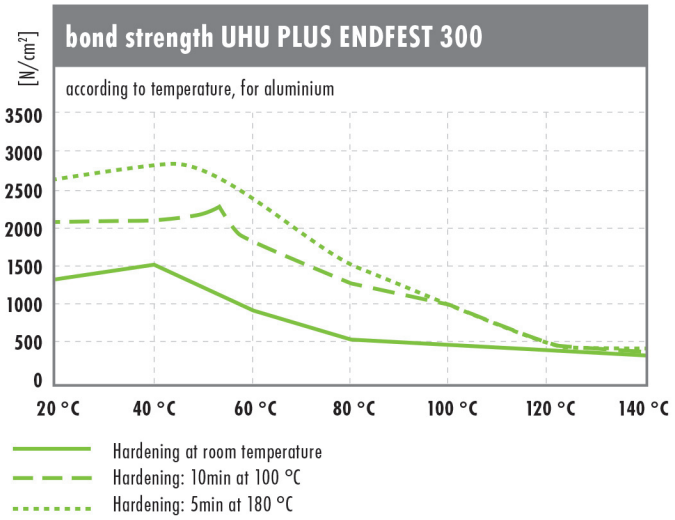
PLUS ENDFEST 300

UNIVERSAL STRONG DUAL-COMPONENT EPOXY ADHESIVE

mixing ratio 1:1 (binder and hardener by volume)
≙ mixing ratio 100:80 (by weight)



mixing ratio 100:50 (by weight)



PRODUCT DESCRIPTION

Universal strong dual-component epoxy adhesive.

FIELD OF APPLICATION

Ideal for repairs to metal, ceramics, porcelain, crystal, glass, ivory, pearls, precious stones and various synthetics (polyester, bakelite, formica, rigid polystyrene and acrylic glass (Perspex®). Not suitable for Polyethylene (PE), polypropylene (PP), PTFE and silicone rubber.

PROPERTIES

- Super-strong
- Resistant to temperatures between -40°C and +100°C
- Filling
- Water resistant
- Chemical resistant
- Paintable

PREPARATION

Working conditions: Only apply at temperatures between +5°C and +35°C. Product cures by mixing the resin and hardener.
Personal safety: Preferably wear gloves.
Surface requirements: The materials to be bonded must be dry, clean, free of dust and grease.
Preliminary surface treatment: Degrease parts to be bonded with acetone. Roughen smooth surfaces (sandpaper).
Tools: Mix the components by means of the supplied mixing bowl and spatula.

APPLICATION

Mixture ratio: 1:1 (by volume)
Coverage: 1 ml = approx 1 cm^2 at a film thickness of 1 mm

Directions for use:
Press out an equal amount of both components onto the enclosed mixing tray. Mix these two equal parts well with a synthetic spatula until a mixture is obtained with a homogeneous colour. Apply the mixture, which at room temperature (+20°C) remains toolable for about 1.5 hours, as a thin layer on one of the two materials. Join the materials and keep them in place for 7 hours. Be careful not to move the parts before the adhesive has cured. Resin and hardener must not come into contact with each other unless for usage.
Potlife: 90 minutes
Stains/residue: Remove wet stains immediately with warm water and soap. Cured adhesive residue can only be removed mechanically.
Advice: Some types of synthetics can not be joined such as polyethylene and polypropylene. This can be tested by holding a glowing copper wire against the synthetics. Does it smell of wax? Then you can not bond it.
Use a piece of adhesive tape in order to keep the parts in place while the adhesive is curing.

Note: This information is the result of carefully executed tests. This Technical Data Sheet has been prepared to the best of our knowledge to provide you with advice when gluing. We cannot be held responsible for the results or any damage suffered, as the variety of factors involved (type and combination of materials and working method) are beyond our control. Users have to carry out their own checks and trials. Liability can only be accepted for the consistently high quality of our product.

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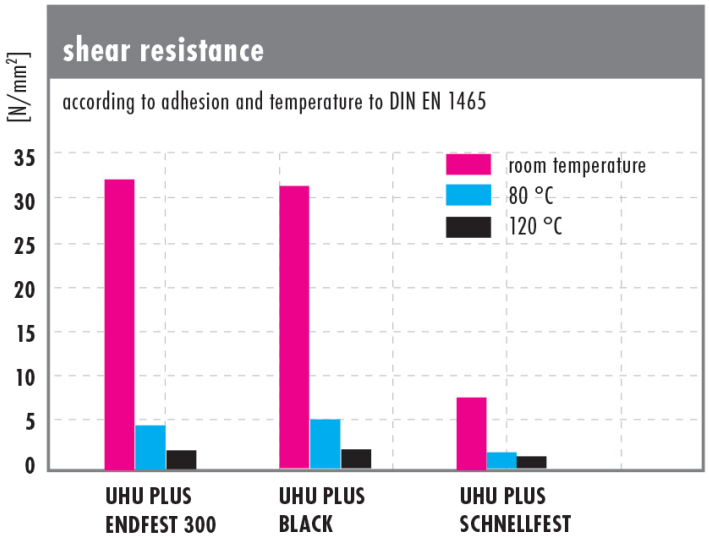
PLUS ENDFEST 300

UNIVERSAL STRONG DUAL-COMPONENT EPOXY ADHESIVE

Points of attention: Close well after use. For optimum performance it is important to create a larger amount of adhesive and mix it very well. Curing time depends on the temperature. Adhesive does not cure below +5°C.



CURE TIMES*

Drying/Curing time: approx. 90 minutes
Final bonding strength after: approx. 12 hours

Adhesion of UHU PLUS ENDFEST 300

according to temperature, for aluminium

temperature	hardening time	bond strength
40 °C	3h	ca. 18N/mm²
70 °C	45min	ca. 20N/mm²
100 °C	10min	ca. 25N/mm²
180 °C	5min	ca. 30N/mm²

* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

TECHNICAL PROPERTIES

Moisture resistance: Good
Water resistance: Good
Temperature resistance: -40°C - +100°C
UV resistance: Very good
Chemicals resistance: Very good
Paintability: Good
Filling capacity: Very good

TECHNICAL SPECIFICATIONS

Appearance: Binder: Opaque with high viscosity; Hardener: Honey Coloured with medium viscosity
Chemical base: Binder: Epoxy Resin; Hardener: Aliphatic Amines
Bonding technique: 1-sided application
Consistency: Liquid
Viscosity: approx. 35.000 mPa.s., Liquid
Solid matter: approx. 100 %

STORAGE CONDITIONS

Store cool, dry, frost-free and tightly closed.

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