

PX628MF

A general purpose, two part, room temperature medium fast curing adhesive

Application

- Structural bonding of metals, plastics and composites

Key Properties

- Excellent adhesion to a wide variety of substrates
- Non-toxic
- Thixotropic
- High impact resistance
- Medium cure speed

Description

- Basic Two-component epoxy system
- Resin RX628MF
- Hardener HX628MF

Physical Data (approx. – values)

	Resin	Hardener	Mixed
Colour	Natural	Natural	Natural
Specific Gravity	1.15	0.99	1.01
Viscosity (mPas) @ 25°C	Thixotropic	Thixotropic	Thixotropic

Cure Schedule (150ml sample)

Temperature	Working Life (minutes)	Gel Time (minutes)	Light Handling (hours)	Full Cure (hours)
10°C	30	90	4	48
RT	20	60	3	24
30°C	15	40	2	16

*RT is defined as 20-25°C

The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. For maximum properties a post cure may be required – Contact our technical service department for advice.

Processing

Mix ratio by weight 1.2:1
Mix ratio by volume 1.0:1

Approvals

RoHS compliant	Yes
UL94-V0	No
REACH (SVHC concentration)	0%

Typical Properties

Test	Result	Unit
Hardness	75	Shore D
Operating Temperature	-40 to +120	°C (Application and geometry dependant)
Thermal Conductivity	0.3	W/mK
Tensile Strength	36	mPa
Compressive Yield Strength	< 10	mPa
Coefficient of Linear Expansion	70 - 90	ppm/C
Volume Resistivity	3×13^{10}	ohm.cm
Electric Strength	15	kV/mm
Elongation at break	4	%
Glass transition	~40	°C
Water Absorption (7 days @ 23°C)	0.50	%

Lap Shear Adhesion

Aluminium to Aluminium	10.9 MPa	ABS to ABS	3.8 MPa
Copper to Copper	8.5 MPa	Nylon 6 to Nylon 6	2.3 MPa
Stainless Steel	11.8 MPa	Acrylic to Acrylic	3.2 MPa

Packaging

PX628MF is available in Bulk, Twinpacks, kits and sets

Availability

Available through distribution and www.resins-online.com sales@robnor.co.uk

Cartridge Mixing Part Numbers

PX628MF/NC/050TC	
PX628MF/NC/200TC	

It is essential for best results that the cartridge is 'balanced' before use to ensure correct mixing. Loading the cartridge into the gun before attaching the mixer element and pumping the gun to push a small amount of the contents forward will achieve this.
Wipe the excess from the cartridge tip and add the static mixer.
The cartridge is now ready for use.

Twinpacks Part Numbers

Available on request	

Twinpacks are pre-weighed resin and hardener components contained in a tough flexible film, separated by a removable clip and rail.
Once the clip and rail is removed the resin and hardener is thoroughly mixed within the bag and is immediately ready for use. Mixing will normally take ~ 2 minutes due to the viscosity; but pay special attention to the corners.
Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use.
The twinpack weight/volume may also be tailored to a specific size on request.
For further details please visit www.robnor.co.uk

Bulk Materials Part Numbers

RX628MF/NC/5KG	HX628MF/NC/5KG
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Both resin and hardener are supplied in 5kg, 25kg and 200ltr drums and fully evacuated and ready for use. Care should be taken to ensure when mixing the resins air is not entrained in the mixture.
If this is unavoidable the mixed resin and hardener should be re-evacuated before dispensing.
The bulk resin and hardener materials can be dispensed from suitable dispensing machinery and Robnor Resins produce a range of these machines, details that can be provided on request.

Kits and Sets Part Numbers

PX628MF/NC/40KGKIT	

Kits and Sets are provided in separate containers to the correct ratio.
In Kit form, pour the hardener into the larger resin container and use it as a mixing vessel.
Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by erratic or partially incomplete cure even after extended time periods.

Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened. TS130 is a suitable non-flammable cleaning agent, although other solvents may be found suitable. TS130 will also remove cured material provided it is allowed to soak for a number of hours.

Storage and Shelf Life

Material stored in the original unopened containers under cool dry condition between 15° and 25°C will have a shelf life of at least two years.
Once used the containers must be kept sealed to prevent effects from water, air or contaminants.

Health and Safety

Epoxy resin systems may cause sensitisation by skin contact or inhalation may be corrosive, harmful or toxic. It is therefore strongly recommended that skin and eye contact is avoided by the using of appropriate personal protective equipment such as gloves, safety glasses or goggles and overalls. Wash any contamination from the skin immediately and thoroughly and do not eat, smoke or drink in the working vicinity. Under normal working conditions a good source of ventilation is adequate, however if the material is heated, or where vapour levels are likely to exceed the occupational exposure limits appropriate respiratory protection must be worn. Local exhaust ventilation (LEV) may be required especially for curing ovens or where large volumes of material are curing. The above is given as a guide only; please refer to RX/HX628MF Health and Safety data or our Technical Service Department for individual/specific advice.

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The results and information above does not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for his intended by proper evaluation and testing.

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