



Kisling AG

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TECHNICAL DATA SHEET

ergo® 1810 (ergo® 1811 resin + ergo® 1812 activator)

Product - Description

The product is suitable to bond metals like aluminum, steel, brass and its alloys as well as ferrite and combinations.

It is a two-component system and cures after mixing into a tack-free, high-strength and impact resisting polymer film. The best mixture-ratio is 1:1 (volume) and is obtainable without problems by using the common double-cartridges.

Advantages

- Fast curing system
- High tensile shear strength
- Creates a dry and tack-free film, even outside the bonding area
- Resists against impacts as well as again peeling
- Good gap-filling behavior up to 0,50mm
- Free of solvents
- Short fixture time and reliable curing

Physical Properties (liquid product)

Chemical base : modified urethane-methacrylate

Viskosity : thixotropic

Brookfield RVT, Sp.6, 25°C, 1rpm : approx. 150.0 00 mPas

100rpm : approx. 5.000 mPas

Density : 1,1 g/cm³

color adhesive (ergo® 1811) : red

activator (ergo® 1812) : green

Shelf life : 12 month at room temperature



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cured product:

tensile shear strength acc. to DIN EN 1465, parts only degreased

aluminum/ aluminum

after 24 h at 23°C : > 25 N/mm²

steel/ steel

after 24 h at 23°C : > 25 N/mm²

- Impact resistance : good
- Resistance against bending : very good
- Elongation at break : ~ 50 %
- Peeling (T-peel on aluminium) : ~ 6 N/mm
- Thermal range : - 40°C up to + 150°C

Curing

- Curing system : 2-component-system
ratio 1:1 (volume)
- Potlife : 2 - 5 minutes (2g-mixture)
- Initial strength : ~ 10 minutes at 23°C
- 75% of final strength : ~ 2 hours at 23°C
- Final strength : ~ 12 hours at 23°C
- Dry, tack-free surface : ~ 12 hours at 23°C

How to use the product

Resin ergo® 1811 und activator ergo® 1812 is normally applied by using the double-cartridge with static mixture tube. ATTENTION: Potlife in the tube will be, depending on room-temperature, between 2 - 5 minutes. Apply the mixed glue on one part and spread it carefully over the whole bonding area. Fit the parts together and fix them at least as long as the potlife time, better 10 minutes.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

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