



# Technical Data Sheet

## B2204 Steel Epoxy Resin

### PRODUCT DESCRIPTION

B2204 is a two part cold curing epoxy adhesive. B2204 will bond a wide range of metals and plastics. B2204 has a medium length work-life, 90 minutes, to cater for a long assembly time.

### APPLICATIONS

General purpose metal and plastics assembly.

### USEFUL HINTS/NOTES

- Clean & easy to use.
- Viscous but not thixotropic.
- Rapid Curing.

### INSTRUCTIONS FOR USE

Proper surface preparation is essential to the success of any epoxy application. In all cases the surface should be clean, dry free from any oils.

- Remove all oils, dirt and grease by means of a strong cleaner/degreaser.
- Mix equal quantities of the two parts and stir thoroughly until a uniformed colour is obtained. Where a static mixing nozzle is supplied the 2 parts will be mixed correctly upon dispensing.
- Apply to one surface and offer up the second surface. Clamp or jig together under light pressure.
- Leave to cure at room temperature.

### CAUTION

Some instances have occurred of the Part 1 setting solid. This is due to it crystallising. It can be returned to normal by placing in a bath of hot water.

### TECHNICAL FEATURES

	Part 1	Part 2
Physical form	Viscous Paste	
Appearance	Black	Cream
Viscosity @ 25°C	35,000 cps	35,000 cps
Specific Gravity	1.6	1.4
Mix ratio	1:1	
Work Life	As a mix 90 minutes	
Temperature Range	-40°C - 121°C	

### CURED PERFORMANCE

Plastics	Shear Strength	
	PSI	MPa
ABS	500	3.4
GRP	870	6.0
HIPS	300	2.1
Perspex	580	4.0
Polycarbonate	550	3.8
Metals	Shear Strength	
	PSI	MPa
Steel	3500	24
Steel, Abraded	2250	15.5
Stainless Steel	2950	20.3
Aluminium	2100	14.5
Aluminium, Abraded	2400	16.6
Galvanised Iron	1800	12.4

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## HEALTH & SAFETY

This technical information sheet does not constitute a Safety Data Sheet (SDS). Before using this product ensure you have read and fully understood this products SDS

## STORAGE

Store product in the unopened container in a dry area out of direct sunlight. Storage between 5°C and 25°C. If stored properly, this product has a shelf life of 12 months.

## PACKAGING FORMAT

Cartridge.....50ml, 400ml

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