Technical Instruction Sheet

Characteristics:

AKEPOX® 3000 Mini Quick is a jelly-like, solvent-free 2-component adhesive based on an epoxy resin containing a modified special hardener. The product is distinguished by the following qualities:

- very rapid hardening
- easy measuring and mixing by use of cartridge system
- extremely low shrinkage during the hardening process and therefore low tensions in the bonding layer
- a good dimensional stability of the bonding layer
- a small tendency to fatigue
- a very good alkali-stability, thus the adhesive is very well suited to bond concrete.
- excellently suited for bonding gas-impermeable materials as it is a solvent-free product
- good electrical insulating property
- suited for bonding materials which are sensitive to solvents (e.g. expanded polystyrene, acrylonitrile butadiene styrene)
- the product is not liable to crystallize, therefore no problems in storing and processing.

Field of Application:

AKEPOX® 3000 Mini Quick is an universal adhesive for bonding natural and cast stones, metal (iron, steel, aluminium, copper), wood, ceramics and various synthetic materials (rigid PVC, polyester). Due to its jelly-like consistency the product has a good vertical stability. The rapid hardening time makes the product suitable for assembly work, bonding of letters and dowels. Materials s. a. polyolefin (polyethylene, polypropylene), silicone, fluorohydrocarbons (teflon), flexible PVC and butyl rubber cannot be bonded with AKEPOX® 3000 Mini Quick.

Instructions for Use:

- without mixing nozzle: dosing apparatus only
- with mixing nozzle: dosing and mixing apparatus at the same time

1. Thoroughly clean and slightly roughen surfaces to be bonded.
2. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle.
3. Both components must be thoroughly mixed when working without mixing nozzle.
4. The mixture remains workable for approx. 3-4 min (20°C). After 30-60 min (20°C) the adhesive has a good initial stability, after 3-5 hours (20°C) the bonding may be stressed; after 24 hours (20°C) the adhesive has its max. stability.
5. Tools can be cleaned with AKEMI Nitro-Dilution.
6. The hardening process is accelerated by heat and delayed by cold.
7. If stored in cool place, approx. shelf life is 1 year.

Special Hints:

- The product is not suited for bondings which are exposed to permanent moisture.
- Metallic surfaces should be ground in a short interval before bonding to avoid a decrease in adhesion.
- Use AKEMI Liquid Glove to protect your hands.
- An adhesive which is already thickened or just gelling should not be used anymore.
- At temperatures below 10°C the product should not be used anymore as there is no sufficient hardening.
- The hardened adhesive is liable to yellowing, especially when exposed to sunlight

- Once hardened, the adhesive can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- When worked correctly, the hardened adhesive is not damaging to health.
- Use AKEMI original mixing nozzle only.

Safety Measures: see EC Safety Data Sheet

Technical Data:

1. Component A+B
   Colour: milky white
   Density: approx. 1.16 g/cm³

2. Working Time

a) mixture of 75 g of component A + 75 g of component B
   at 10°C: 8 - 9 minutes
   at 20°C: 3 - 4 minutes
   at 30°C: 2 - 3 minutes
   at 40°C: 1 - 2 minutes

b) at 20°C and different quantities
   15 g of component A + 15 g of component B}
   40 g of component A + 40 g of component B}
   75 g of component A + 75 g of component B}3 - 4 minutes
   250 g of component A + 250 g of component B}

3. Hardening process (shore-D-hardness) of a 2 mm layer at 20°C

15 min	30 min	60 min	2 hrs	3 hrs	4 hrs	5 hrs	24 hrs
30	35	36	43	48	50	52	63

4. Shelf life: 1 year approx. if stored in cool place free from frost in its tightly closed original container.

Notice: The above information is based on the latest stage of technical progress. It is to be considered as a non-binding hint and does not release the user from a performance test, since application, processing and environmental influences are beyond our realm of control.

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