



# TECHNICAL DATA SHEET

## RADEX 225 2k epoxy structural bonding

RADEX 225 2k epoxy is a fast curing, easy to use structural 2C Epoxy tin solder replacement which cures by a chemical reaction of the two components forming a durable polymer resistant to elevated temperature, moisture and many solvents and chemicals.

RADEX 225 2k epoxy is specially designed for repairing surfaces of aluminium or steel. RADEX 225 2k epoxy shows excellent gap filling properties. Once cured RADEX 225 2k epoxy is perfect sandable. Curing time can be reduced by heat. At 45 degrees Celsius the 2C-Epoxy is sandable after 20 minutes. No shrinkage.

### TECHNICAL DATA:

#### Nominal Components Properties:

	RADEX 225 2k epoxy - A	RADEX 225 2k epoxy - B
<b>Chemical base</b>	Epoxy	Amine
<b>Colour</b>	Grey	Off white
<b>Specific Gravity [g/cm<sup>3</sup>]</b>	1,37	1,33
<b>Viscosity [mPas]</b>	118.000	55.000
<b>Appearance</b>	Pasty	Pasty

#### Typical Cure Characteristics:

<b>Working Time</b>	<b>@ 23° C [min]</b>	<b>25</b>
<b>Sanding Time</b>	@ 23° C [hr]	2,5
<b>Clamp Time</b>	@ 23° C [min]	--

#### Typical properties of Cured Adhesive:

<b>Shore D Hardness</b>	<b>EN ISO 868 @ 23° C</b>	<b>82</b>
<b>Tensile Strength</b>	DIN 53504 @ 23° C [MPa]	34
<b>Young's Modulus</b>	DIN 53504 @ 23° C [MPa]	459
<b>Elongation at Break</b>	DIN 53504 @ 23° C [%]	11



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### LAP SHEAR INFORMATION:

Substrate	Pre-treatment			Bondline thickness	Average strength
	Cleaning	Sanding	Cleaning		
CRS	Acetone	P80	Acetone	1 mm	16 MPa
Stainless steel	Acetone	P80	Acetone	1 mm	13,6 MPa
Galvanized steel	Acetone	P80	Acetone	1 mm	14,3 MPa
Aluminium	Acetone	P80	Acetone	1 mm	10 MPa

### USE INSTRUCTIONS:

RADEX 225 2k epoxy has been designed for ease of dispensing with both hand-held manual and pneumatic applicator tools. To assure an on ratio dispense we recommend levelling the pistons by placing the opened cartridge in the dispenser and purge till material starts to flow from both cartridge chambers prior to attaching the mixer. After attaching the mixer tip (we recommend to only use the mixer tips included in the package; additional mixer tips can be ordered from RADEX) and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both epoxy and amine through the mixer tip. It is recommended to dispose the first 25 to 30 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform grey colour, is creamy, smooth and glossy. The mixer time is 50% of the open time.

After having finished dispensing, leave the mixer in place till RADEX 225 2k epoxy shall be used again. The remainder of the adhesive will have a shelf life of several weeks if stored properly. To start using RADEX 225 2k epoxy again, remove the static mixer and dispose of properly. Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated. Attach a new mixer and start dispensing.



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### **SAFETY NOTE:**

Please observe the information provided with the Material Safety Data Sheet.

MSDSs are provided to you under RADEX's policy of communicating to our customer health, safety and environmental information for safe handling, use and disposal of our products. This information must be made available to health and safety personnel within your organization and to all employees who come in contact with these products.

**RECOMMENDED WORKING TEMPERATURE:** Between 15-30 °C

**STORAGE:** Unopened containers stored at a dry place indoors at 15 – 35 °C

**SHELF LIFE:** 18 Months in the originally sealed cartridge

**PACKAGING:** RADEX 225 2k epoxy is packed in 195 ml u-TAH cartridges for use with a hand-held dispensing tool. Other packaging available on request.

