

## KOPSTRUAL SA-2105

### Transparent two part/5mins gel time / Modified epoxy adhesives

#### Product Description

SA-2105 Epoxy Adhesive Clear is a fast setting, two-part, 1:1 mix ratio mercaptan-cured epoxy adhesive. It is unique among fast setting mercaptan cure epoxies in that it combines high shear strength with good peel performance properties. SA-2105 epoxy adhesive is transparent and slightly flexible when cured.

#### Features

5 minute worklife	1:1 mix ratio
High shear and peel strength	Slightly flexible

#### Typical uncured Properties

Chemical component		Modified epoxy resin
Appearance	Part A	Transparent
	Part B	Transparent or slightly yellow
Viscosity, @ 25°C	Part A	11000 ~ 15000cPs
	Part B	10000 ~ 16000cPs

- mix ratio                                A : B = 100 : 100 ( By weight )
- Worklife                                    5mins@ 25°C ( 100 gram )
- Time to Handling Strength        10mins@ 25°C ( shear strength > 1MPa )

#### Handling/Curing Information

##### Directions For Use

1. For high strength structural bonds, paint, oxide films, oils, dust, mold release agents and all other surface contaminants must be completely removed. However, the amount of surface preparation depends on the required bond strength and the environmental aging resistance desired by user. For specific surface preparations on common substrates, see the section on surface preparation.
2. Use gloves to minimize skin contact. Do not use solvents for cleaning hands.
3. Mixing

##### For Duo-Pak Cartridges

SA-2105 Epoxy Adhesive is supplied in a dual syringe plastic duo-pak cartridge as part of the Applicator System.

To use, simply insert the duo-pak cartridge into the EPX applicator and start the plunger into the cylinders using light pressure on the trigger. Next, remove the duopak cartridge cap and expel a small amount of adhesive to ensure both sides of the duo-pak cartridge are flowing evenly and freely. If automatic mixing of Part A and Part B is desired, attach the EPX applicator mixing nozzle to the duo-pak cartridge and begin dispensing the



adhesive. For hand mixing, expel the desired amount of adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.

**For Bulk Containers**

Mix thoroughly by weight or volume in the proportions specified in the typical uncured properties section. Mix approximately 15 seconds after uniform color is obtained.

4. For maximum bond strength, apply adhesive evenly to both surfaces to be joined.

5. Application to the substrates should be made within 3 minutes. Larger quantities and/or higher temperatures will reduce this working time.

6. Join the adhesive coated surfaces and allow to cure at 60°F (16°C) or above until completely firm. Heat up to 200°F (93°C), in order to speed curing. These products will cure in 48 hours @ 75°F (24°C).

7. Keep parts from moving during cure. Contact pressure necessary. Maximum shear strength is obtained with a 3-5 mil bond line.

8. Excess uncured adhesive can be cleaned up with methyl ethyl ketone (MEK).

**Typical cured Properties**

Hardness,Shore D	85D
Shear strength , GRP	9 MPa
Peel strength, Aluminum	5.5 N/mm
Typical Glass transition temperature , Tg	40°C
Permitted useful temperature range	-40 ~ 90°C

**Storage & Shelf Life**

Store products at 60-80°F (16-27°C) for maximum shelf life.

These products have a shelf life of 1 years in their unopened original bulk containers and 9 months in duo-pak containers.

**Package**

Duo-pak	Container
50ml、 400ml Duo cartridge	500 Gram / Plastic bottle;2Kilogram/Plastic Bottle

**About KOPLIN KPL :**

*KPL brand is owned by KOPLIN LLC.*

*KPL is engaged in providing complete solution of high performance adhesives, lubricants materials for manufacturers of electronics and other industries.*

*KOPLIN is in charge of product development, quality control and related industrial design. All KPL products are manufactured by partner factories authorized by KOPLIN LLC.*