





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	80D
Shear strength , GRP	10MPa
Peel strength, Aluminum	5.7 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.*