

PLIO METAL EPOXY

DEFINITION

PLIO-METAL EPOXY is a two-component structural epoxy cartridge adhesive system, intended for use in bonding panels made with sheet metal, aluminium, reinforced plastic, etc. Bond line thickness is controlled by 0.25 mm glass microspheres.

This 2:1 adhesive system is available as either 220ml side by side or 195ml universal cartridge format. The larger chamber contains a black epoxy based resin; the smaller one contains a beige catalyst system. Do not attempt to use mixing systems other than the one supplied in the application of this product. Additional mixers are available.

The product cures at room temperature, heat acceleration is possible.

Withstands automotive e-coat, powder prime, and paint oven temperatures up to 230°C.

When uncured, it is spot-weldable.

The system offers excellent corrosion protection, high energy absorption and very good crash performance.

CHARACTERISTICS

	Epoxy	Hardener
Colour	Nero	Beige
Consistency	paste	paste
Density, (g/cm³)	1.08	1.13
Ratio by weight	1.9	1.0
Ratio by volume	2.0	1.0
Odour	none	Amine

Cured adhesive:

- Tensile strength (23°C): 30 MPa
- Elongation at break: 3.0%
- Water absorption: 2.9%
- Shore hardness (D): 80
- Oven curing: up to 230°C
- Gap-filling capability: Very good
- Sag resistance: Excellent, non-sagging
- Coverage (round bead, 6 mm diameter): Approx. 35 g/m
- Coverage (round bead, 13 mm diameter): Approx. 141 g/m

The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.

* For any information about product codes or packs, please see our catalogue, our price list or contact us.

SUBSTRATE PREPARATION

The surfaces to be bonded must be thoroughly clean, dry, and free from grease or contaminants.

Suitable for application on:

- Metal: after sanding and degreasing.
- Composite materials such as SMC, RTM, and CFRP: after sanding and cleaning with a suitable solvent.

Due to the wide variety of coating systems and application conditions, preliminary tests are recommended to verify the compatibility of the selected paint system with the applied product. Each coating process should be evaluated in advance, as application variables may significantly affect the final result.

DRYING TIMES

- Open time at 23°C: 60 minutes
- Working time at 23°C: 90 minutes
- Clamping time at 23°C: 4 hours
- Full cure time at 23°C: 24 hours

STORAGE

Store the product in a dry place, protected from direct sunlight, at temperatures between 5°C and 35°C.

The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.

* For any information about product codes or packs, please see our catalogue, our price list or contact us.