

# ***Robnor Adhesive***

## **Technical Data Sheet Epoxy Adhesive PX800CS**

### **Description**

PX800CS is a very fast curing multi-purpose epoxy adhesive with excellent all round properties.

### **Features**

Non-Toxic  
Rapid curing  
High adhesion to a wide variety of substrates  
Excellent chemical resistance

### **Specification**

<b>Property</b>	<b>Resin RX800CS</b>	<b>Hardener HX800CS</b>	<b>Mixed PX800CS</b>
Colour	Light Yellow	Amber	Pale Yellow
Specific Gravity g/ml	1.18	1.14	1.15
Viscosity m.Pa.s @ 25°C	150,000	100,000	120,000
Mix Ratio by Weight	1:1		
Mix Ratio by Volume	1:1		
Usable Life (20g @ 25°C)	4 minutes		
No Flow Gel (20g @ 25°C)	5 minutes		

### **Approvals**

RoHS compliant	Yes
UL94-V0	No
REACH (SVHC concentration)	0%

<b>Cure Schedule</b>	<b>Working Life</b>	<b>Light Handling</b>	<b>Full Cure</b>	<b>Post Cure</b>
Temperature	(minutes *)	(hours *)	(hours *)	(**)
10°C	4	6	24	3 days @ 25°C
20°C	4	3	12	4 hours @ 60°C
30°C	2	1	4	2 hours @ 80°C

\*2mm cross sectional area

\*\*For maximum properties

Cure time will depend on cross sectional area, ambient conditions and mixing method. The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects.

For maximum properties a post cure may be required - call Robnor Technical Service Department for advice.

### **Typical Properties**

Shore D Hardness	80	
Operating Temperature	-40 to +120°C	(Application and geometry dependant)
Thermal Conductivity	0.3 W/mK	
Tensile Strength	20 mPa	
Compressive Yield Strength	< 10 mPa	
Coefficient of Linear Expansion	70 - 90 ppm/C	
Volume Resistivity	13 Log <sub>10</sub> ohmm	
Electric Strength	15 kV/mm	
Water Absorption (7 days @ 23°C)	0.80%	

### **Lap shear adhesion**

Aluminium to Aluminium	7.6 MPa	ABS to ABS <sup>(1)</sup>	6.2 MPa
Copper to Copper	9.1 Mpa	Nylon 6 to Nylon 6	2.3 MPa
Stainless Steel	5.8 MPa	Acrylic to Acrylic	3.2 MPa

<sup>(1)</sup> Substrate failure

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Buy On-line: [www.resins-online.com](http://www.resins-online.com)

<b>Packaging</b>	<b>Part number</b>
50g Twin Cartridge	PX800CS/NC/050 TC
200g Twin Cartridge	PX800CS/NC/200 TC

**Availability:**

Available through distribution and [www.resins-online.com](http://www.resins-online.com)

**Cartridge Mixing**

It is essential for best results that the cartridge is 'balanced' before use to ensure correct mixing. Loading the cartridge into the gun before attaching the mixer element and pumping the gun to push a small amount of the contents forward will achieve this. Wipe the excess from the cartridge tip and add the static mixer. The cartridge is now ready for use.

**Twinpacks**

Twinpacks are pre-weighed resin and hardener contained in a tough flexible film, separated by a removable clip and rail. Once the clip and rail is removed the resin and hardener can be thoroughly mixed within the bag and is then ready for use. Mixing will normally take ~ 2 minutes depending on the operator and viscosity of the material. Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use. Light sediment may be re-dispersed by carefully warming (to avoid distortion of the clip and rail) and kneading the pack. The twinpack weight /volume may also be tailored to a specific size on request. The use of twinpacks results in reduced chemical handling and less environmental impact as the waste product is inert. For further mixing details please visit [www.robnor.co.uk](http://www.robnor.co.uk)

**Kits**

In kit form, resin and hardener are provided in separate containers to the correct ratio. In most cases, pour the hardener into the larger resin container and use it as a mixing vessel. Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by variable or partial cure (even after extended time periods).

**Cleaning**

All equipment contaminated with mixed material should be cleaned before the material has hardened. Robnor Resins TS130 is suitable non-flammable cleaning agent, although other solvents may be found suitable. TS130 will also remove cured material provided it is allowed to soak for a number of hours.

**Storage and Shelf Life**

Material stored in the original unopened containers in cool dry condition between 10 and 25°C will have a shelf life of at least two years. Once used the containers must be kept sealed to prevent effects from water, air or contaminants.

**Health and Safety**

Epoxy resin systems may cause sensitisation by skin contact or inhalation may be corrosive, harmful or toxic. It is therefore strongly recommended that skin and eye contact is avoided by the using of appropriate personal protective equipment such as gloves, safety glasses or goggles and overalls. Wash any contamination from the skin immediately and thoroughly and do not eat, smoke or drink in the working vicinity. Under normal working conditions a good source of ventilation is adequate, however if the material is heated then local exhaust ventilation (LEV) may be required especially for curing ovens. The above is given as a guide only; please refer to RX/HX800CS health and safety data or our Technical Service Department for individual/specific advice.

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