

Structural Adhesives

XD 4510 / XD 4511

Temperature resistant two component epoxy paste adhesive

Key properties

- Temperature resistant to 180°C
- Excellent resistance to most common chemicals
- Non-flowing paste for ease of application and good gap filling
- Bonds a wide range of substrate materials
- Post cure recommended for optimum properties

Description

XD 4510 with XD 4511 is a two component, ambient temperature gelling paste adhesive, which after post curing at temperatures up to 150°C, will give bonds with temperature resistance up to 180°C and excellent resistance to common chemicals. It is suitable for bonding a range of ferrous metals and aluminium alloy substrates and composite materials such as GRE, GRP and SMC.

Typical product data

| Property | XD 4510 | XD 4511 | Mixed adhesive |
|---------------------------|-------------------|-------------|-----------------|
| Colour (visual) | White-beige paste | Black paste | Dark grey paste |
| Viscosity at 25°C (Pas) | 90 - 140 | 50 - 70 | 80 - 140 |
| Specific gravity | 1.55 - 1.65 | 1.55 - 1.65 | 1.55 - 1.65 |
| Pot Life (100 gm at 25°C) | - | - | 90 minutes |

Processing

Pretreatment

The strength and durability of a bonded joint are dependant on proper treatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone, iso-propanol (for plastics) or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Low grade alcohol, gasoline (petrol) or paint thinners should never be used.

The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces. Abrading should be followed by a second degreasing treatment

| Mix ratio | Parts by weight | Parts by volume |
|-----------|-----------------|-----------------|
| XD 4510 | 100 | 100 |
| XD 4511 | 50 | 50 |

The resin and hardener should be mixed together at room temperature stirring thoroughly.

Application of adhesive

The resin/hardener mix is applied directly or with a spatula, to the pretreated and dry joint surfaces.

A layer of adhesive 0.05 to 0.10mm thick will normally impart the greatest lap shear strength to the joint.

The joint components should be assembled and clamped as soon as the adhesive has been applied. An even contact pressure throughout the joint area will ensure optimum cure.

Mechanical processing

Specialist firms have developed metering, mixing and spreading equipment that enables the bulk processing of adhesive.

We will be pleased to advise customers on the choice of equipment for their particular needs.

Equipment maintenance

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation.

If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Curing requirements

To achieve optimum performance properties an elevated temperature cure or post cure is recommended. This adhesive will solidify to a handlable state but will not fully cure at temperatures below 60°C.

Suggested cure schedules are:

3 hrs at 80°C

1 hr at 130°C

30 mins at 150°C

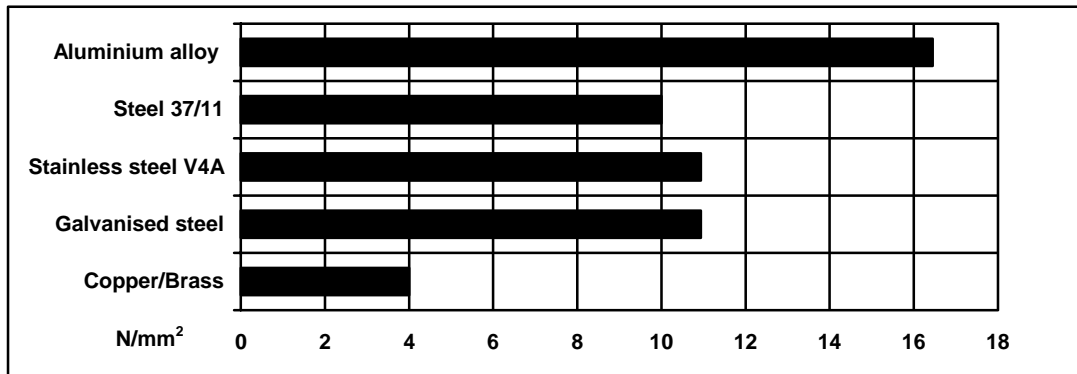
Typical cured properties

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 170 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case. The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

Average lap shear strengths of typical metal-to-metal joints (ISO 4587)

Cure: 24 hours at 23°C + 1 hour at 130°C and tested at 23°C

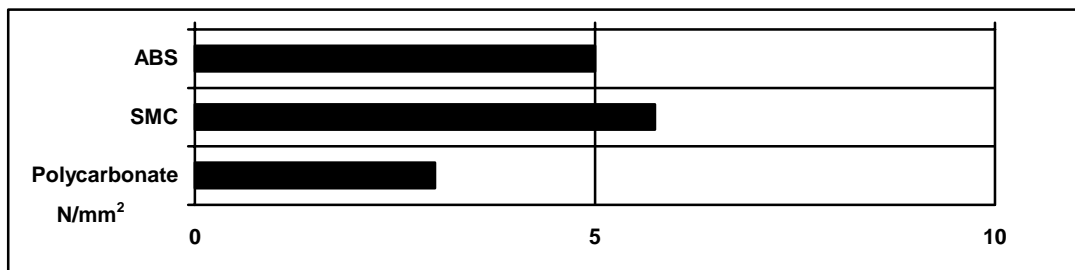
Pretreatment - Sand blasting



Average lap shear strengths of typical plastic to plastic joints (ISO 4587)

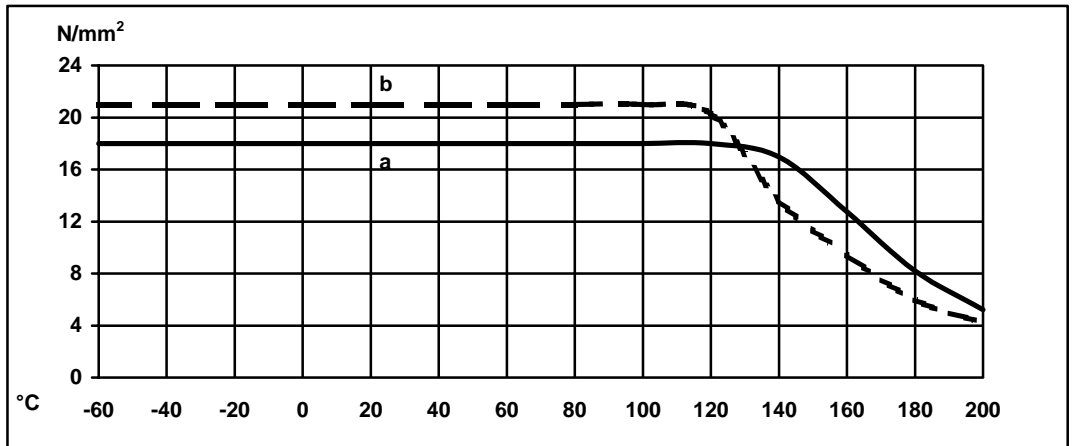
Cured: 24 hours at 23°C + 1 hour at 130°C and tested at 23°C

Pretreatment - Lightly abrade and isopropanol degrease



Lap shear strength versus temperature (ISO 4587) (typical average values)

Cure: (a)=24 hours at 23°C + 1 hour at 130°C (ACB, shot blast), (b)= 30 mins at 100°C (L165, pickled)



Roller peel test (ISO 4578)

Substrate: Aluminium alloy

1.6N/mm tested at 23°C

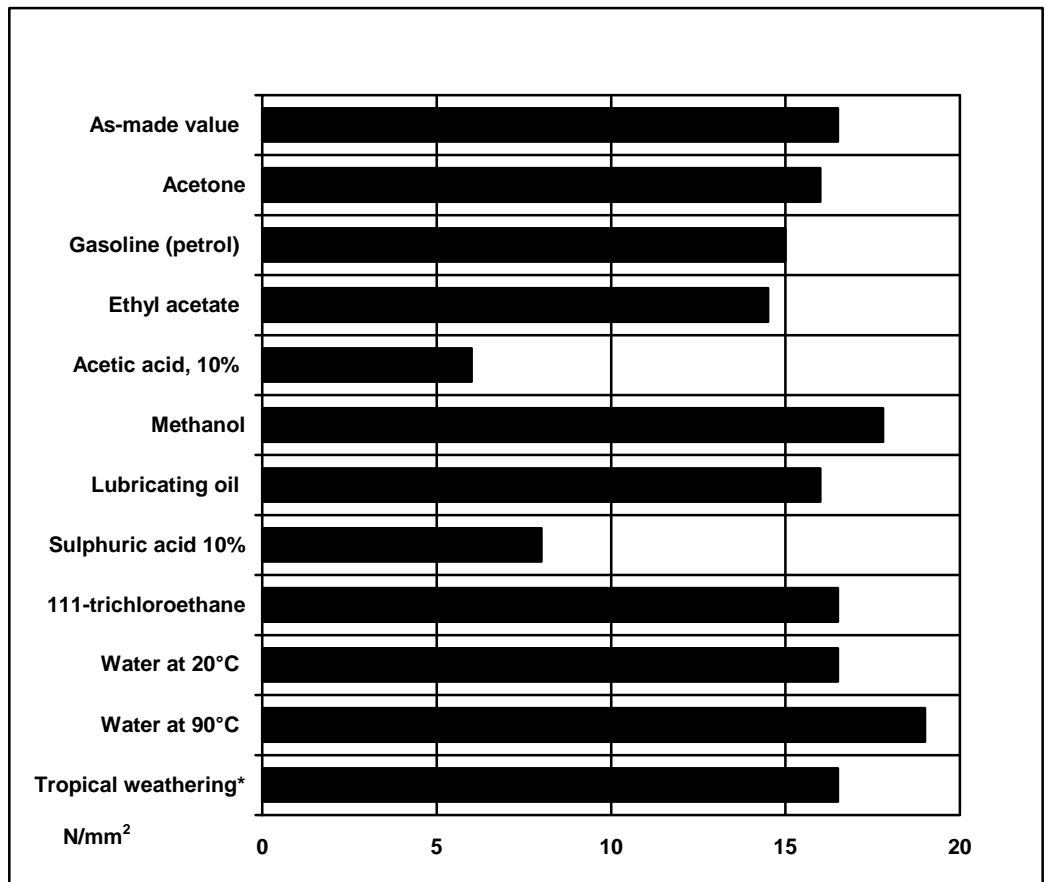
Cure: 24hours at 23°C + 1 hour at 130°C

6.0 N/mm tested at 120°C

Lap shear strength versus immersion in various media for 90 days (ISO 4587)

Typical average values

Cure: 24hours at 23°C + 1 hour at 130°C and tested at 23°C



* DIN 50015 (40/92)

Storage

XD 4510 and XD 4511 may be stored for up to 3 years at room temperature, provided that storage is in original sealed containers. The expiry date is indicated on the label.

Handling precautions**Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

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All recommendations for the use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefor. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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