Technical Data Sheet

Engineering Materials

EASYPOXY® K-230

Two-Component Epoxy Adhesive

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EASYPOXY® K-230

Product Description

EASYPOXY® K-230 is a two-component, 100% solids, room temperature cure epoxy adhesive system.

Areas of Application

General-purpose adhesive and repair compound for bonding of materials with widely different coefficients of thermal expansion

Features and Benefits

- High bond strength
- Electrically insulating
- Room temperature or low heat cure
- Neutral color for less noticeable bond lines
- Non-flowing paste

Transportation / Storage

Store at 20 – 30C / 68 – 86F°F in a dry controlled environment out of direct sunlight. This material should be suitable for use stored under these conditions in the original sealed containers for twelve (12) months from the date of shipment.

Failure to store the product as recommended above may lead to deterioration in product performance.

EASYPOXY® K-230 Part A and K-230 Part B may crystallize upon storage or during shipment. If crystallization has occurred, place the container in a 49 - 71°C / 120 - 160°F water bath until material is again pliable and then cool to room temperature before processing.

Health / Safety

Refer to the Safety Data Sheet.

See ELANTAS PDG Technical Bulletins *TI-100 - Handling Precautions for Epoxy Resins* and *TI-4005 - Epoxy Reaction Potential Hazards* for additional information.

Typical Properties of Material as Supplied

Property	Conditions	Value	
		EASYPOXY® K-230 Part A Resin	**EASYPOXY® K-230 Part B Hardener**
Viscosity	25°C / 77°F	100,000 cP	50,000 cP
Specific Gravity	25°C / 77°F	1.17	1.08
Color		clear	light amber
Mix Ratio	Parts by weight	100	45
Flash Point	ASTM D93	>94°C >201°F	>94°C >201°F

Regulatory Information

Property	Test Method	Value	Units
Volatile Organic Content	ASTM D6053	<0.1 [1]	%

[1] VOC test methods and limits vary widely by regulatory jurisdiction and product application. The value above was obtained by curing under our specific laboratory conditions.

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Surface Preparation

High-strength bonds can only be obtained if all surfaces to be bonded are free of moisture, dirt, rust, chemicals, and mold releases. In addition, surfaces to be bonded should be sandblasted, etched, or degreased. See ELANTAS PDG Technical Bulletin *TI-3000 Surface Preparation Guide* for additional information.

Application / Curing Schedule

Mix equal length beads of K-230 Part A Resin and K-230 Part B Hardener from the tube kits or at 100:45 by weight until a uniform color is achieved.

The bond surface must be dry and free from oil and dirt. Apply adhesive with a spatula or stiff brush to both joining surfaces. Apply light pressure to ensure proper wetting and contact of bonded surfaces.

Work life: 60 minutes @ 25°C / 77°F

Cure 24 - 36 hours at 25°C / 77°F – or – 2 hour at 65°C / 149°F

The cure schedules above are based on time after the unit reaches the specified temperature and are recommendations only. The user is responsible for determining the optimum cure conditions for their application.

Typical Physical Properties

Property	Test Method	Conditions	Value	Units
Appearance		25°C / 77°F	Clear	
Shore Hardness	ASTM D2240	25°C / 77°F	D 80	
Flexibility			semi-flexible	
Lap Shear Strength Etched Aluminum / Aluminum	ASTM D1002	-55°C / -67°F 25°C / 77°F 82°C / 180°F	1,400 2,500 1,500	psi psi psi
Linear Shrinkage	ASTM D2566	25°C / 77°F	0.7	%
Water Absorption	ASTM D570	24 h @ 25°C / 77°F	0.4	%
Flexural Strength	ASTM D790	25°C / 77°F	10,000	psi
Compressive Strength	ASTM D695	25°C / 77°F	18,000	psi
Thermal Conductivity		25°C / 77°F	0.2	w/m·K
Fungus Resistance	ASTM G21		Non-nutrient	

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Typical Electrical Properties

Property	Test Method	Conditions	Value	Units
Dielectric Constant	ASTM D150	1 kHz @ 25°C / 77°F	4.6	
Dissipation Factor	ASTM D150	1 kHz @ 25°C / 77°F	0.01	
Volume Resistivity	ASTM D257	1 kHz @ 25°C / 77°F	4.0×10^{13}	ohm-cm

The above properties are typical values and are not intended for specification use.