Technical Data Sheet

Engineering Materials

EASYPOXY® K-20

Two-Component Epoxy Adhesive

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EASYPOXY® K-20

Product Description

EASYPOXY® K-20 is a clear, two-component, 100%-solids, room temperature cure epoxy adhesive system

Areas of Application

General-purpose adhesive and repair compound for metal, wood, rubber and most plastics

Features and Benefits

- High bond strength
- Electrically insulating
- Room temperature or low heat cure
- Supplied in two-tube kit form

Transportation / Storage

Store between 20 - 30°C / 68 - 86°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.

Health / Safety

Refer to the Safety Data Sheet.

See ELANTAS PDG Technical Bulletin *TI-100 - Handling Precautions for Epoxy Resins* for additional information.

Typical Properties of Material as Supplied

Property	Conditions	Value	
		EASYPOXY® K-20 Part A Resin	**EASYPOXY® K-20 Part B Hardener**
Form	25°C / 77°F	Paste	Paste
Appearance		Clear	Tan
Mix Ratio	Parts by Weight	100	45
Flash Point	ASTM D93	> 94°C / > 201°F	> 94°C / > 201°F

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.

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Application / Curing Schedule

Dispense equal length beads from EASYPOXY® K-20 Part A and K-20 Part B onto a clean, dry surface or enclosed mixing board.

Mix thoroughly with tongue depressor until color is uniform.

The repair surface must be dry and free from oil and dirt. Apply with spatula or stiff brush. Apply to both joining surfaces, if possible, and wipe away excess material before it hardens.

Work life: 30 minutes

Cure: 24 hours at 25°C / 77°F **– or –** 2 hours at 65°C / 149°F

If resin has crystallized, place closed tube in a 49 – 71°C / 120 – 160°F water bath for 45 – 60 minutes.

Typical Physical Properties

Property	Test Method	Conditions	Value	Units
Shore Hardness	ASTM D2240	25°C / 77°F	D 85	
Lap Shear Strength Etched aluminum /aluminum	ASTM D1002	-55°C / -67°F 25°C / 77°F 82°C / 180°F	1,600 2,500 2,300	psi psi psi
Tensile Strength	ASTM D412	25°C / 77°F	3,000	psi
Flexural Strength	ASTM D790	25°C / 77°F	6,000	psi
Compressive Strength	ASTM D695	25°C / 77°F	10,000	psi
Linear Shrinkage	ASTM D2566	25°C / 77°F	< 1	%

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	25°C / 77°F	4.0×10^{13}	ohm-cm

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