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## EPOXY CONSTRUCTION ADHESIVE Havel Adhesive G 40 (COMP. A5 + B 20, B30)

### TDS, instruction to use

<b>Charakteristic:</b>	Epoxy construction adhesive Two component system
<b>Application:</b>	Bonding of epoxy laminates, sandwich, metal, wood, concrete, Production of cements and polymer concrete Mixing of compound A5 with hardeners B 20                           100:13...20-30min. B 30                           100:17...30-40min.
<b>Processing temperature:</b>	10-50°C
<b>Application methods:</b>	Manual application by brush, spatula, extrusion from cartridge
<b>Special properties:</b>	High hardness Chemical resistance High viscosity

Havel ADHESIVE G 40 is an epoxy adhesive based on a mixture of epoxy resin and a reactive diluent cured with a mixed modified hardener.  
Appearance of ingredients A5 light gray paste, B 20, B30 yellow paste.

#### **Application**

It is recommended to be used for bonding at 10 - 30 ° C (at normal temperature). The system is suitable for bonding laminate parts, metals, wood, concrete, etc. For perfect curing and improving mechanical properties such as bond strength and temperature resistance it is advisable to heat the bonded article for 4.5 hours to 45-60 ° C. Declared properties are given for non-tempered joints.

This system has been designed to be sufficiently cured at room temperature from 10 up to 30 ° C, therefore it can be processed even at room temperature and used after subsequent tempering. Pot life (for A5 + B20) is 20-30 minutes and 30-40 minutes for (A5 + B30) minutes at room temperature. By curing at room temperature (approx. 25 ° C) for 24 hours, heat resistance up to 50 ° C can be achieved. When hot cured, heat resistance up to 80 ° C can be achieved.

Gel time- in layer 1mm  
At 25°C about 1-3 hod.  
At 50 °C about 30 -50 min.

### **Aditives**

Contains thixotropic and structural fillers based on silica, glass fibers, etc. For some properties, can be mixed with: CAB-O-SIL, chopped fibers, talc, sand ...

### **Physical a chemical properties**

Contain of epoxy gr.	5291-5586 (resin. A without aditives)
Thermal stability	50°C curred at 25°C 24 hours 80°C curred at 60°C 3 hours
Epox. molar weight	182-192 g (resin. A without aditives)
Appearance 25°C	mastic slurry
Color	after mixing yellowish to yellowish gray non-transparent
Density at 25°C	0,93 g/cm <sup>3</sup> (DIN 53 217 T.4)
Flexural strength	52,2 MPa (ČSN EN ISO 14125)
Flexural modulus	1341,2 MPa (ČSN EN ISO 14125)
Impact strength	27,31+-6,47 kJ/m <sup>2</sup> (Charpy)
Breaking force	3178 N (ČSN EN 1465)
Elasticity modulus	7874 MPa (ČSN EN 1465)
Elongation at break	10,7% (ČSN EN 1465)

### **Storage**

In a sealed container, dark at 15-25 ° C, the shelf life is 6 months.

### **Health and safety**

Please read the separate Material Safety Data Sheet.

### **Note for the reader**

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