



TECHNICAL DATA SHEET

SK2TM200-6

Adhesive paste for bonding boards by prototype tooling

► DESCRIPTION

SK2TM200-6 is an epoxy modified two-components adhesive paste which was specially developed for bonding and repairing of high-temperature model boards.

► ADVANTAGES

- Maximum working temperature >200°C
- Pot life :10 hours at 20°C
- Do not contain solvent
- Low exothermal effect

► TECHNICAL DATA

Material type	Epoxy modified
Mix ratio	30:70 (A:B) 31:84 (A:B)
	Pb weight Pb volume
Aspect	Part A : Viscous yellow paste Part B : Yellow-brown paste
Pot life	10 hours (1000 g at 22 °C)
Viscosity	Part A : 80 Pa*s Part A : 1,5 Pa*s Adhesive (after mixing): > 500 Pa*s
Density	Part A: 0,96 g/cm ³ Part B: 0,84 g/cm ³ Adhesive (after mixing): 0,88 g/cm ³
Shelf life	6 months at 22 °C
Curing behaviour	60 °C – 4 hours 100 °C – 1 hour 180 °C – 1 hour 220 °C – 2 hour
Glass Transition Temperature	Curing Tg 180 °C – 1 hour 220 °C 220 °C – 2 hours 270 °C



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Coefficient of thermal expansion, $\times 10^{-6} \text{ } ^\circ\text{C}^{-1}$		
	at 100 °C	42,6
	at 150 °C	44,3
	at 200 °C	46,4
Shear strength	Destroying of modeling board material	

► APPLICATION

All operations on components' mixing and bonding should be carried at 18-25°C and humidity not more than 60%.

Bonding surfaces should be thoroughly cleaned, roughened and degreased with solvent.

Before application the adhesive parts should be carefully mixed with a glass or metallic spatula. Weight the necessary quantity of parts and then mix them in a metallic or polypropylene container during 5 minutes to ensure complete homogenization. The use of low-speed mechanical mixer (with the stirring rate not more than 100 rpm) is allowed.

Apply a thin layer of adhesive paste on surfaces meant to be bond using a spatula. Bond together the surfaces using a clamp. To get an adhesive bonding of high quality it is recommended to use vacuum bagging while bonding.

► PACKAGING

Packing	Minimum order quantity	Weight
SK2TM200-6	1	1 kg
SK2TM200-6	1	5 kg

Other packaging is available upon request.

Storage conditions: it is recommended to store at temperature from +15°C until +25°C in the original packing.