



TECHNICAL DATA SHEET

SK2TM80-2

Epoxy adhesive for bonding of PU boards

► DESCRIPTION

SK2TM80-2 is a two-component non-filled epoxy adhesive whose properties make it the ideal product for bonding high dimension surfaces having high levels of mechanical and ageing resistance.

► APPLICATION

Bonding of panels: honeycomb, aluminium sheet, steel sheet, composite materials, wood, thermoplastics, foam, etc.

PHYSICAL PROPERTIES			
	Resin	Hardener	Mixing
Mix ratio by weight	100	62	
Mix ratio by volume	100	73	
Colour	light amber	translucent red	pink
Specific gravity at 25°C	1.16	0.98	1.08
Brookfield viscosity at 25°C (mPa.s)	10,000	8,000	9,000
Pot life (50g) at 25°C (min)	Gel timer		50



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MECHANICAL PROPERTIES ON ASSEMBLIES			
Time to obtain 1 Mpa lap shear strength at 25°C	ISO 4587 : 95	h	6
Time to obtain 50% final lap shear strength at 25°C	ISO 4578 : 90	h	12
Lap shear strength on aluminium ⁽¹⁾	ISO 4587 : 95	MPa	29 AF ⁽²⁾
Floating roller peel resistance ⁽¹⁾	ISO 4578 : 90	kN/m	4 AF ⁽²⁾

Lap shear strength (LSS) on aluminium 2017A sand blasted.

(1) Hardening conditions: 8 hours at 80°C + 48 hours at room temperature.

(2) According to ISO 10365:1992: AF = Adhesive Failure.

► HANDLING PRECAUTIONS

It is recommended to use the product at a temperature between +18°C and +35°C.

Normal health and safety precautions should be observed when handling these products:

- ensure good ventilation,
- wear gloves and safety glasses,
- wear waterproof clothes.

For further information, please consult the product safety data sheet.

MECHANICAL PROPERTIES ON ASSEMBLIES			
Lap shear strength after moist cataplasm 15 days at 80°C	ISO 4587 : 95	MPa	27 AF ⁽²⁾
Lap shear strength after ageing by shock thermic 15 cycles D3 (see annex)	ISO 4587 : 95	MPa	29 AF ⁽²⁾
Lap shear strength after ageing by immersion for 3 weeks : • motor oil at 70°C • chlorhydric acid (0.1N) at 23°C • soda (0.1N) at 23°C • sea water at 23°C • gazole at 23°C • oil at 23°C	ISO 4587 : 95 ISO 175 : 99	MPa	29 AF ⁽²⁾ 28 AF ⁽²⁾ 29 AF ⁽²⁾ 29 AF ⁽²⁾ 28 AF ⁽²⁾ 28 AF ⁽²⁾
Lap shear strength after thermic ageing for 3 weeks at 100°C	ISO 4587 : 95	MPa	28 AF ⁽²⁾



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THERMAL AND MECHANICAL PROPERTIES			
Hardness	ISO 868 : 85	Shore D1 / D15	75/73
Tensile strength	ISO 527 : 96	MPa	30
Elongation at break	ISO 527 : 96	%	10
Glass transition temperature	TMA-METTLER	°C	60
Thermal coefficient of expansion (CTE) [-30 ; +50]°C	TMA-METTLER	10 ⁻⁶ K ⁻¹	70
Working temperature	-	°C	-40 ; +100

► SUBSTRATE PREPARATION

The item to be bonded must be free of all dirt, oil or other foreign matter. A clean, dry surface is a must. Please, refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner.

► PACKAGING

RESIN	HARDENER
6 x 0.5 kg	6 x 0.31 kg
5 kg	3.1 kg
25 kg	15.5 kg

► STORAGE

Shelf life of the SK2TM80-2 is 18 months stored in its original unopened packaging at a temperature between +15°C and +25°C.



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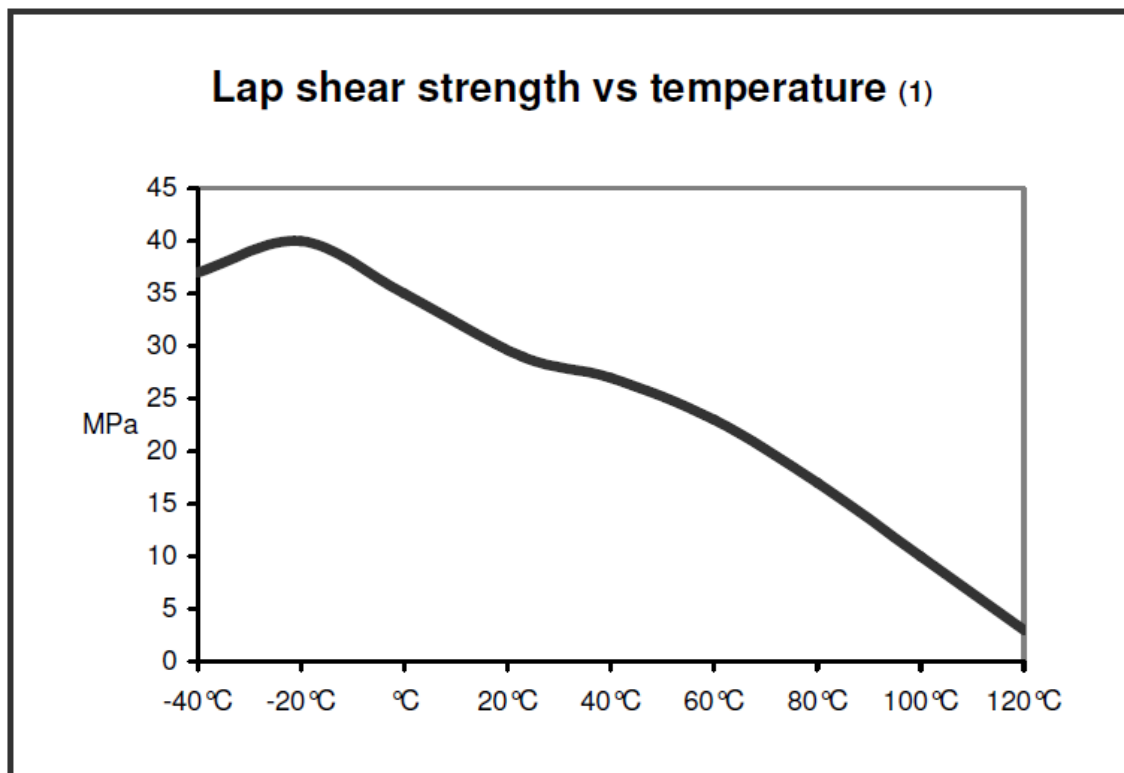
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► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

► ANNEX



(1) Hardening conditions: 8 hours at 80°C + 48 hours at room temperature



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THERMAL SHOCK TEST ACCORDING TO ISO 9142-93 NORM

D3 cycle

