

TECHNICAL DATA SHEET

VIK412B/A FC/NS

Two-component epoxy adhesive



VIK412 B/A FC/NS is a reliable, high-performance two-component epoxy adhesive that provides high mechanical strength and long-lasting bonds. Designed for use under significant loads, it is ideal for bonding metals, composite materials, and plastics where high strength and chemical resistance are required.

TECHNICAL DATA	VALUE
Material	Two-component epoxy adhesive
Color*	Part A: Blue* / Part B: Yellow
Curing agent	Amines
Consistency	Thixotropic paste
Application	High-strength bonding
Application method	400 ml cartridge

MECHANICAL PROPERTIES	VALUE
Tensile Strength	High
Vibration Resistance	High
Adhesion to Metals	Excellent

* Can be ordered as well with Part A: Black by achieving of MOQ 2.784 pce



Technical values are provided to the best of our knowledge and are based on data considered reliable. Users are responsible for verifying suitability and assume all associated risks.

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PHYSICAL AND CHEMICAL PROPERTIES

PARAMETER	VALUE UNCURED
Viscosity (mPa·s)	- For Resin: 300 – 500 Pa·s - For Hardener: 200 – 400 Pa·s
Specific Gravity	- For Resin: 1,15 g/cm ³ - For Hardener: 1,03 g/cm ³
Mixing Ratio (by volume)	100:50
Gelation Time (10 g)	120 minutes
Full Cure Time	24 hours at room temperature or 1-1,5 hours at a temperature 60°–65°C

PERFORMANCE CHARACTERISTICS

PARAMETER	VALUE
Overlap Shear Strength**	20,4 MPa

** results are typical value aluminum alloy D16T. Test conditions: +23°C / + 2°C

APPLICATION INSTRUCTIONS

- Surface Preparation**
Clean, degrease, and dry surfaces before application.
Mechanical treatment (sanding with fine sandpaper and then degrease with acetone) is recommended to improve adhesion.
- Mixing Components**
Use a 400 ml dual cartridge with a static mixer.
Follow the recommended mixing ratio.
- Adhesive Application**
Apply evenly to both surfaces.
Press the parts together and fix them until polymerization is complete.
- Curing Process**
The adhesive cures at room temperature at 23°C within 24 hours or to accelerate curing, heating to 60–65 °C may be applied, achieving full cure within approximately 1–1.5 hours.
- Excess uncured adhesive can be cleaned up with ketone type solvents. When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

PACKAGING

Form: Dual cartridge 400 ml
Net Weight: 0.440 kg
Part A Curing Agent Net Weight: 0.135 kg
Part B Epoxy resin Net Weight: 0.305 kg

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SAFETY PRECAUTIONS

Causes skin irritation.
May cause an allergic skin reaction.
Causes serious eye irritation.
Toxic to aquatic life with long-lasting effects.

PROTECTIVE MEASURES

Wear protective gloves and goggles.
Avoid inhaling vapors.
Avoid contact with eyes and skin.
In case of contact, rinse thoroughly with water.

STORAGE

Store in a tightly sealed container at 15-25°C in a dry place.
Avoid exposure to direct sunlight and moisture. The shelf life may be shortened if the original packaging is not properly sealed or stored in an environment with high temperatures or humidity.

The product can be stored up to 48 months after production.
Dispose of in accordance with local and international regulations.

MARKING

Part A: UN3082 (Environmentally hazardous substance, liquid, N.O.S. (epoxide derivatives)), Class 9

Part B: UN3259 (Amines, solid, corrosive, N.O.S.), Class 8