

Product Data

Aerospace Adhesives



Paste Adhesive

ST1060 STRUCTIL



DESCRIPTION

Two-part epoxy adhesive. This product is recommended for application requiring high deformation. It is adapted for pasting any rubbers EPDM until low temperatures (-40°C).

FEATURES

- Room temperature cure ($\geq 18^{\circ}\text{C}$)
- High elongation at break: $\approx 85\%$ at 23°C
- Pot life at 25°C : 2 hours

UNCURED ADHESIVES PROPERTIES

	PART A	PART B	MIXTURE
Colour	White	Amber	Amber
Brookfield viscosity at 25°C (Poise)	300 to 500	1000 to 3000	
Shelf life at 4°C / 25°C from date of shipment	1 year / 6 months	1 year / 1 year	

INSTRUCTIONS FOR USE

- Refer to the Material Safety Data Sheet before handling.
- Mixing:
Mix ratio by weight: Part A / Part B 100/200.
Thoroughly mix the two parts. The resulting colour must be consistent.
Do not mix quantities greater than 450g as dangerous heat buildup can occur.
- Bonding surfaces should be clean, dry and properly prepared.
- Curing: 5 to 7 days at 25°C to achieve optimal performance.
Cure time can be reduced by heating for 1 hour at 60°C .

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BOND STRENGTH PERFORMANCE

TEST TEMPERATURE (°C)	SHEAR ⁽¹⁾ : Lap shear strength (MPa)	PEEL ⁽²⁾ : Bell peel strength (N/25mm)
23	17	
80	5	150

⁽¹⁾ According to EN 2243-1, on aluminium 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 25°C

⁽²⁾ According to EN 2243-2, on aluminium 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 25°C

All values are nominal.

Important notice

All statements, technical information and recommendations offered are only for consideration and evaluation. Whilst they are believed to be accurate they are not guaranteed and are provided without warranty of any kind. No undertaking is given that the goods/products supplied are fit for any particular purpose and the buyer/user should rely upon its own tests to establish suitability of the goods/products for its particular purpose. The buyer/user shall assume all risks and liabilities in connection therewith.

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