



RESOLTECH 3350

Hardener 3358

Structural Epoxy adhesive Adhesion promoter for secondary laminations

- Rubber toughened epoxy
- High shear and peeling resistances
- Excellent applicability (grease-like consistency)
- Non sagging vertical applications > to 5mm & 10 mm horizontal
- All weather applicability even in high humidity conditions.



The RESOLTECH 3350 structural adhesive is a high performance adhesive offering a high tenacity and toughness. Its good elongation ratio enables to bond most materials, even if they have a large CTE difference.

Resoltech 3350's rheology is close to a universal grease, making the mixing and application very easy with a spatula or even with a brush.

The vertical sagging limit of 5mm on vertical applications & 10mm on horizontal applications will enable to bond bulkheads with 10 mm diameter fillet joints

Particularly resistant to the propagation of micro-cracking, this system is well adapted to the bonding subject to important cycles of fatigue.

The areas of application of the 3350 are very varied: structural composite bonding, adhesion promoter on secondary lamination specially on pre-pregs...etc.

Resin 3350

Hardener 3358

Secondary lamination structural adhesive

MIXING RATIO

By weight

Resin 3350

100

Hardener 3358

42



Le rapport de dosage doit être respecté sans excès ni défaut. Le mélange doit être intime et homogène avant l'utilisation.

APPLICATION

The surface should be clean, dust-free and degreased. Prepare all surfaces by abrading with medium grit paper or other suitable abrasive, remove dust then wipe with acetone, MEK or similar solvents

Metals usually require a chemical pre-treatment to create the best bond (contact Technical Services).

Ensure that **polyester or vinylester laminates** are fully cured before bonding, then prepare as above.

When bonding **epoxy laminates**, the use of a suitable Peel Ply as the last stage in their manufacture is recommended, otherwise prepare as above. Trials may be required to test Peel Ply suitability.

The adhesive can be applied with a notched trowel, spatula, putty knife or self mixing/dispensing machine in various thicknesses up to 5mm without sagging on vertical surfaces

- Avoid application under 10°C.
- Assemble and maintain parts in contact during hardening with clamps, vacuum or masking tape.
- Cleaning of the materials should be done before polymerization with acetone, methylethylcetone (MEK) or equivalent.

It is recommended to use **notched spreaders** in order to apply even thicknesses of adhesive on the surface to be bonded.

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PHYSICAL CHARACTERISTICS @ 25°C

Visual aspect

3350 : Opalescent Gel
3358 : Transparent to slightly yellow Gel
Mix : Opalescent Gel

Density

| REFERENCES | 3350 | 3358 | Mélange |
|------------|------|------|---------|
| Density | 1,00 | 1,00 | 1.00 |

Viscosity (Brookfield)

| REFERENCES | 3350 | 3358 |
|------------------------|------|------|
| Viscosity (mPa.s)* | 9000 | 2000 |
| Mix viscosity (mPa.s)* | - | 3700 |

REACTIVITY

All measures realized on Trombotech®

| Reactivity | 3350 / 3358 |
|----------------------------|-------------|
| Gel time on 70g @ 25°C | 25 min |
| Gel time on 500g @ 25°C | 20 min |
| Gel time on 5mm film @25°C | 60 min |
| Clamp time @ 25°C | 6 to 8 h |

* Due to the thixotropic nature of the system this value is purely indicative

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Curing

| Optima properties | 3350/ 3358 |
|-------------------|---------------------------|
| @ 25°C | 7 days (8h de clamp time) |
| @ 50°C | 16h |
| @ 70°C | 5h |

MECHANICAL PROPERTIES

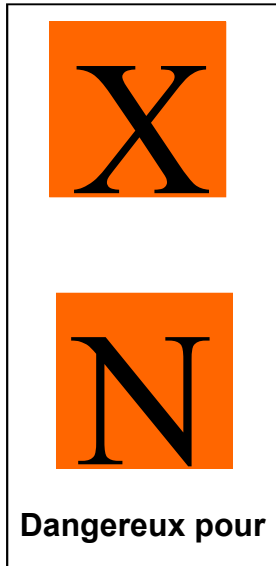
| PROPRIETES | |
|---|---------------------------------|
| Resistance to crack propagation | 10,51 kN |
| Resistance to failure in interlaminar mode - MBT | 0,453 ± 0.071 kJ/m ² |
| Resistance to failure in interlaminar mode - CC | 0,482 ± 0.142 kJ/m ² |
| Resistance to failure in interlaminar mode - MCC | 0,494 ± 0.149 kJ/m ² |
| Shear resistance on steel | 30,49 MPa |
| Conservation of shear resistance in wet environment | 98,70 % |

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LABELLING

3350



3358



PACKAGING

- Kit de 0,5 Kg + 0,21 Kg
- Kit de 1,0 Kg + 0,42 Kg
- Kit de 5,0 Kg + 2,10 Kg
- Kit de 25 Kg + 10,5 Kg

TRANSPORT ET STOCKAGE

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold preferably between 10°C and 30°C in a well ventilated area.

HEALTH & SAFETY

Although the 3350 3358 is a recent formulation, it is advised to follow basic rules such as avoiding skin contact and wear masks like with any other epoxy resins. Please read our standard health and safety sheet for more information. In case of eye contamination, wash with water and seek medical advice. Please read the Material Safety Data Sheet prior to using this product.

Nota The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.



resoltech
ADVANCED TECHNOLOGY RESINS

35, impasse Emeri • Pôle d'activités
13510 EGUILLES • France
Tél : +33 4 42 95 01 95 • Fax : +33 4 42 95 01 98
e-mail : info@resoltech.com • website : www.resoltech.com

Distribué par :

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