

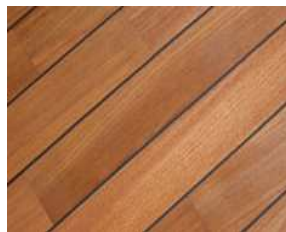
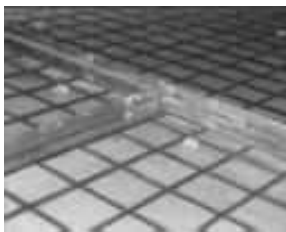


RESOLTECH 3500

Hardeners 3506, 3507, 3508

Epoxy Adhesive for bonding materials with different dilatation coefficient ratios

- 40% Elongation until break properties
- Excellent application characteristics (low viscosity, high thixotropy).
- Adjustable pot life for any size applications & climates.
- Ambient temperature curing.
- Applicable in high humidity conditions.



The Resoltech 3500 epoxy adhesive cures at ambient temperature and enables durable bondings of materials of different dilatations coefficient such as teak wood on composite, aluminium or steel hulls, steel on wood.

GRP laminates (polyester on polyester, vinylester on vinylster) bonded with the 3500 system will suffer delamination before adhesive failure

It's 40% elongation until break properties enable extremely strong and durable bonding with good chemical resistance.

Both resin and hardener component are low viscosity, but once mixed result in a highly thixotropic gel, easy to mix and to apply, while not sagging even applied on vertical surfaces in thick layers.

The hardener 3506 enables to obtain a long pot life for large surface applications and hot climates, while the 3507 and 3508 are faster and correspond to smaller surface applications.

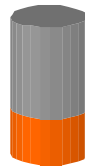
Resin 3500

Hardeners 3506, 3507 & 3508

Epoxy Adhesive for bonding materials with different dilatation coefficient ratios

MIXING RATIO

	By weight	By Volume
Resine 3500	100	100
Hardeners 3506 ,3507 & 3508	50	57



WARNING:

The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties. The mixture should be thoroughly stirred to ensure full homogeneity. It is important to note that epoxy systems tend to heat up much faster in a pot than as a thin film. It is therefore necessary to only mix the necessary amount usable within the given pot life. Keeping the mixture in flat open containers reduces the risks of exothermic reaction.

APPLICATION

The surface should be clean, dust-free and degreased. Resoltech 3500 will provide superior adherence onto composites, steel, aluminium, concrete and wood substrates.

The adhesive can be applied with a notched trowel, spatula, putty knife or self mixing/dispensing machine in various thicknesses up to 15mm without sagging.

- 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.

Resin 3500

Hardeners 3506, 3507 & 3508

PHYSICAL CHARACTERISTICS @ 25°C

Visual aspect

3500 : Thixotrope neutral color liquid
350X : Yellow thixotrope liquid
Mix : Light yellow thixotrop liquid

Density

REFERENCES	3500	350X	Mix
Density	1,10	0.97	1.05

Viscosity (Brookfield)

REFERENCES	3500	3506	3507	3508
Viscosity (mPa.s)	30000	6000	6000	6000
Mix viscosity (mPa.s)	-	15000	15000	15000

REACTIVITY

All measures realized on Trombotech®

Réactivités	3500 / 3506	3500 / 3507	3500/3508
Pot life on 375g @ 25°C	5h to 6h	NC	50 min
Pot life on 375g @ 40°C	1h	NC	NC
Gel time on 1 mm thick film @25°C	4h	2h	1h50
Clamp time @ 25°C	18 to 24h	12 to18h	6 to 12h

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CURING

Optimal properties	3500 / 3506	3500 / 3507	3500 / 3508
@ 20°C	7 days (24h clamp time)	4 days(18h clamp time)	3 days (12h clamp time)
@ 40°C	48h	24h	18h
@ 60°C	12h	6h	4h

MECHANICAL PROPERTIES

TRACTION

Tensile strength @ 23°C (ASTM D638M-96) :	8.0 MPa
Elongation until breaking (%) @ 23°C (ASTM D638M-96) :	40 %

HARDNESS

Shore (ASTM D2240-97) :	64 D
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SHEAR STRENGTH

Shear resistance on beech wood @ 23°C :	10.0 MPa (until wood break)
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GLASS TRANSITION

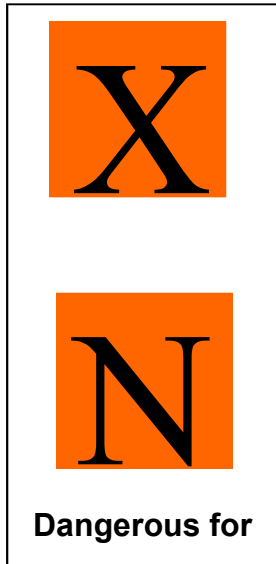
Glass transition temperature on Kinetech@ TGm :	52°C
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Resin 3500

Hardeners 3506, 3507 & 3508

LABELLING

3500



3506, 3507 & 3508



PACKAGING

- 0,75 KG Kit (0,5 Kg + 0,25 Kg)
- 1,5 kg Kit (1,0 Kg + 0,50 Kg)
- 4,5 kg Kit (3,0 Kg + 1,50 Kg)
- 37.5 kg. Kit (25kg +12.5 kg)
- 75kg Kit (2x25 Kg + 25 Kg)

TRANSPORT & STORAGE

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 3500/3506/3507/3508 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.



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