

Araldite[®] Kit K 268-1

Araldite [®] Kit K 268 - 1	Part A	100	pbv	100	pbw
Araldite [®] Kit K 268 - 1	Part B	100	pbv	100	pbw

Araldite[®] Kit K 268-1 is a two part, rapid set epoxy adhesive paste

Application

This system is designed specifically for the bonding of raised pavement markers to bitumen and concrete, but it is also for general adhesive purposes such as quick repairs to concrete and for bonding fixtures to concrete. It can also be used for bonding to metals and some plastics.

Processing methods

Manual mixing.

Key Properties

Cures at 5° C and above.
 Suitable for Bonding of road markers.
 Quick repairs to concrete, particularly in cold conditions.
 Bonding fixtures to concrete
 Bonding to metals and many plastics.

Product Data (Guideline Values)

Araldite® Kit K 268 - 1

		Resin	Hardener
Colour		White	Black
Consistency		Thixotropic Paste	Thixotropic Paste
Specific Gravity gm/cm ³		1.45 - 1.6	1.45 - 1.6
Flash Point°C	DIN 51758	Above 100	100
Shelf Life		At least 18 months	At least 18 months

Processing Data (Guideline Values)

Mix Ratio

		Parts by weight	Parts by volume
Araldite® Kit K 268 - 1	Part A	100	100
Araldite® Kit K 268 - 1	Part B	100	100

Gel Time, Viscosity and Curing

Usable Life	At 25° C	2-5 minutes
Minimum application temperature	At 5° C	
Initial Cure Time	At 15° C	40-60 minutes
	At 25° C	20-30 minutes
Full Cure Time	At 15° C	4 hours
	At 25° C	2 hours

Processing and Storage (Guideline Values)

Application

This system can be applied by towel or putty knife, or mechanically by metering/dispersing equipment. A cartridge version is available as Accumix 268-1 which mixes automatically as it dispenses.

Mixing

Mixing must be thorough and it should be continued until a homogeneous, streak less grey mix has been achieved.

Curing

To determine whether crosslinking has been carried to completion and the final properties are optimal, it is necessary to carry out relevant measurements on the actual object or to measure the glass transition temperature. Different gel and cure cycles in the customer's manufacturing process could lead to a different degree of crosslinking and thus a different glass transition temperature.

Storage Conditions

Store the components in a dry place at RT, in tightly sealed original containers. Under these conditions, the shelf life will correspond to the expiry date stated on the label. After this date, the product may be processed only after reanalysis. Partly emptied containers should be tightly closed immediately after use.

For information on waste disposal and hazardous products of decomposition in the event of a fire, refer to the Material Safety Data Sheets (MSDS) for these particular products.

Mechanical and Physical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 24h/RT + 6h/80°C

Density		1.6 ± 0.05
Compressive Strength	N/mm ²	50 - 60
Flexural Strength	N/mm ²	15 - 20
Elastic Modulus in Compression	N/mm ²	0.5 – 1.0 x 10 ³
Tensile Strength	N/mm ²	15 - 25
Tensile Bond Strength	N/mm ²	10 - 15

1N/mm² = 1 Mpa = 145 psi

Industrial hygiene

Mandatory and recommended industrial hygiene procedures should be followed whenever our products are being handled and processed. For additional information please consult the corresponding Safety Data Sheets and the brochure "Hygienic precautions for handling plastics products".

Handling Precautions

Safety precautions at workplace:

protective clothing

Yes.

gloves

Essential.

arm protectors

Recommended when skin contact likely.

goggles/safety glasses

Yes.

respirator/dust mask

Recommended.

Skin protection:

before starting work

Apply barrier cream to exposed skin.

after washing

Apply barrier or nourishing cream.

Cleaning of contaminated skin

Dab off with absorbent paper, wash with warm water and alkali-free soap, then dry with disposable towels. Do not use solvents.

Clean shop requirements

Cover workbenches, etc. with light coloured paper. Use disposable beakers, etc.

Disposal of spillage

Soak up with sawdust or cotton waste and

Ventilation:

deposit in plastic-lined bin.

of workshop

of workplace

Renew air 3 to 5 times an hour.

Exhaust fans. Operatives should avoid inhaling vapors.

First Aid

Contamination of the **eyes** by resin, hardener or casting mix should be treated immediately by flushing with clean, running water for 10 to 15 minutes. A doctor should then be consulted.

Material smeared or splashed on the **skin** should be dabbed off, and the contaminated area then washed and treated with a cleansing cream (see above). A doctor should be consulted in the event of severe irritation or burns. Contaminated clothing should be changed immediately.

For more detailed information please read Huntsman Advanced Material safety data sheets for the individual products.

Note

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