



HEMPADUR EPOXY ADHESIVE 05674

05674: BASE 05679: CURING AGENT 95670

Description: HEMPEL'S EPOXY ADHESIVE 05674 is a two-component polyamine adduct cured epoxy glue. Low viscosity and with good penetration properties.

Recommended use: For gluing of metal, china, sandwich constructions, polypropylen, deck covering, etc.

Availability: Part of European Yacht assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours: 00000/ Transparent
Finish: Glossy
Volume solids, %: 92 ± 1
Theoretical spreading rate: see REMARKS below
Flash point: 35 °C [95 °F]
Specific gravity: 1.1 kg/litre [9 lbs/US gallon]
Dry to touch: 6 - 8 approx. hour(s) 20°C/68°F or 15-20 hours at 10°C/50°F
Fully cured: 7 day(s) at 20°C/68°F or 14 days at 10°C/50°F
VOC content: 70 g/l [0.6 lbs/US gallon]

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.

APPLICATION DETAILS:

Version, mixed product:

05674

Mixing ratio:

BASE 05679: CURING AGENT 95670

1:1 by volume

Application method:

Brush, spatula or similar

Thinner (max.vol.):

Do not dilute.

Pot life:

2 approx. hour(s) 20°C/68°F or 4 hours at 10°C/50°F

Cleaning of tools:

HEMPEL'S THINNER 08451 or HEMPEL'S DEGREASER 99611

Safety:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.

SURFACE PREPARATION:

Glass fibre: All loose/defect gel coat must be removed and any absorbed moisture must have evaporated before applying the product.

Ferro-cement: Any loose surface layer (e.g. laitance) must be removed by sanding or abrasive sweeping. The moisture content of the concrete must be below 3%.

Wood: The wood must be completely dry, moisture content below 16%, and should not be primed with any ordinary priming oils or commercial antimould fluids. Only copper naphthenate based impregnating fluid can be used. Let it dry minimum 24 hours (20°C/68°F). As a general rule, the surface must be clean, free from rust, dirt, loose matter, oil, grease etc.

Porous, absorbing surfaces should be sealed with HEMPADUR SEALER 05990 or with HEMPEL'S EPOXY ADHESIVE 05674 diluted approximately 50% with HEMPEL'S THINNER 08451.

APPLICATION CONDITIONS:

The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 10°C/50°F. The temperature of the surface and that of the glue itself must also be above this limit.

For porous surface apply the glue on both sides before joining. For deck coverings apply the glue only on the deck surface and allow the glue to be tacky before mounting. In other cases the glued parts have to be held tightly together for 24 hours at 20°C/68°F, 48 hours at 10°C/50°F. Any surplus of the glue must be removed immediately by using HEMPEL'S THINNER 08451.

REMARKS:

Stirring:

Do not mix more than what is to be used within 2 hours at 20°C/68°F - 4 hours at 10°C/50°F. Pour the Curing Agent into the Base while stirring. The practical spreading rate is approximately 10 m²/litre (400 sq.ft/US gallon), however, much depending on porosity and roughness of the surface and method of application.

Note:

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The information given in the Product Data Sheet is intended for commercial use.

ISSUED BY:

HEMPEL A/S

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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