

AD4610 / H4610

FEATURES

- Structural bonding
- High viscosity
- Good thixotropy

COMPOSITION

- Resin: AD4610
- Hardener: H4610



AD4610 / H4610 is a two-component epoxy adhesive, with non-abrasive mineral fillers, characterized by high viscosity and thixotropy, immediate setting, hardening at room temperature. Designed for structural bonding of metals: steel, aluminum, anodized aluminum. Suitable for use with a mixing and dosing machine with pressing plates.

APPLICATIONS

- Bonding of textile combs

TYPICAL PROPERTIES

This data does not constitute the Product Sales Specifications. The values indicated refer to typical properties and are not to be understood as extreme minimum or maximum values. They do not constitute a guarantee of product conformity and do not relieve the buyer from the need to test the suitability of the products before use or placing them in his production cycle. Please contact your local sales representative to obtain the product specifications.

Property	Unit	Value
Color (Resin/Hardener)	Visual	Beige / Black
Density at 23°C (Resin/Hardener)	g/cm ³	1.4566 / 1.3492
Viscosity at 23°C (Resin/Hardener)	mPa.s	TIXO / 17000
Mix ratio Resin : Hardener	pbw	100 : 55
Onset [DSC]	°C	52.6
Peak [DSC]	°C	106.3
Setting time	mins	45
Not repositionable	mins	90
Pot Life [150g at 23°C]	mins	40
Gel time [150g at 23°C]	mins	60
Hardness	Shore D	86
Tensile strength	MPa	26.1
Elongation at break	%	4.0
Flexural modulus	MPa	4780
Flexural strength	MPa	51.2
Compressive modulus	MPa	1270
Compressive strength	MPa	92
Tg	°C	59
Linear shrinkage [500x50x10mm]	%	0.24

SUBSTRATE SETTING

The surface of the supports must be clean, free from dust, oils, release agents. Metal bonding: we recommend pre-heating the substrates to be bonded.

RESIN SETTING

The two components must be processed at a temperature between +20°C and +30°C. High temperatures

increase the reaction rate, reducing the workability time.

MIXING

Mix the two components in the proportions indicated until an homogeneous mixture is obtained. Make sure that the material on the sides and bottom of the container is well mixed. The greater the quantity of material, the shorter the workability time. The higher the temperature of the environment and

components, the shorter the workability time. Components are packaged in non-ribbed metal drums for use with machines with pressing plate.

CURING

Wait at least 16 hours for curing. The product can generally be processed within the times indicated above. The hardening time depends on the mass: thinner thicknesses require longer curing times. High product and environmental temperatures lead to reductions in workability and hardening times. Conversely, low temperatures mean longer times. A post-curing treatment in a medium temperature oven is recommended to stabilize the polymer at high temperatures and/or accelerate the crosslinking process.

HANDLING PRECAUTIONS

The information for a correct and safe handling of the products is contained in the safety data sheet. Consult the safety data sheets before use for complete information on the risks to health and the environment and for the suitable protective devices to be adopted. Share the safety data sheets with all staff involved in the use of the products.

USABLE LIFE - STORAGE

Resin and hardener must be stored in the original unopened containers at a temperature between +10°C and +35°C. Epoxy resins can crystallize at low temperatures: heat to 40-50°C for 8-12 hours to restore the product. Bring the components to 20-25°C before use. Be sure to close containers tightly after use. When stored under the specified conditions, the components have a shelf

life of 12 months from the date of manufacture.

PACKAGING

The components are supplied in 56kgs (Resin) and 25kgs (hardener) cans. For other packaging please contact our sales department.

LIMITATIONS

This product is neither tested nor represented as suitable for food contact, skin contact or medical uses.

LIMITED WARRANTY

The information contained in this document is offered in good faith based on Chemix research and is believed to be accurate. However, as the conditions and methods of use of our products are beyond our control, this information should not be used as a substitute for the tests that customers must first perform to ensure that Chemix products are fully satisfactory for their specific applications. The warranty is only applicable to the values indicated in the Product Sales Specifications. The sole and exclusive compensation for products with values that are out of specification is limited to the replacement of the product or the refund of the purchase price.

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www.chemix.it

Chemix Srl Via Berlinguer 8, 21010 Golasecca (Italy). Phone +39(0)331959373 info@chemix.it