



Kisling AG

**Motorenstrasse 102
CH-8620 Wetzikon**

Telefon +41 (0)58 272 01 01
Telefax +41 (0)58 272 01 03

info@kisling.com
www.kisling.com

TECHNICAL DATA SHEET

ergo.[®] 1315 (ergo.[®] 1313 resin + ergo.[®] 1314 hardener)

Product - Description

This **low odor ergo.[®] - grade** was developed to bond metals like aluminum, steel, brass and its alloys as well as ferrite, a wide range of plastics and combinations of those materials. It is a two-component system and cures after mixing into a dry, high-strength and impact resisting polymer film. The best mixture-ratio is 1:1 (volume) and is obtainable without problems by using the common double-cartridges.

Advantages

- Very fast curing system
- High tensile shear strength
- Resists against impacts as well as again peeling
- Good gap-filling behavior up to 0,10mm
- Free of solvents
- Short fixture times
- Passes test acc. to UL-94 HB at layer thickness of 3 mm

Physical Properties (liquid product)

Chemical base	:	modified acrylic
Viscosity	:	
Cone/plate-system, cone C-25, D=35s ⁻¹	:	5500 – 7500 mPas
Density	:	1,03 – 1,10 g/cm ³
Colour resin (ergo. [®] 1313)	:	between white and beige
hardener (ergo. [®] 1314)	:	between dark green and blue
Shelf life	:	6 month at ≤ 25°C

Cured product after 24 hours @ 23°C:

Tensile strength (DIN 53504 S2)	:	~ 21 N/mm ²
Elongation at break (DIN 53504 S2)	:	~ 20 %

./2



Kisling AG

**Motorenstrasse 102
CH-8620 Wetzikon**

Telefon +41 (0)58 272 01 01
Telefax +41 (0)58 272 01 03

info@kisling.com
www.kisling.com

- 2 -

tensile shear strength acc. to DIN EN 1465, parts only degreased

aluminum	:	> 20 N/mm ²
steel	:	> 22 N/mm ²
at 100°C	:	~ 7 N/mm ²
brass	:	> 17 N/mm ²
ABS	:	> 6 N/mm ² (stripe failed)
PS	:	> 2,5 N/mm ² (stripe failed)
Shore D – hardness	:	72
Thermal range	:	- 40°C up to + 150°C
Resistance against solvents	:	good

Curing

Curing system	:	2-component-system ratio 1:1 (volume)
Potlife	:	1 - 2 minutes (2g-mixture)
Initial strength (3 N/mm ²)	:	5 - 6 minutes at 23°C
Final strength	:	~ 12 hours at 23°C

How to use the product

Resin ergo® 1313 and **hardener ergo® 1314** is normally applied by using the double-cartridge-system with static mixture tube. ATTENTION: Potlife in the tube will be, depending on room-temperature, between 1 - 2 minutes. Apply the mixed glue on one part and spread it carefully over the whole bonding area. Fit the parts together and fix them at least as long as the potlife time, better 6 minutes. The product may be used also in bead on bead manner.

In this case, cure speed and final strength will be on a slightly lower level and has to be checked by the customer in his real application.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that KISLING products are safe, effective, and fully satisfactory for the intended end use. KISLING sole warranty is that the product will meet the KISLING sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. KISLING specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless KISLING provides you with a specific, duly signed endorsement of fitness for use, KISLING disclaims liability for any incidental or consequential damages. Suggestions of uses should not be taken as inducements to infringe any particular patent.