



## TECHNICAL DATA SHEET

### **ergo® 1915** (ergo® 1913 resin + ergo® 1914 hardener)

#### **Product - Description**

This **ergo® - grade** is suitable for bonding of metals like aluminum, steel, brass and its alloys as well as ferrite and 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**

- Fast curing system
- High tensile shear strength
- Resists against impacts as well as again peeling
- Good gap-filling behavior up to 0,15 mm
- Free of solvents
- Short fixture times
- Dry surface after short time

#### **Physical Properties (liquid product)**

<b>Chemical base</b>	:	modified acrylic
<b>Viscosity</b>	:	
Brookfield RVT, Sp.6, 25°C, 20 rpm	:	14000 – 17000 mPas (thixotropic)
<b>Density</b> resin (ergo® 1913)	:	1,04 g/cm <sup>3</sup>
hardener (ergo® 1914)	:	1,05 g/cm <sup>3</sup>
<b>Colour</b> resin (ergo® 1913)	:	white
hardener (ergo® 1914)	:	green
<b>Shelf life</b>	:	6 month between 2°C – 7°C

#### **Cured product:**

<b>Tear Strength @ break</b> (DIN 53504 S2)	:	~ 36 N/mm <sup>2</sup>
<b>Elongation @ break</b> (DIN 53504 S2)	:	~ 8 %
<b>Glass transition</b> (DSC, DIN 65467)	:	~ 119 °C

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

##### **aluminum/ aluminum**

after 24 h at 23°C : > 20 N/mm<sup>2</sup>

##### **steel/ steel**

after 24 h at 23°C : > 22 N/mm<sup>2</sup>



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**brass/ brass**

after 24 h at 23°C

: > 20 N/mm<sup>2</sup>**ABS/ ABS**

after 24 h at 23°C

: > 6 N/mm<sup>2</sup> (stripe failed)**PVC, hard/ PVC, hard**

after 24 h at 23°C

: > 3 N/mm<sup>2</sup> (stripe failed)**GFR polyester/ GFR polyester**

after 24 h at 23°C

: > 6 N/mm<sup>2</sup>**GFR epoxy/ GFR epoxy**

after 24 h at 23°C

: > 6 N/mm<sup>2</sup>**Impact resistance**: > 18 kJ/m<sup>2</sup> (steel, sand blasted)**T-Peeling**

: &gt; 20 N/cm (steel, sand blasted)

**Thermal range**

: - 50° C up to + 150° C

**Resistance against solvents  
and fuel/petrol (diesel)**

: good

**Curing****Curing system**: 2-component-system  
ratio 1:1 (volume)**Potlife**

: ~ 2,5 minutes (2g-mixture)

**Initial strength**

: ~ 10 minutes at 23°C

**Final strength**

: ~ 12 hours at 23°C

**How to use the product**

**Resin ergo® 1913** and **hardener ergo® 1914** is normally applied by using the double-cartridge-system with static mixture tube. ATTENTION: Potlife in the tube will be, depending on room-temperature, ~ 2,5 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 is, but better 10 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**

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