BONDING +
SEALING +
ENCAPSULATION

Kisling

TECHNICAL DATASHEET

1925
(Resin 1923 + Hardener1924)

Description
This very low odour structural adhesive was developed to bond metals like aluminium, 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 easily by using the common dual-cartridges. Due to its insensitiveness to changing mixture ratios, it may be applied also as bead beside bead and mixed by hand or when parts are joined.

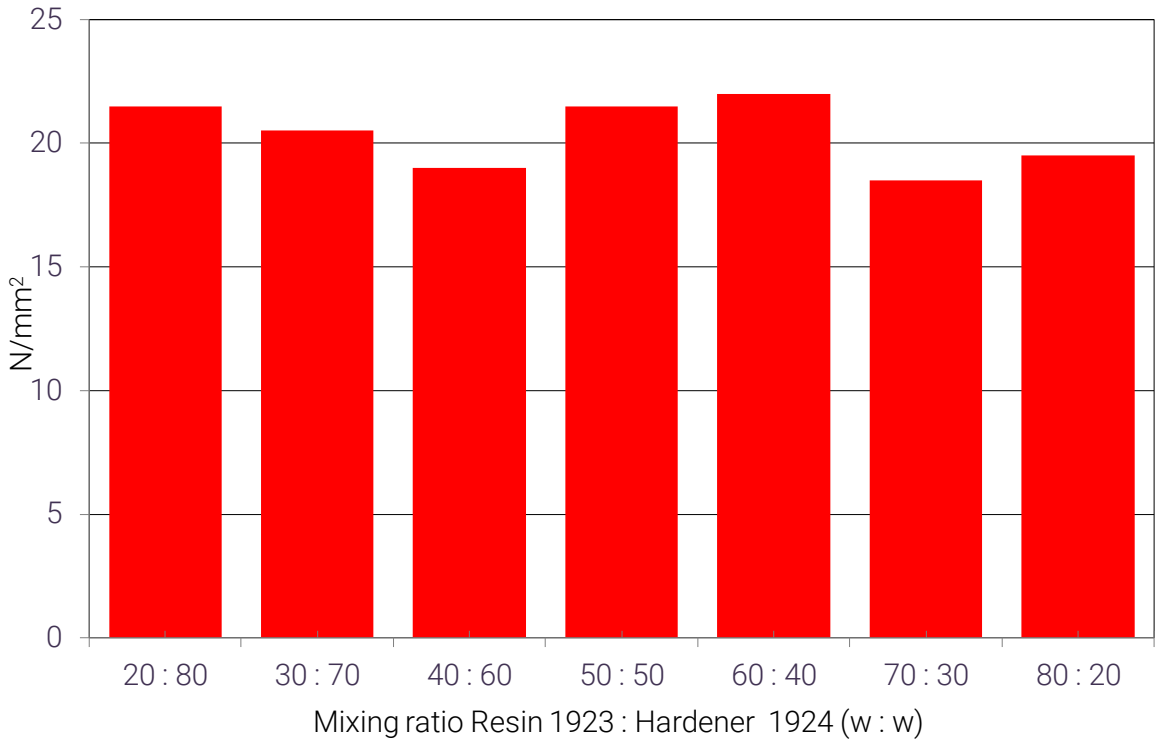
Advantages
- Long open time allows adjustment of joined parts, even if big areas are involved
- Fast curing means short fixture times and reliable, complete curing
- Excellent adhesion
- High tensile shear strength
- Resists against impacts as well as against peeling
- Resists again paint baking (stove enamel process)
- Compatible with spot welding procedure
- Contains 100µm spacer to optimize gap and mechanical properties
- Wide range of mixing ratio
- Relative low shrinkage
- Very low odour
- Free of solvents
- Non-flammable

Physical properties (liquid product)

Chemical base	Modified, toughened acrylate
Curing System	2-component-system
Mixing ratio by volume	1 : 1 (Resin 1923 : Hardener 1924)

Mixing ratio

tensile shear strength depending on various mixture ratios tested acc. to EN 1465 on steel



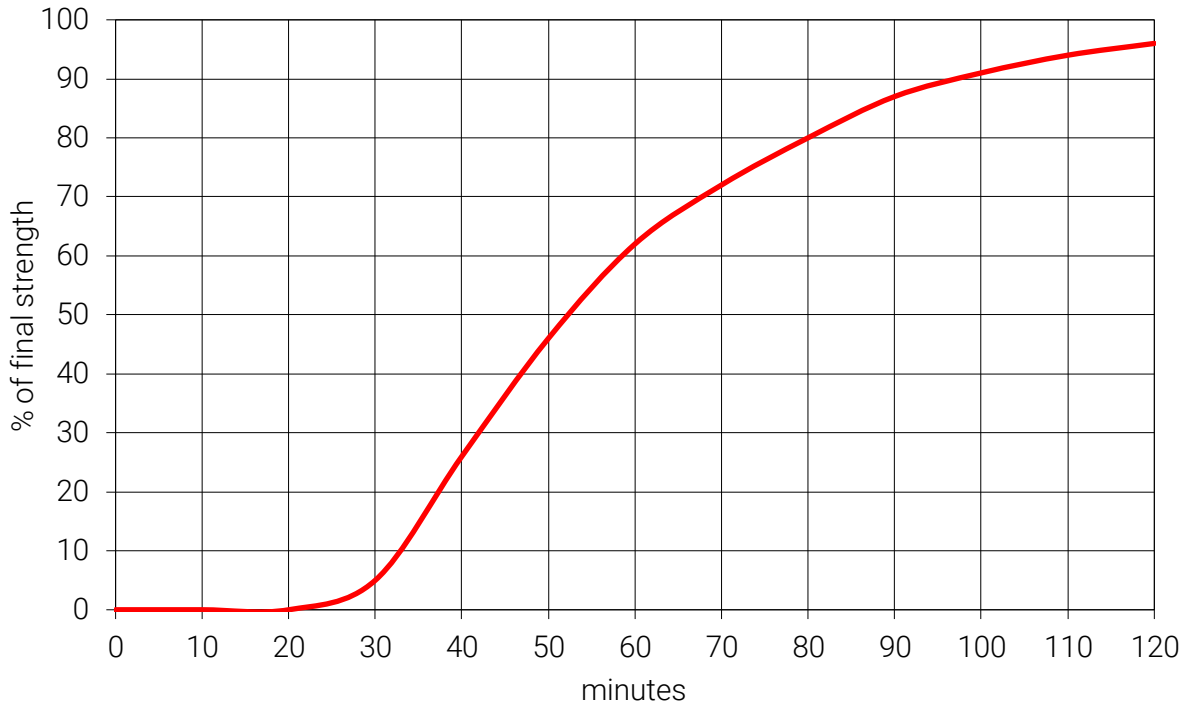
Colour	Resin 1923	Pale yellow
	Hardener 1924	Dark blue-green
	Mixture	Dark brown-grey
Viscosity	Resin 1923	~ 20'000 mPa•s
	Hardener 1924	~ 20'000 mPa•s
Density	Resin 1923	1.02 g/cm³
	Hardener 1924	1.03 g/cm³
Shelf life	50 ml cartridges	12 months at ≤ 25°C
Flash point		~ 101 °C

Curing properties

Pot life at 23°C; ~2g	~ 20 minutes
Fixture time at 23°C (>1 N/mm^2)	~ 25 minutes
Final strength at 23°C	~ 4 hours
Shrinkage after curing	< 8%

Curing speed

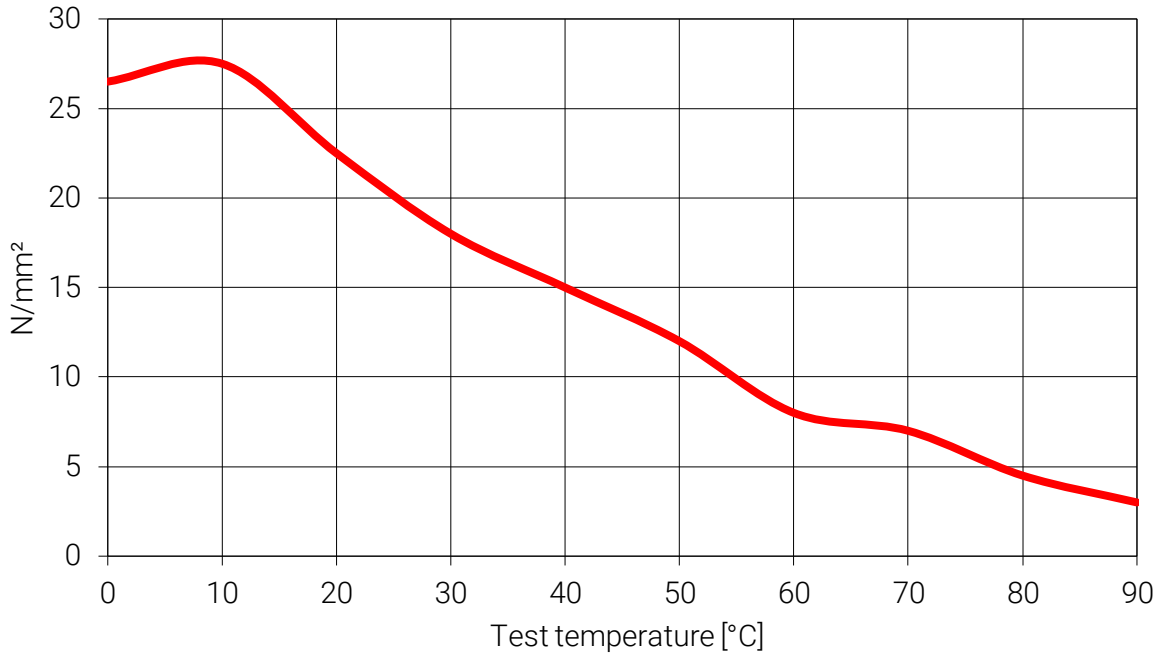
Tensile shear strength on steel acc. to EN 1465



Physical properties (cured product)

Thermal range	- 40 °C up to 110 °C

Tensile shear strength at mentioned temperatures
after 24 hours at mentioned test temperature (EN 1465)



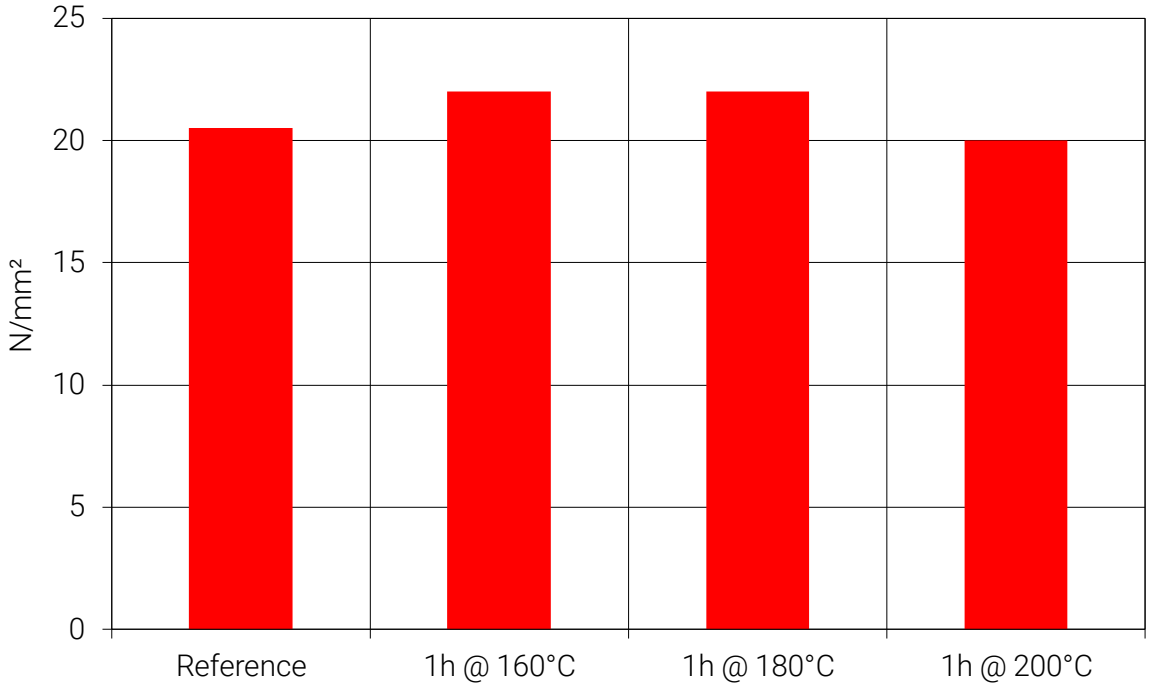
Tensile strength (ISO 527/1A/10) after 24 hours at 23°C	~ 15 N/mm²
Elongation at break (ISO 527/1A/10) after 24 hours at 23°C	~ 45 %
E-Modul DIN EN ISO 178 after 24 hours at 23°C	480 MPa
Impact resistance (steel, corundum blasted) steel, corundum blasted	> 16 kJ/m²
Peel strength – floating roller (ISO 4578) steel, corundum blasted	> 70 N/cm
Shore D hardness	~ 60

Tensile shear strength acc. to DIN EN 1465
12 hours at 23 °C; test temperature: 23 °C; metals corundum blasted / plastics cleaned

Stainless steel	> 23 N/mm²
Steel	> 20 N/mm²
Galvanized steel	> 20 N/mm²
Aluminium	> 19 N/mm²

Resistance against short time heating

Tensile shear strength tested at room temperature (EN 1465)



Precautions

For your own safety, please refer to the information of the concerned MSDS and for the correct handling the "user instructions".

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