

TECHNICAL DATA SHEET

POWER BOND 2K Epoxy panel bonder

Product Description

A toughened two-part epoxy structural adhesive that seals and bonds outer body panels to reduce welding and riveting time. Provides a long work time for easier adjusting and handling. Contains glass beads to provide adequate spacing between parts for optimal bond strength. Excellent corrosion resistance and spot-weldable while uncured. Meets OEM recommendations.

Areas of Application

Designed to bond steel, aluminum, SMC, and fiber reinforced parts and panels. Use to bond roof, door, quarter panels, and other outer body sheet material.

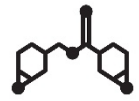
 Replaceable panels



Directions

Power Bond comes supplied in a 2:1 ratio dual cartridge that can be used with handheld manual or pneumatic applicator tools that fit 220 mL dual cartridges. To ensure accurate dispensing, load an open cartridge into the dispenser and purge until material starts to flow from both chambers. Attach mixer nozzle and discard the first 2.5-5 cm (1-2 inches); adhesive should have a uniform black colour. A 24-element mixing nozzle or greater must be used to ensure proper performance.

Store partially used product with the mixing nozzle attached. Use a new mixing nozzle when reused. Always use a mixing nozzle; do not mix by hand.



EPOXY

Work time

60
MIN

Temps de travail

Clamp time

4
HR

Temps de serrage

Cure time

24
HR

Temps de durcissement

Description	Contents	Art. No.
Power Bond	225 mL	893.950100

Key Features

High-strength epoxy resin adhesive

- High impact energy absorption
- Fewer spot welds
- Meets OEM specifications

Glass particle technology

- Even if too much pressure is exerted, an adhesive layer thickness of 0.25 mm is guaranteed

Excellent stability

- The adhesive will not run on vertical surfaces (thixotropic)

Excellent corrosion protection

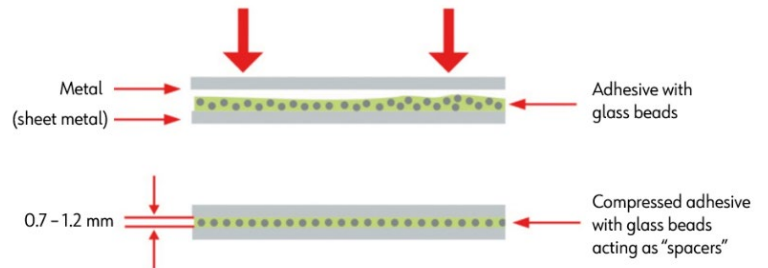
- The original degree of rust resistance is maintained
- Corrosion is prevented from occurring at spot welds

Weldable (in uncured state)

Can be sanded and painted over

Technical Details

Format	Dual Cartridge, 2:1 Ratio
Chemical Basis	2K Epoxy with glass beads
Colour	Black
Working Time @ 23°C	60 min
Clamp Time @ 23°C	4 hr
Cure Time @ 23°C	24 hr
Application Temperature	15 to 25°C
Temperature Resistance	-30 to 120°C
Max Short Term Temperature	190°C
Shore D Hardness EN ISO 868 @23°C	80
Tensile Strength DIN ISO 53504 @23°C	33.3 MPa
Youngs Modulus DIN ISO 53504 @23°C	325 MPa
Elongation at Break DIN ISO 53504 @23°C	19%
Glass Transition Temperature ASTM E-1640 @23°C	65°C
Energy to Break EN ISO 178	~ 0.600 N.m
T-Peel EN ISO 11339-2010	6.95 MPa
Shelf Life	24 months
Nozzle Compatibility	24 element



Strength Test

Substrate	Pre-Treatment			Testing		
	Cleaning	Sanding	Cleaning	Bond Line Thickness	Expected Failure Mode	Average Strength
Aluminum 6016	Acetone	P80	Acetone	0.25 mm	Cohesive	17.4 MPa
Aluminum 6082	Acetone	P80	Acetone	0.25 mm	Cohesive	24.9 MPa
Cold Rolled Steel DC04	Acetone	P80	Acetone	0.25 mm	Cohesive	24.0 MPa
Carbon	IPA	P120	IPA	0.25 mm	Substrate	18.6 MPa

Notice

Structural components should be welded. Allow 24 hr before returning vehicle to service. Cure time varies with temperature and humidity. The listed values are based on a temperature of 23°C and 50% relative humidity

Disclosure Information

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