ADHESIVES
ENGINEERING DATA

techniglue R15
TOUGHENED EPOXY ADHESIVE

TECHNIGLUE R15 is a soft, thixotropic, solvent-free, epoxy paste, specifically formulated for use with H15 hardener to cure at room temperature to produce a high strength structural adhesive for bonding of metals, particularly aluminium and steel.

R15 has been formulated to overcome the problem of peeling failure at the metal-resin interface, by increasing the peel strength of the bond, with negligible reduction in other adhesive properties.

TECHNIGLUE R15 offers high chemical resistance, high compressive & tensile strengths, and also has excellent adhesion to all normal substrates.

MIX RATIO
1 part hardener to 1 part resin by weight or volume.
Take care to ensure that the components are thoroughly mixed to a uniform colour before applying.

Note: *Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.*

MIX RATIO
The following data was obtained after curing for 2 weeks at ambient temperature.

CURED PROPERTIES - TENSILE LAP SHEAR ASTM D1002

Sample	Surface Preperation	Strength (psi)	Strength (MPa)
Aluminium (2024-T3 aluminium alloy 0.063 inches thick)	Degrease Degrease & abrade (120 grit)	3335 3770	23 26
Mild Steel	Degrease Degrease & abrade (120 grit)	3553 4061	24.5 28
Composite (epoxy/E-glass ASTM D3165)	Peel ply removal	2320*	16*

* Failure occurred within the substrate for all test specimens; the adhesive bond remained intact.

APPLICATION
All surfaces should be clean and free from grease and/or loose particles. For best results and high strength bonds to occur, the adhesive must be capable of wetting both surfaces, this is best achieved by a uniformly, finely roughened (matt) finish.

HEALTH AND SAFETY
TECHNIGLUE R5 resin and H5 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

Resins - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.
Hardeners - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE: Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages.