

## IX 28216

### Two component toughened structure adhesive system

#### Key properties

- Bonding thermoplastic and thermosetting plastic, high shear strength and peel strength
- Chemical resistance, excellent resistance to dilute acid and oil
- After cured with excellent toughness and elongation at break
- Fast cured at the room temperature
- Can also be tightly bonding a variety of metal
- Italian production, Conform to EUR Standards

#### Description

IX 28216 is a modified adhesive from Italy, Used in hard plastic and metal structure adhesive, conform to EUR standards. Excellent resistance to heat and cold cycle performance, chemical resistance, excellent resistance to dilute acid and oil. It is mainly used for bonding hard plastic. Using professional design of gun type packaging, avoided completely, use in the process of blending ratio error, uneven mixing, wasteful big problems.

It can also be bonding the metal and compound material, and can satisfy the using demand of the most complex environment.

#### Product data

	28216A	28216B	28216AB mixed
Colour (visual)	Beige	Red	Dark red
Specific gravity	1.00	1.10	1.06
Viscosity at 25°C (Pas)	90	60	90
Pot Life (100 gm at 25°C)	-	-	5 minutes

#### Processing

##### Pretreatment

The strength and durability of a bonded joint are dependant on proper treatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Low grade alcohol, gasoline (petrol) or paint thinners should never be used. The strongest and most durable joints are obtained by either mechanically abrading or chemically etching pickling the degreased surfaces. Abrading should be followed by a second degreasing treatment

Mix ratio	Parts by weight	Parts by volume
28216A	100	100
28216B	11	10

IX 28216 must be in the cartridge and fully in accordance with the corresponding proportion mixing can achieve the best bonding effect.

##### Application of adhesive

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces. A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied. Too thick rubber can not bring greater bonding strength.

##### Equipment maintenance

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation. If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact. Used the packing box can't be used again.

##### Time to minimum shear strength

Temperature	°C	10	15	25	40	60	100
Cure time to reach LSS >1 MPa	hours	-	-	-	-	-	-
	minutes	25	20	8	1	-	-
Cure time to reach LSS >10 MPa	hours	-	-	-	-	-	-
	minutes	40	30	20	15	10	-

LSS =Lap shear strength

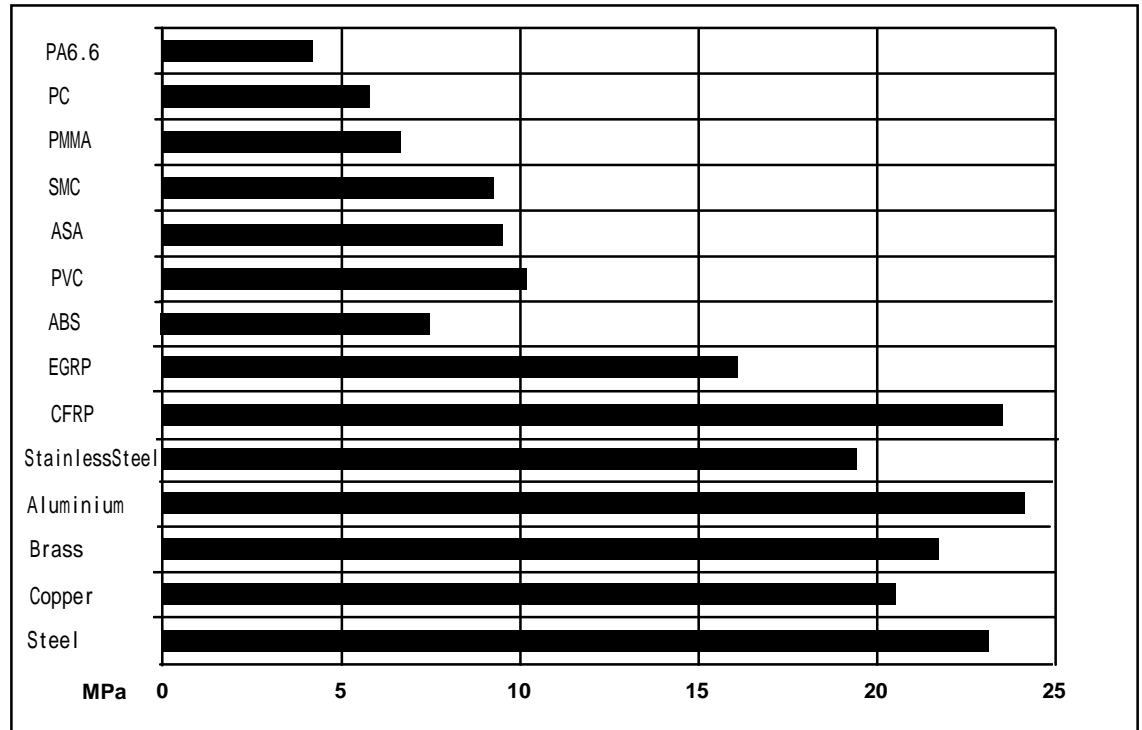
## Typical cured properties

### Sample standard

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case. The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

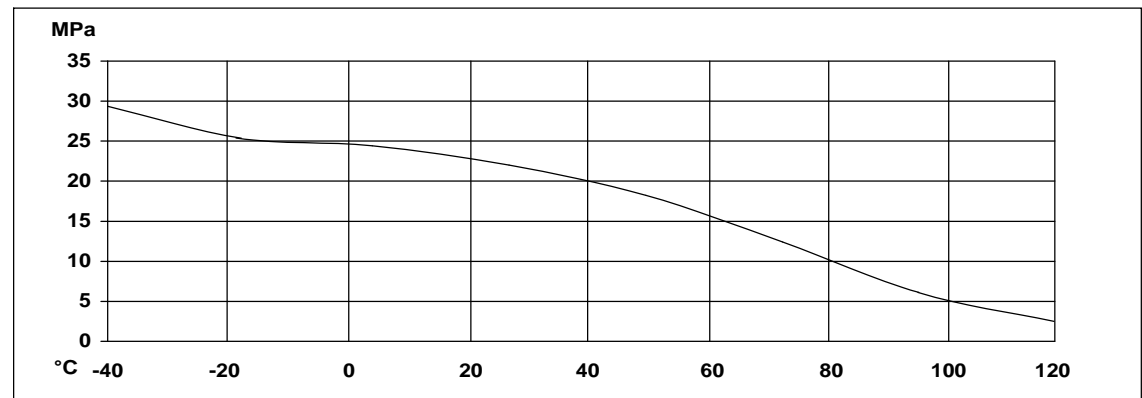
### Average lap shear strengths of typical (ISO 4587)

Cure: 72 hour/25°C, tested at 25°C. Metals: Sand blasting, Non-metallic: Lightly abrade.



### Lap shear strength versus temperature (ISO 4587) (typical average values)

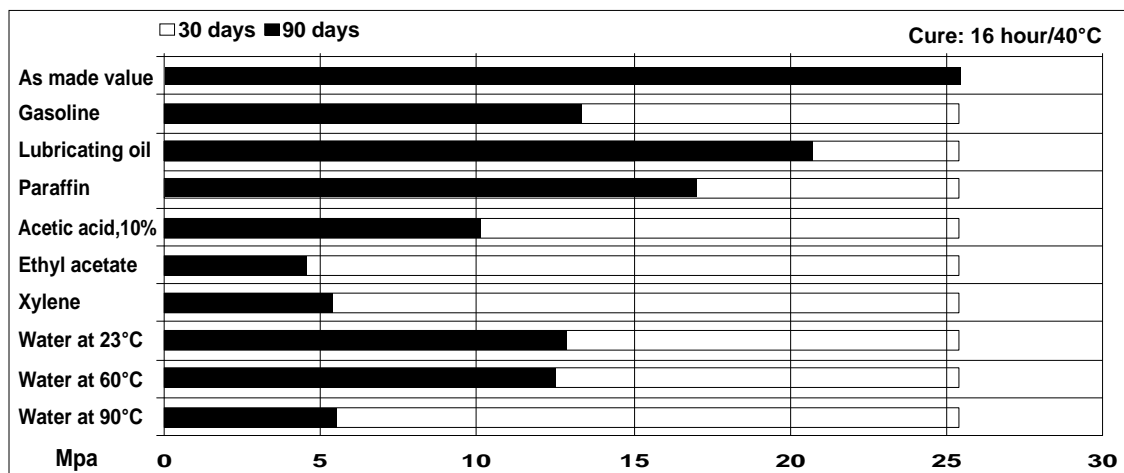
Cure: 72 hour/25°C, tested at 25°C, Sand blasting steel-Sand blasting steel



### Other typical characteristics Cure: 72 hour/25°C, tested at 25°C, Sand blasting steel-Sand blasting steel

Tensile strength	ISO527	13Mpa
Shore hardness	ISO868	48D
Elongation at break	ISO527	91%
Roller peel test	ISO4587	5.4N/mm
Glass transition temperature	ISO6721	67 °C

Lap shear strength versus immersion in various media at 23 °C (typical average values)



**Storage**

IX 28216 may be stored for up to 18 months at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label.

**Handling precautions**

**Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper -not cloth towels -should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data Sheets for the individual products and should be referred to for fuller information.

All recommendations for the use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefor. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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