

Technical Datasheet

Structalit® 1028 R



Product Description

Panacol Structalit® adhesives are solvent free single or two-component adhesives. They are mostly based on epoxy resin and can be cured at room temperature or by exposure of heat. Structalit® products are designed for bonding, casting and protecting components in electronic and automotive industry.

Structalit® 1028 R is a universal applicable two-component non-filled epoxy adhesive, which can be used as an adhesive or in grouting applications. Structalit® 1028 R cures at room temperature.

Due to the strong exotherm reaction behavior, no larger quantities (> 5.0 g) should be used at once. For large quantities, curing temperatures of more than 120 ° C can be achieved quickly.

Curing Properties

This product is a two-component adhesive. The adhesive can be cured at room temperature or thermally under exposure to heat after mixing the two components in the ratio indicated. Possible curing temperatures are listed in the table below.

Thermal curing	[min]
Time at room temperature	24 h

The adhesive can be applied after mixing the components within the pot life. To determine the pot life, the time it takes to double the increase in viscosity after mixing of the two components is used.

Curing	
Pot life	3 min
Mixing ratio	1:1
Initial strength	10 - 15 min
Final strength	48 h

The curing times given are guidelines. They refer to the curing of 2 g of adhesive. The heating up of the joining members are not taken into account.

The final strength of the adhesive is reached at the earliest after 24 h.

Technical Data

Resin

epoxy

Appearance

transluzent

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Uncured material

Viscosity [mPas]	16 000 - 24 000
Density [g/cm ³] <i>PE-Norm 004</i>	1,15
Flash point [°C] <i>PE-Norm 050</i>	>100

Cured material

Hardness shore D <i>PE-Norm 006</i>	72 - 76
Temperature resistance [°C]	-20 - 85
Shrinkage [%] <i>PE-Norm 031</i>	<1
Water absorption [mass %] <i>PE-Norm 016</i>	<1

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	30 - 35
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Young's modulus E [MPa] <i>PE-Norm 056</i>	2 762
Tensile strength [MPa] <i>PE-Norm 014</i>	42
Elongation at break [%] <i>PE-Norm 014</i>	3
Lap shear strength (FR4/FR4) [MPa] <i>PE-Norm 013</i>	3
Lap shear strength (steel/steel) [MPa] <i>PE-Norm 013</i>	5
Lap shear strength (Al/Al) [MPa] <i>PE-Norm 013</i>	3
Lap shear strength (PC/PC) [MPa] <i>PE-Norm 013</i>	1
Lap shear strength (PA/PA) [MPa] <i>PE-Norm 013</i>	1
Lap shear strength (brass/brass) [MPa] <i>PE-Norm 013</i>	3

Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	at room temperature max. 25°C	at room temperature max. 25°C	at delivery min. 6 months max. 12 months

***Store in original, unopened containers!**

Instructions for Use

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

For safety information refer to our safety data sheet.

Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

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