

SWC®

SWC-HE616 two-part epoxy resin adhesive



DESCRIPTION

SWC-HE616 (Loctite EA616) is a two-part, 100% solids, non-shrinking epoxy resin adhesive that gives strong bonds with excellent chemical and weather resistance. It has been formulated for use as heavy duty flooring adhesives including bonding of rubber tiles, protective mattress and metal support for raised flooring system to concrete surface. The adhesive has a high degree of flexibility and will with-stand impact and temperature variations.



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HE616

EPOXY RESIN ADHESIVE

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SPECIFIC PROPERTIES

Consistency	flowable thixotropic liquid
Colour Part A	white
Part B	black
Mixed	grey
Pot life	1-2 hours depending on ambient temperature and quantity of mixture
Set time 4-8 hours	
Cure time	24 hours
Density	1.3
Mixing ratio	1:1 by volume

APPLICATION AND HANDLING

Surface preparation:

Surfaces should be clean, dry and free of oil and greases. Metals should be abraded with emery paper. For more detailed information, consult Building Products Division Technical Bulletin "Surface Preparation for Epoxy Resin Compounds".

Mixing:

Combine equal volumes of component A (base) and component B (hardener). Mix quickly but thoroughly. Do not mix more than can be used immediately.

Application:

Using a flexible knife or small trowel, apply mixed adhesive thinly to one surface. Bond immediately, applying sufficient pressure to ensure complete contact between the surfaces. Although clamp pressure is not necessary, the bond should receive some support while curing.

Curing:

After approximately 12 hours, the adhesive will have gained 75% of its strength and the bond can be handled and moved, provided no undue stress is imposed. Curing will be retarded in cold conditions and accelerated by heat.

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