

# NAE-1600

EPOXY-BASED STRUCTURAL ADHESIVE

- ✓ Two components
- ✓ High tensile strength
- ✓ Fast curing at room temperature
- ✓ Mixing ratio 2/1

## Technical Info

- Chemistry: epoxy.
- Appearance (WL-M020): white paste.
- Viscosity part A (WL-M002 - 23°C, 10s-1): 108 Pa.s.
- Viscosity part B (WL-M002 - 23°C, 10s-1): 80 Pa.s.
- Viscosity mixture A+B (WL-M002 - 23°C, 10s-1): 95 Pa.s.
- Hardness (WL-M001): 68 shore D.
- Curing (WL-M018 - KT): 7 minutes.
- Shear strength (after 7 days at room temperature);
- WL-M013 steel: 160 kg/cm<sup>2</sup>.
- WL-M013 PA6.6: 10 kg/cm<sup>2</sup>.
- Temperature resistance (WL-M013): from -50 to +125°C.

Be careful when mixing quantities exceeding 50 g, as an exothermic reaction will occur. Store material dry for maximum 12 months in original container between 5 and 25°C not exposed to humid and sunny conditions. Consult the safety data sheet before using the product.

## Packing

NAE-1600 - cartridge 150ml	532040000
NAE-1600 - 50ml	532041000

## Product [NAE-1600]

### Characteristics

NAE-1600 is a two-component epoxy adhesive for structural bonding applications where high tensile strength is required. NAE-1600 offers high tensile strength, curing at room temperature and a convenient 2/1 mixing ratio.

NAE-1600 bonds various materials such as metals and engineering plastics. The curing at room temperature eliminates the need for an oven or other curing equipment.

### Applications

Industrial and structural assembly where high tensile strength and long-term performance are important requirements. NAE-1600 provides strong and reliable bonding between most commonly used metals and engineering plastics.

## Use

- Apply to clean substrate. Clean if necessary using Safety Clean (chemical contamination) and/or Multifoam (natural contamination).
- Difficult to bond plastics may benefit from plasma treatment to improve adhesion to plastics and aluminium.

- Respect a minimum adhesive thickness of 0.1 mm and a maximum of 1 mm.
- After bonding, ensure that the assembly is left in place for at least 1 hour.
- Maximum strength is obtained after 7 days.