

# NAE-1500

EPOXY-BASED STRUCTURAL ADHESIVE

- ✓ Two components
- ✓ High tensile strength
- ✓ Curing at room temperature
- ✓ Long working time
- ✓ Mixing ratio 1/1

## Technical Info

Chemistry: epoxy.

- Appearance (WL-M020): white paste.
- Viscosity part A (WL-M002 - 23°C, 10s-1): 100 Pa.s
- Viscosity part B (WL-M002 - 23°C, 10s-1): 30 Pa.s
- Viscosity mixture A+B (WL-M002 - 23°C, 10s-1): 75 Pa.s
- Hardness (WL-M001): 75 shore D.
- Curing (WL-M018 - RT): 4 h.
- Curing (WL-M018 - 80°C): 10 min.
- Curing (WL-M018 - 120°C): 3 min.
- Shear strength (after 7 days at room temperature):
  - WL-M013 steel: 170 kg/cm<sup>2</sup>.
  - WL-M013 PA6.6: 30 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-1500 - cartridge 280ml	532020000
NAE-1500 - cartridge 2x200ml	532021000
NAE-1500 - 50ml	532022000

## Product [NAE-1500]

### Characteristics

NAE-1500 is a two-component epoxy adhesive for structural bonding applications where high tensile strength is required. NAE-1500 offers high tensile strength, curing at room temperature and a convenient 1/1 mixing ratio, and its long working time makes application and assembly easier. NAE-1500 bonds various materials such as metals and engineering plastics, and its room-temperature curing 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-1500 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 remains in place for at least 24 hours.
- Maximum strength is obtained after 7 days.
- Curing can be significantly accelerated by increasing the curing temperature.