8. ADHESIVES **ELFIX/** Epoxy adhesives/ **ELFIX 410**

Aplication:

ELFIX 410 is suitable as adhesive for metals, glass, porcelain, various kinds of thermosetting materials, wood and others. It can be used for trickling, sealing, insulating etc. After uring ELFIX 410 can be treated respectively covered with coat.

Charakteristics:

Two-component ELFIX 410 insulating paste is based on modified epoxy resin. It is cured at ambient as well as at elevated temperature. Its adhesion to other materials e.g. to metals, glass, wood, úorcelain, concrete and various kinds of thermosetting materials is very good. Its chemical resistance is good too and its curing shrinkage is small. Its adhesion to elastomeric materials, fat and dirty surfaces is poor. Electrical and mechanical properties of ELFIX 410 are good.

Processing:

Two (2) weight parts of yellow component and one (1) weight part of grey component are properly mixed together. This must be done very carefully to avoid the mixing of air bubbles. Pot life of mixture depends on mixture quantity and processing temperature.

Approximative data are as follows:

Quantity [g]	Temperature [°C]	Time [min.]
	10 - 15	100 - 130
10 - 50	20 - 30	60 - 70
	50 - 60	10 - 20
	10 - 15	60 - 80
50 - 500	20 - 30	20 - 30
	50 - 60	10 - 15

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8. ADHESIVES **ELFIX/** Epoxy adhesives/ **ELFIX 410**

Curing:

Curing time depends on mixture quantity and curing temperature. Curing time for larger quantity is shorter.

Curing time at 20 - 30 °C, [h]	5
Post curing time to reach optimal properties	
at 20 - 30 °C, [h]	24 - 36
at 100 °C, [h]	1 – 2

Properties of component:

Viscosity 20 °C, [mPa.s]	
grey component	7.103
yellow component	2.104
30 min. after mixing	3.104
Density 20 °C, [g/cm3]	
grey component	1,555
yellow component	0,98
Storage life of separate components in original packing:	1 year

Properties of component:

Measured on test specimens cured for 48 hours at 25 °C	
Tension strength, [MPa]	36
Flexural strength, [MPa]	58,2
Impact strength Charpy, [N.mm/mm2]	7,0
Dissipation factor at 50 Hz/23 °C/50 % r.h. [%]	3,5
Permittivity 50 Hz/23 °C/50 % r.h.	4,44
Volume resistivity, [Ω .m]	10.1012
Electric strength, [kV/mm]	15