



# EVO-STIK Epoxy Rapid Metal Tubes

## A TWO PART, MULTIPURPOSE EPOXY RESIN ADHESIVE

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Fact Sheet No.: TDS01662

### YOUR SMART ADVANTAGES

- Specially formulated to form a super strong bond that sets in minutes
- Can be roughly handled/machined in 10 minutes
- Can be drilled, filed and painted

### USES

EVO-STIK Epoxy Rapid Metal Tubes is a solvent free, low odour, two-part rapid curing epoxy adhesive specially formulated to bond most metals. EVO-STIK Epoxy Rapid Metal Tubes will bond a wide range of other materials as well as metals. It is particularly suited for common metals such as steel, aluminium, iron and copper.

### PRODUCT CHARACTERISTICS

Colour	Resin: Metallic black Hardener: White
Form	Liquid
Specific Gravity	1.2 approx.
Composition	Resin: Epoxy Resin Hardener: Amine Hardener
Product Code	30813389 1 x 6 15ml metal tubes in blisters
Storage/Shelf Life	Store for up to 36 months when stored in original, unopened packaging under cool, dry conditions within the temperature range of +5°C to +25°C.

### TYPICAL PERFORMANCE DATA (Approx.)

Flammability	Non-flammable
Setting Time	About 6 to 7 minutes at 23°C
Service Temperature	-40°C to +70°C
Sandability	Sandable. Please wear dust mask
Paintability	Good, but confirm by test. Fine sanding helps. Please wear a dust mask.

### DIRECTIONS FOR USE

**IMPORTANT:** Before using EVO-STIK Epoxy Rapid Metal Tubes refer to the relevant Health & Safety Data Sheet, available at [www.bostik.co.uk](http://www.bostik.co.uk).

### PREPARATION

1. Make sure surfaces are dry, clean and free from dust, dirt and grease. For even better bonding slightly roughen surfaces with a suitable abrasive paper.
2. Following the instructions on the back of the blister card, dispense equal volumes of resin and hardener onto a clean disposable surface or the tray provided. Wearing gloves is recommended. Reseal the tubes of resin and hardener as directed on the blister card as soon as possible. Not mixing according to instructions will weaken the bond. Stir well ensuring a thorough mix. Use within 3 minutes.

### APPLICATION

3. Apply the mixed adhesive to both surfaces of the joint and assemble carefully (a layer of adhesive 0.10 to 0.20mm thick will normally impart the greatest lap shear strength to the joint).
4. Keep the joint supported until set (using clamps or tape etc.) for about 45 minutes. Allow 10 minutes before rough handling/machining. Under normal conditions EVO-STIK Epoxy Rapid Metal Tubes attains its full



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strength after 24 hours. Exact setting time depends on temperatures and the quantities mixed. Setting times may be shorter in hot weather. In cold conditions the rate of curing of the mixed adhesive may be slowed down significantly and weak joints may result. Best results are achieved between 20°C to 25°C. Do not use below 5°C.

5. For a perfect finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

#### CLEANING

6. Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners, acetone or methylated spirits, which is more readily available. Solvents must always be handled with due care as they may be hazardous or flammable.
7. Please note the solvents may attack some rubbers, plastics, painted surfaces, fabrics etc. Bear this in mind if intending to use solvent to remove excess adhesive and carry out a preliminary test first.
8. Cured adhesive residues can usually be dissolved from tools by soaking in commercial paint stripper. Refer to the paint stripper manufacturer's instructions for use and safe handling. Assess a small trial area before general work.
9. The adhesive may be removed from the skin using a suitable propriety hand cleaner. Contact with the skin should however be avoided. Do not use solvents in contact with the skin. Always open and use adhesive products over a protected surface, and avoid contact with clothing.

#### PRECAUTIONS IN USE

Do not use EVO-STIK Epoxy Rapid Metal Tubes to repair or make items that will contain food or drink. Not recommended for bonding polyolefin's (e.g. polythene or polypropylene). Thorough mixing is the key to getting a good cured product. Simply stirring leaves unmixed materials at the edges. Always fold in the edges and then re-stir. Cured adhesive may slightly yellow if exposed to sunlight for long periods, even through windows. Not suitable for bonding oven doors or car mirrors.

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit [www.bostik.co.uk](http://www.bostik.co.uk) for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK Epoxy Rapid Metal Tubes, available at [www.bostik.co.uk](http://www.bostik.co.uk).

BOSTIK HOTLINE

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