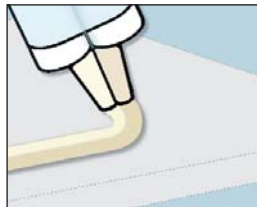


Product data

740

Fast Set epoxy liquid

Double barrelled syringe



General description

This clear, pure epoxy sets very rapidly and has excellent adhesion to metal, ceramic, porcelain, glass, brick, concrete, wood and most hard plastics.

AJett 740 is very easy to mix and can be used for a large number of applications from small scale repairs to filling screw holes. When fully cured, it can be smoothed and painted.

Benefits

- Rapid curing – around five minutes.
- Handling time of around 15 minutes – job soon done!
- Versatile – can be used on virtually any surface, whether vertical or horizontal.
- Self levelling..
- Excellent adhesion to a wide range of substrates.
- Optimum viscosity for flow and gap filling.
- Simple preparation – 1:1 mixing ratio.
- Static mixer extension to syringe ensures controlled, graduated mixing.
- Does not shrink.
- Cures to a hard surface.
- Non-rusting.
- Cures to a clear gloss finish.

Can be used on

- Metals.
- Ceramics.

- Porcelain.
- Concrete.
- Brick.
- Glass.
- Wood.
- Hard plastics, including acrylics.

Typical uses

- Bonding components.
- Rapid, small scale repairs to metal parts and castings, ceramic ornaments and metal or wood furniture.
- Filling small holes, cracks and worn areas.
- Fixing fittings to brick, wood or plaster.
- Fixing stone slabs and copings.
- Filling screw holes.
- Modelling.
- Repairing damage to laminates.

Application

- AJett 740 is supplied in a 50ml double barrelled syringe for use with a static mixer nozzle and an applicator gun, so ensuring complete mixing and accurate application. It is advisable to mix just enough for the job in hand. Apply either directly to the workpiece or with a spatula. Working time is 3 to 4 minutes at 20°C, depending upon the amount mixed – the greater the amount, the shorter the working time. Allow 15 minutes for initial cure and 24 hours for full cure at room temperature. See over for further details

Technical data

Composition	Pure epoxy resin
Physical appearance	Viscous liquid (uncured); solid (cured)
Colour	Pale straw yellow (uncured); clear (cured)
Odour	Barely perceptible (uncured); none (cured)
Mixing ratio	1:1 By weight and volume
Mixed viscosity	8.5 mPa.s
Working time at 20°C	3 to 4 minutes
Initial set at 20°C	5 to 8 minutes
Handling time at 20°C	10 to 15 minutes
Full cure	24 hours
Application temperature	5 to 35°C
Service temperature	-20 to +60°C In wet or damp conditions -20 to +120°C Dry heat
Lap shear, 0.1 mm bond line	10 N/mm² (1 hour, DIN 53283) 14 N/mm² (4 hours, DIN 53283) 20 N/mm² (24 hours, DIN 53283)
Compressive strength	25 N/mm² (ASTM D 695M)
Maximum bond line thickness	<2 mm
Cured Shore D hardness	65

All performance figures quoted after seven days cure at 20°C using grit blasted mild steel.

Packaging

50 ml double barrelled syringe dispenser.
Catalogue number **740/50**. Other sizes available to order.

Shelf life

Two years in normal storage conditions (dry, room temperature) and in closed original packaging.

Precautions for use

Irritant. Please refer to the **AJETT** material safety data sheet *MSDS 740*

Application method

AJETT 740 works best on clean parts – i.e dry and free of grease, oil and dust etc. Lightly abrading the substrate surface(s) prior to cleaning will improve performance. Remove the syringe cap and attach the mixer nozzle. Keep the cap in a safe place in order to reseal the syringe if only partly used. Place the cartridge in the applicator gun and extrude the first 1 to 2 ml to waste to ensure an even mix. Apply directly to the workpiece or use a spatula – normally to one surface, but if the substrate is absorbent or a thick bond line is required,

apply to both surfaces. Remove excess material before pressing or clamping the two surfaces together. Support the joint if necessary. Leave undisturbed until the handling time has elapsed. **AJETT 740** will start setting within a few minutes at 20°C, depending on volume – the greater the volume (or higher the temperature), the faster it will set. It can smoothed and painted after 24 hours.

NOTE: Data provided shows mean averages arrived after laboratory testing. Manufactured batches may vary slightly.

This publication is intended to serve as a guide only. Customers should satisfy themselves by appropriate trials that the product is suitable for its intended use.

The information is given in good faith and based on the state of our knowledge about the product – but cannot be used as a sales specification.

The attention of users should be brought to eventual hazards arising from the use of the product if they differ from what it was originally formulated for.

The customer will agree and accept our general sales and supply condition, in particular the cause of limitation and relief of responsibility.

Publication reference PS-740 – issue 3, April 2007