

**Technical Instruction Sheet**

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**Characteristics:** AKEPOX® 3000 Mini Quick is a jelly-like, solvent-free 2-component adhesive based on an epoxy resin containing a modified special hardener. The product is distinguished by the following qualities:

- very rapid hardening
- easy measuring and mixing by use of cartridge system
- extremely low shrinkage during the hardening process and therefore low tensions in the bonding layer
- a good dimensional stability of the bonding layer
- a small tendency to fatigue
- a very good alkali-stability, thus the adhesive is very well suited to bond concrete.
- excellently suited for bonding gas-impermeable materials as it is a solvent-free product
- good electrical insulating property
- suited for bonding materials which are sensitive to solvents (e.g. expanded polystyrene, acrylonitrile butadiene styrene)
- the product is not liable to crystallize, therefore no problems in storing and processing.

**Field of Application:** AKEPOX® 3000 Mini Quick is an universal adhesive for bonding natural and cast stones, metal (iron, steel, aluminium, copper), wood, ceramics and various synthetic materials (rigid PVC, polyester). Due to its jelly-like consistency the product has a good vertical stability. The rapid hardening time makes the product suitable for assembly work, bonding of letters and dowels. Materials s. a. polyolefin (polyethylene, polypropylene), silicone, fluorohydrocarbons (Teflon), flexible PVC, flexible polyurethane and butyl rubber cannot be bonded with AKEPOX® 3000 Mini Quick.

- Instructions for Use:**
- without mixing nozzle: dosing apparatus only
  - with mixing nozzle: dosing and mixing apparatus at the same time
1. Thoroughly clean, let dry and slightly roughen surfaces to be bonded.
  2. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle.
  3. Both components must be thoroughly mixed when working without mixing nozzle.
  4. The mixture remains workable for approx. 3-4 min (20°C). After 30-60 min (20°C) the adhesive has a good initial stability, after 3-5 hours (20°C) the bonding may be stressed; after 24 hours (20°C) the adhesive has its max. stability.
  5. Tools can be cleaned with AKEMI® Nitro-Dilution.
  6. The hardening process is accelerated by heat and delayed by cold.
  7. If stored in cool place, approx. shelf life is 1 year.

**Technical Instruction Sheet****Special Hints:**

- AKEPOX® 3000 Mini Quick is not suited for bondings which are exposed to permanent moisture.
- Metallic surfaces should be ground in a short interval before bonding to avoid a decrease in adhesion.
- Use AKEMI® Liquid Glove to protect your hands.
- An adhesive which is already thickened or just gelling should not be used anymore.
- At temperatures below 10°C the product should not be used anymore as there is no sufficient hardening.
- The hardened adhesive is liable to yellowing, especially when exposed to sunlight
- Once hardened, the adhesive can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- When worked correctly, the hardened adhesive is not damaging to health.
- Use AKEMI® original mixing nozzle only.

**Safety Measures:**

see EC Safety Data Sheet

**Technical Data:**

1. Component A+B      Colour:      milky white  
    Density:      approx. 1.16 g/cm³

## 2. Working Time

a) mixture of 75 g of component A + 75 g of component B

- at 10°C: 8 - 9 minutes
- at 20°C: 3 - 4 minutes
- at 30°C: 2 - 3 minutes
- at 40°C: 1 - 2 minutes

b) at 20°C and different quantities

- |  |               |
|--|---------------|
| 15 g of component A + 15 g of component B}   |               |
| 40 g of component A + 40 g of component B}   |               |
| 75 g of component A + 75 g of component B}   | 3 - 4 minutes |
| 250 g of component A + 250 g of component B} |               |

## 3. Hardening process (shore-D-hardness) of a 2 mm layer at 20°C

<u>15 min</u> 30	<u>30 min</u> 35	<u>60 min</u> 36	<u>2 hrs</u> 43	<u>3 hrs</u> 48	<u>4 hrs</u> 50	<u>5 hrs</u> 52	<u>24 hrs</u> 63
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4. Shelf life:                  1 year approx. if stored in cool place free from frost in its tightly closed original container.

**Notice:**

The above information is based on the latest stage of our development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area or fabrication of a sample piece.

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