

## Usage: 330-GLUE2

### Description

Media resistance 2 component glue

- temperature resistance up to 250°C
- media resistance against many solvents

330-GLue is a solvent-free, hot-curing glue with high temperature resistance. This medium viscosity and unfilled glue shows a good cohesive on high performance thermoplastics. It is also very media resistant. In vacuum applications the glue can also be used like a varnish for protecting surfaces. Because the glue gets brittle after curing, it is not applicable for moving surfaces.

### Specifications

Colour	A: white opaque, B: yellow
Viscosity (23°C)	Medium, brushable
Pot Life (23°C, 10g)	6h
Mix Ratio A:B	2g:1g
Peak Temp at Curing	130°C
Store at Temp	2-15°C (do not freeze)
Shelf Live	6 month after manufacturing

### Application

#### Preparation of the surfaces

The surfaces have to be carefully cleaned from any residue fats. The glue works better on rough surfaces. It is applicable, that the preparation is planned according to the used materials. With plastics we suggest using ethylacetat.

#### Preparation of the mix

The components A and B have to be mixed in the weight ratio 2:1. On a scale put 2 times of component A in a pot then component B. Both components have to be mixed homogeneously. The mixed glue has a pot life of 6h at 23°C.

#### Application of the glue

The glue has to be brought on with an applicator or something similar on both sides of the surfaces, which are going to be glued together. After applying the glue, the surfaces have to be pressed against each other.

#### Cleaning of the tools

Uncured rests of the glue can be easily cleaned with solvents like acetone, ethylacetat or methyl ethyl ketone. Please regard the safety notes for using such solvents.

#### Curing

The best way of curing this glue consists on two steps at 80°C and 130°C. The length of the single step depends on how fast the temperature can be transmitted over the joined components to the glue. For first tests we recommend of using 1h for 80°C and 2h for the 130°C step. The best curing time can be optimized due further test. The minimum curing time is 20 minutes for each step. As an alternative the glue can also be cured for 30 minutes at 150°C.

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All data given in this sheet are carefully checked but subject to change at any time.