

| Object: Adhesives to fixe plates, bearings, washers, ...

1.Adhesives steel-to-steel bonding

ARALDITE

ref. **AY105 + NY991**

Liquid, two-component epoxy-based adhesive

Solvent-free; cold- and heat-curing

Curing conditions: 24 hours at 20°C or 0.5 hours at 80°C

Normal operating temperature: -60°C to +100°C

Shear strength: 12 N/mm² from -60°C to +40°C
(17 N/mm² at 80°C)

ref. **AW106 + NV953U**

Liquid, multi-purpose adhesive with standard hardener

Normal operating temperature: -60°C to +100°C

Shear strength: 27 N/mm² at 20°C
(7 N/mm² à 80°C)

MINESOTA 3M

ref. **EC2216 B/A**

Two-component structural adhesive

Curing conditions: 150 h at 20°C or 10 h at 80°C

Normal operating temperature: -60°C to +100°C

Shear strength: 12 N/mm² from -60°C to +40°C
(17 N/mm² at 80°C)

LOCTITE

ref. **329 + 7386** (MULTI-BOND)

Single-component structural adhesive

Curing conditions: 3 hours at 20°C

Normal operating temperature: -40°C to +100°C

Shear strength: > 24 N/mm² from -40°C to +40°C
(12 N/mm² at 80°C)

2. Adhesives for bonding bronze to steel or aluminum to steel

ARALDITE

ref. **AV 144-2 + HV 997**

Thixotropic multi-purpose adhesive, paste

Normal operating temperature: -60°C to +100°C

Shear strength: 22 N/mm² at 20°C(5 N/mm² at 80°C)

LOCTITE

ref. **306 + 7471**

Single-component structural adhesive

Curing conditions: 3 hours at 20°C

Normal operating temperature: -30°C to +60°C

Shear strength: > 14 N/mm² from -40°C to +40°C(6 N/mm² à 80°C)**Recommended for CSB-650 material**ref. **496**

One-component, fast-curing cyanoacrylate adhesive

curing time: 1 mi condition de durcissement 1 minute à 22°C

normal operating température normale de fonctionnement : - 40° à + 80°C

shear strength: > résistance au cisaillement : > 15 N/mm² à 22°C sur alu2 N/mm² à 22°C sur Zn Bi**Recommended for CSB-650 material**ref. **326 + N**

Fast-curing, single-component anaerobic adhesive

Curing conditions: 6 hours at 20°C

Normal operating temperature: -40°C to +80°C

Shear strength: > 18 N/mm² at 22°C on grit-blasted mild steel

The data is for information purposes, contact the manufacturers for further details.