



HOLDIT[®]

**Technical Datasheet
HOLDIT EMPOX**

Revised Date: June 2011

Description

HOLDIT Empox is a two component metal filled epoxy that cures at room temperature to form an ultra hard thermostat polymer. Empox has a fast cure system, allowing a 4 to 6 minute setting time (At 20°C), and when mixed forms a non-slump repair paste.

Applications

Empox is used widely in the MRO market sectors for the repair and recovery of worn and damaged machinery. In addition it has been found in many bonding applications due to its high tensile strength on steel and aluminium parts. Some typical uses of the Empox are:

- Re-building threads (can be drilled and tapped).
- Repairing worn shafts and keyways
- Filling cracked castings

Instructions for Use

1. Always consult the MSDS before using Empox for the first time.
2. Carry out surface preparation where required.
3. Carefully cut nozzle tip of the syringe.
4. Dispense sufficient adhesive for the application.
5. Mix the two components with a spatula until the colour is a uniformed grey.
6. Apply adhesive to both surfaces and assemble/clamp if required.
7. Remove excess glue immediately.
8. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping parts.

Properties of Uncured Material.

Resin	Epoxy
Colour	Black/White
Viscosity @ 25°C	1,100,000 cps
Mix Ratio	1:1
Cure System	Exothermic
Fixture Time	6-15 Minutes @ 20°C

Performance of Cured Material

Full Cure	72 Hours @ 20°C
Shore D Hardness	85
Chemical Resistance	Good
Gap Fill	4mm
Temperature Range	-50°C to 80°C

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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Storage

HOLDIT EMPOX should be stored in a dry cool area, out of direct sunlight in temperatures between -10°C and 30°C. Optimal Storage temperature is 22±4°C.

Presentation

Empox is available in 25ml cartridges.

Health & Safety in Use

Empox is an adhesive and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.

Conversions

- (°C x 1.8)+32 = °F
- N/mm x 5.71 = lb/in
- MPa x 145 = psi
- N/mm² x 145 = psi
- N x 0.225 = lb
- N·m x 8.851 = lb·in
- N·mm x 0.738 = lb·ft
- mPa·s = cP

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