

특징 및 이점

- ▶ 복합재 접착에 이상적
- ▶ 높은 전단 강도 및 박리 강도
- ▶ 고속 경화
- ▶ 고온 내열성
- ▶ 탄소섬유 접착에 적합한 색상

설명

PERMABOND® ET5428 BLACK은 충격 및 진동에 대한 높은 내성 및 틱스트로픽 점성을 제공한다. 접착제 혼합 및 도포 시 유동 특성 조절이 가능해 틈새 메움 용도로 사용된다.

퍼마본드 ET5428 BLACK은 높은 온도에서도 탁월한 성능을 제공한다.

퍼마본드 ET5428 BLACK은 인성 및 고강도가 요구되는 용도에 맞게 특별히 개발되었으며 복합재 조립 시 특별한 이점을 제공한다.

미경화 접착제의 물리적 특성

	ET5428 BLACK A	ET5428 BLACK B
화학 조성	에폭시 레진	폴리아민 경화제
외관(색상)	백색	검정색
혼합 색상	차콜 블랙	
점도 @ 25°C	20rpm: 80,000-150,000 mPa.s (cP) 2rpm: 200,000-400,000 mPa.s (cP)	20rpm: 100,000-300,000 mPa.s (cP) 2rpm: 700,000-1,500,000 mPa.s (cP)
비중	1.1	1.1

대표적인 경화 특성

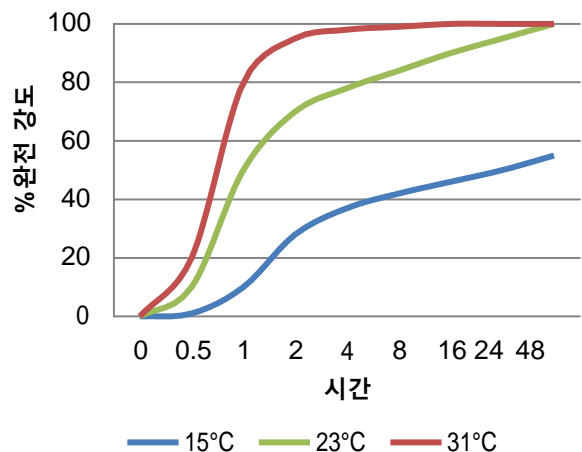
혼합 비율	2:1 by volume 2:1 by weight
최대 갭필	5 mm 0.2 in
가사 시간 @23°C 10g mixed	10-20 분
취급 시간	23°C: 30-45 분
작업 강도	23°C: 1 시간 60°C: 15 분
완전 경화	23°C: 24-48 시간 60°C: 1 시간

경화된 접착제의 대표적인 성능

전단 강도* (ISO4587)	Mild steel: 18-22 N/mm ² (2600-3200psi) FRP Glass/Polyester: 6-9 N/mm ² (900-1300psi) FRP Glass/Epoxy: 24-28 N/mm ² (3500-4000psi) Carbon Fibre: 20-38 N/mm ² (2900-5500psi)
박리 강도 (알루미늄) (ISO4578)	150-250 N/25mm (33-55 PIW)
경도 (ISO868)	65-75 Shore D
파단 시 연신율 (ISO37)	<5%
유리 전이온도 Tg	50-60°C (122-140°F)
절연 강도	15-25 kV/mm

*강도 결과는 표면 처리 및 갭 수준에 따라 달라질 수 있습니다.

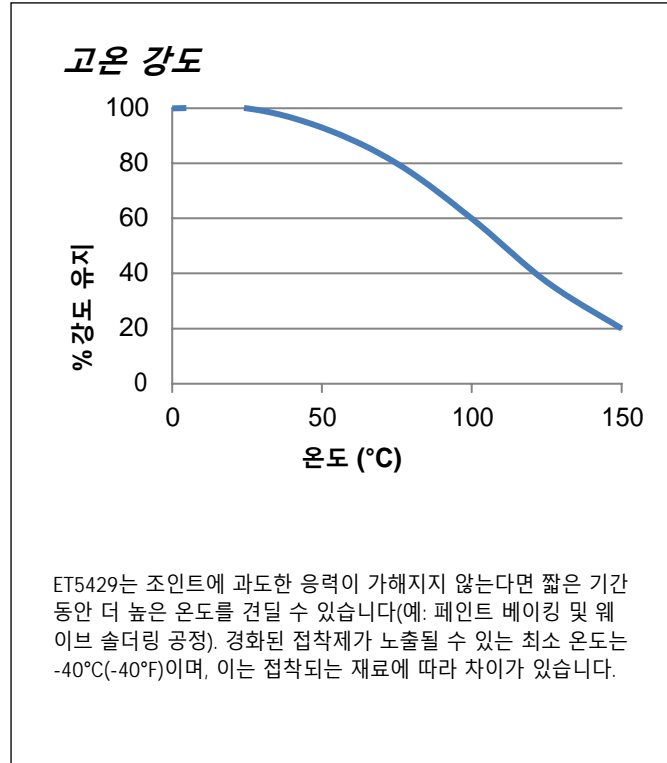
강도 발달



그래프는 접합된 구성요소의 일반적인 강도 발달을 보여줍니다. 온도가 8°C 증가하면 경화 시간이 절반으로 줄어듭니다. 온도가 낮으면 경화 시간이 느려집니다.

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취급 및 보관

보관 온도	5 ~ 25°C (41 ~ 77°F)
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표면 처리

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of surfaces. Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

사용 방법

- Dual cartridges:
 - Insert the cartridge into the application gun and guide the plunger into the cartridge.
 - Remove the cartridge cap and dispense material until both sides are flowing.
 - Attach the static mixer to the end of the cartridge and begin dispensing the material.
- Apply material to one of the substrates.
- Join the parts. Parts must be joined within 10-20 minutes of mixing the two epoxy components.
- Large quantities and/or higher temperature will decrease the usable life or pot life.
- Apply pressure to the assembly by clamping for 30-45 minutes or until handling strength is obtained.
- Full cure will be obtained after 24-48 hours at 25°C (77°F). Heat can be used to accelerate the curing process.

NB. Exercise caution when mixing large quantities due to exothermic reaction.

비디오 링크

표면 처리:
<https://youtu.be/8CMOMP7hXjU>

2액형 에폭시 사용 방법:
<https://youtu.be/GRX1RyknYqc>




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