



CNSL-BASED ADHESIVES GUIDE FORMULATIONS



HIGH BOND STRENGTH 2K EPOXY ADHESIVE WITH LITE 3040 PHENALKAMIDE

- Excellent bond strength on metal substrates including steel and aluminum
- Excellent toughness
- Long working hours

BIO-BASED EPOXY CURING AGENTS

AMBIENT-CURE REACTIVE ADHESIVES

ASSEMBLY, TRANSPORTATION,
COMPOSITE BONDING, POTTING

Guide Formulation

Ingredients	PART A Parts by wt.	PART 1B Parts by wt.	PART 2B Parts by wt.
Epoxy resin (EEW=190)	80		
MX125 25% Core Shell ²	20		
LITE 3040 (Phenalkamide) ¹		50	14
Jeffamine D230 ³			21
Coupling agent amine func.		3	3
Silverbond 602 ⁴		20	20
Fumed silica HB-380 ⁵		6	7
Total	100	79	65

¹ Cardolite ² Kaneka ³ Huntsman ⁴ Sibelco

⁵ Guangzhou GBS High-Tech & Industry Co., Ltd

Typical Properties

Properties	A/1B	A/2B
Cure condition	40°C/12hr + 60°C/4hr	
Mix ratio A/B	100/79	100/65
Lap shear strength on blasted steel, MPa	26.5	26.1
Lap shear strength on blasted aluminum, MPa	22.3	27
Failure mode	Cohesive	Cohesive

PROCESSING

All liquid components are blended together with a high shear mixer. Then any solid components are added separately and blended into the liquid after each addition. The product is generally degassed after mixing and before packaging.

Please refer to each supplier's material safety data sheet (MSDS) for the most current safety and handling information.

DISCLAIMER

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