

**ELI-BOND FR/166
G P ADHESIVE CLEAR**

PRODUCT:	A transparent, liquid adhesive
DESCRIPTION:	An unfilled, two component liquid Epoxy Adhesive
VISCOSITY / 25°C:	Resin: 10 000 - 12 000 mPa.s Hardener: 43 000 - 45 000 mPa.s Mixed: 30 000 - 33 000 mPa.s
APPLICATION:	By brush or spatula or pouring
MIXING RATIO:	By weight or volume: 1 Part Resin 1 Part Hardener
PRACTICAL WORKING LIFE / 25°C: (± 200g mass)	20 – 30 Minutes
POTLIFE / 25°C: (± 200g mass)	30 – 40 Minutes
GELTIME / 25°C: (± 200g mass)	50 – 60 Minutes
SETTING TIME / 25°C: (± 200g mass)	1¼ – 1½ Hours
PRACTICAL CURE / 25°C:	24 Hours
FULL CURE / 25°C:	7 Days
EXOTHERM:	Low Heat development in a quantity up to 2 kg
TYPICAL PHYSICAL PROPERTIES:	
HARDNESS AFTER 24H CURE / 25°C: 7 DAYS / 25°C:	Shore D: 80 Shore D: 85
FLASHPOINT:	> 200°C
HEAT DISTORTION TEMPERATURE: (A.S.T.M. D648 - 56)	60 – 70°C
MAXIMUM OPERATING TEMPERATURE:	70 – 80°C
FLEXURAL STRENGTH (DIN 53452):	> 20 MPa
TENSILE SHEAR STRENGTH:	Steel / Steel > 17 MPa
TENSILE STRENGTH: (DIN 53454)	40 – 45 MPa

COMPRESSIVE STRENGTH: (DIN 53454):	60 – 65 MPa
TYPICAL ELECTRICAL PROPERTIES:	
DIELECTRIC STRENGTH:	> 11 KV / mm
SURFACE RESISTANCE:	> 1 X 10 ¹⁴
TYPICAL CHEMICAL PROPERTIES:	
WATER ABSORPTION / 24H / 25°C:	> 1%
RESISTANCE TO:	Water, Grease, Oil: Excellent
	Hydraulic Fluid, Aviation Fluid: Good
RESISTANCE TO SOLVENTS:	Aliphatic Hydrocarbons, Alcohols: Good
	Aromatic Hydrocarbons: Satisfactory
	Ketones, Esters, Chlorinated Hydrocarbons: Poor Tests are advisable
STORAGE STABILITY:	Stored in closed containers under dry and cool conditions: 12 months
TOXICITY:	Non-toxic at ambient temperatures, very low skin irritation potential. However, gloves should be worn and adequate ventilation must be ensured during application.
PROPERTIES AND USES:	Eli-Bond FR/166 is a room temperature curing, general purpose adhesive which shows outstanding adhesion and bond strength on cleaned and roughened organic or inorganic surfaces. A strong and lasting bond is produced on substrates such as various metals, wood, asbestos, concrete, brick, glass, ceramics and retreated plastics and rubber.
NOTICE:	The technical specification and/or our technical advice, whether verbal in writing or by trials, is given in good faith and based on our test results obtained but without warranty. It does not release the user from the obligation to test the products supplied by us or any third party as to the suitability for the intended application. The application, use and processing of the products are beyond our control, and Elite Chemical Industries (Pty) Ltd's legal obligation in respect of any sale of its products shall be determined by the terms of its conditions of sale.