

SR 3-10 / SD 3' or SD 10' Epoxy fast bonding system

Systems based on SR 3-10 resin and SD x' hardeners

- Two component epoxy system
- Easy mixing ratio: 1/1 by weight and volume
- No critical mixing ratio
- Very fast cure in thick film, just a few minutes.
- Unfilled components, with thinners or diluents, viscous liquids without thixotropic fillers

Curing

- Very fast at low and ambient temperature
- Accelerated by higher temperatures

Material to bond

- Epoxy resin typical substrate prepared according to "state of art"
- Degrease only. / Degrease, abrade and remove loose particles. / Degrease and chemically pretreat
- Please contact our technical department
- Material: Wood, laminates, metals and alloys, plastics, miscellaneous materials...

SR 3-10 Epoxy resin

Colour	Clear to light yellow viscous liquid	
Aspect	Viscous liquid	
Gardner colour	3 maximum	
Viscosity (mPa.s)	@ 15 °C	75 900
	@ 20 °C	26 700
	@ 25 °C	11 000
	@ 30 °C	5100
	@ 40 °C	1500
Density	@ 20 °C	1.16
Refractive index	@ 25 °C	1.5716
Storage	Can crystallize at low temperature or after a long storage. If SR 3-10 develops a haziness or crystallizes on storage, this can be dispersed and the resin restored to its original condition by warming to 50 – 60 °C, with stirring	
Shelf life	@ 20 °C	2 years

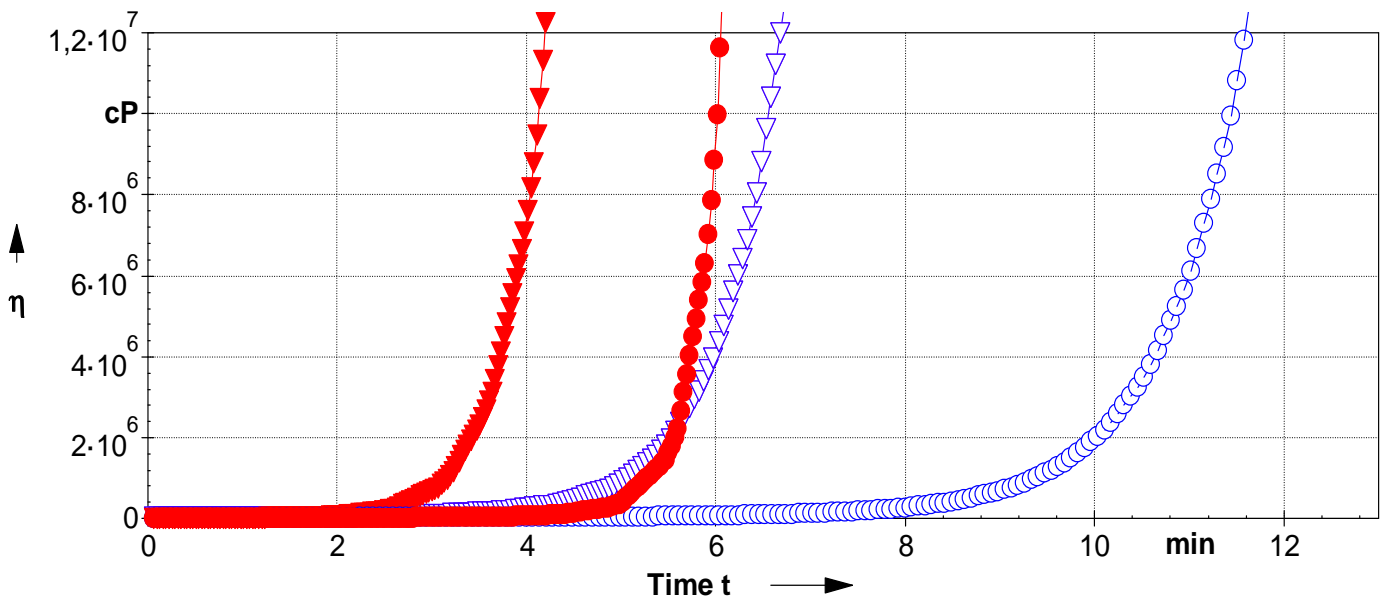
Hardeners SD x'

Type	SD 3'		SD 10'
	"Ultra fast"		"Very fast"
Aspect / colour	Yellow viscous liquid		Yellow viscous liquid
Viscosity (mPa.s)	@ 15 C	47 900	39 000
	@ 20 °C	25 000	20 500
	@ 25 °C	13 800	11 400
	@ 30 °C	7900	6700
	@ 40 °C	3000	2600
Density (g/cm ³)	@ 20 °C	1.13	
Refractive index	@ 25°C	1.5016	1.5001

Blends SR 3-10 / SD x'

		SR 3-10 / SD 3'	SR 3-10 / SD 10'
Mixing by weight		100 g / 90 g	
Mixing by volume		100 ml / 100 ml	
100 mix pot life	@ 25 °C	3 – 6 mn	5 – 10 mn
1 mm film is hard after	@ 25 °C	7- 10 mn	15 – 20 mn
Initial viscosities	@ 20 °C	20 000	12 000
(± 20 % mPa.s)	@ 30 °C	7 000	5 700

Reactivity – 1 mm film viscosity evolution



- ▽ SR 3-10 / SD 3' @ 20 °C
- SR 3-10 / SD 10' @ 20 °C
- ▽ SR 3-10 / SD 3' @ 30 °C
- SR 3-10 / SD 10' @ 30 °C

Measures undertaken according to the following norms:

DSC glass transition:	ISO 11377-2:1999	-5°C to 180°C under nitrogen gas
	T _{g1} or Onset:	1 st run at 20 °C/min
	T _{g1} maximum or Onset:	2 nd run at 20 °C/min
Viscosity:	Rheometer	CP 50 mm - Shear rate 10 s ⁻¹
Density:	ISO 2811-1	Pycnometer
Gel time	Cross G' G'' / rheometer	CP50 - Shear rate 10 s ⁻¹
Color Pt-Co	ASTM D1209 Pt-Co	
Gardner color:	NF EN ISO 4630	Visual method
Flashpoint	DIN 51584	
Refractive index :	NF ISO 280	
Viscosity:	NF EN ISO 3219	Rheometer 50 mm, shear 10s ⁻¹
Density:	NF EN ISO 2811-1	Pyknometer
GreenCarbon content:	ASTM D6866 or XP CEN/TS	16640 Avril 2014

Legal notes :

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We advise users of SICOMIN products to check by some practical trials that they are suitable for the intended processes and applications.

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