

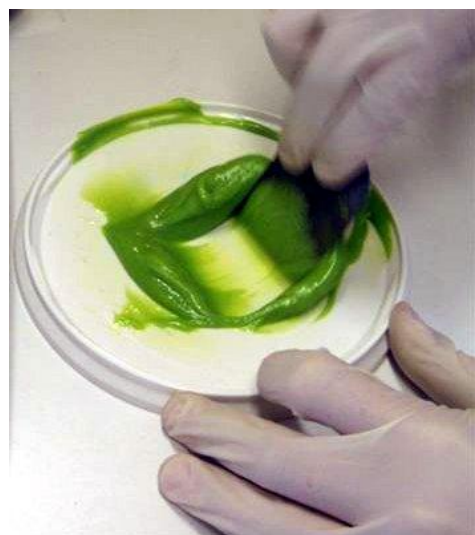
## ISOBOND 735 Two Component Epoxy Adhesive in Cartridge

**ISOBOND 735** is a two-component structural epoxy adhesive that is versatile and compatible with multiple substrates (composite, wood, concrete, stone, etc.).

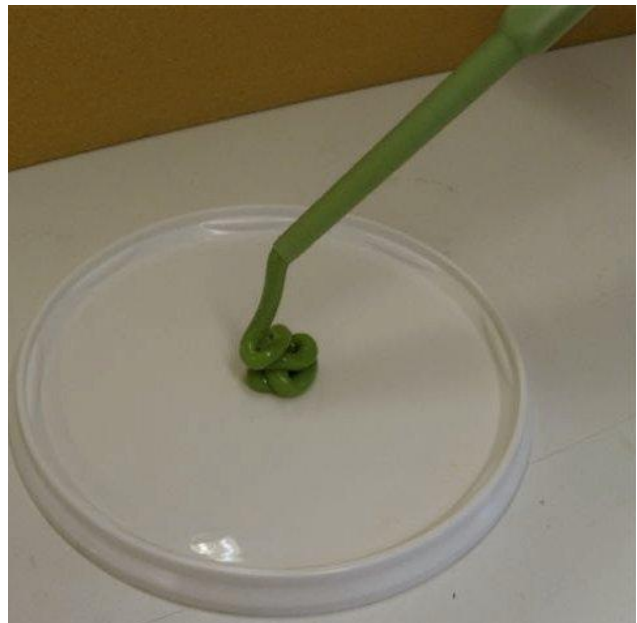
Reactivity is adapted to achieve good adhesion after 20° C hardening. Bonding will be optimal after a few hours at 50-60 °C and will resist under mechanical stress up to 60-65 °C continuously.

The cartridge packaging allows both an easy and precise volume mixing ratio and to quickly prepare the desired quantity before immediate mixing.

Gel texture for fine bonding to a thickness of around 1 mm.  
This adhesive can also be used for sealing surfaces.



The extra mixing nozzle assures a good mixing between resin and hardener, that is showed by the homogenous green colour at the output.



## Epoxy Resin ISOBOND SR 735

		<b>ISOBOND SR 735</b>
Aspect		Paste
Colour		Yellow
Viscosity (mPa.s)	20 °C	35 000 ± 7 000
Rheometer CP 50 mm	25 °C	22 000 ± 4 000
Shear rate 10 s <sup>-1</sup>	30 °C	16 000 ± 8 000
Density :	20 °C	1.24 ± 0.05
Picnometer		
NF EN ISO 2811-1		
Storage stability		24 months, crystallisation free

## Hardener ISOBOND SD 735

		<b>ISOBOND SD 735</b>
Aspect / colour:		Blue paste
Réactivité		Fast
Viscosity (mPa.s)	20 °C	26 000 ± 5 000
Rheometer CP 50 mm	25 °C	24 000 ± 5 000
Shear rate 10 s <sup>-1</sup>	30 °C	23 000 ± 4 000
Density:	20 °C	1.10 ± 0.05
Picnometer		
NF EN ISO 2811-1		
Storage stability		24 months, crystallisation free

## ISOBOND SR 735 / SD 735 Mix Properties

		<b>ISOBOND SR 735 / ISOBOND SD 735</b>
Volume ratio		<b>2 / 1</b>
Colour		Green
Viscosity (mPa.s)	20 °C	25 000 ± 5 000
Rheometer CP 50 mm	30 °C	15 000 ± 3 000
Shear rate 10 s <sup>-1</sup>		

### Processing advice

If the ambient temperature is below 15 °C, the cartridge should be warmed up at 20 to 30°C to ensure a good flow with manual guns.

Both resin (in yellow) and hardener (in blue) are pigmented so that it becomes easy to detect any mixing deviation. If the mix colour is not homogenous, the first 10-15 grams should be withdrawn.

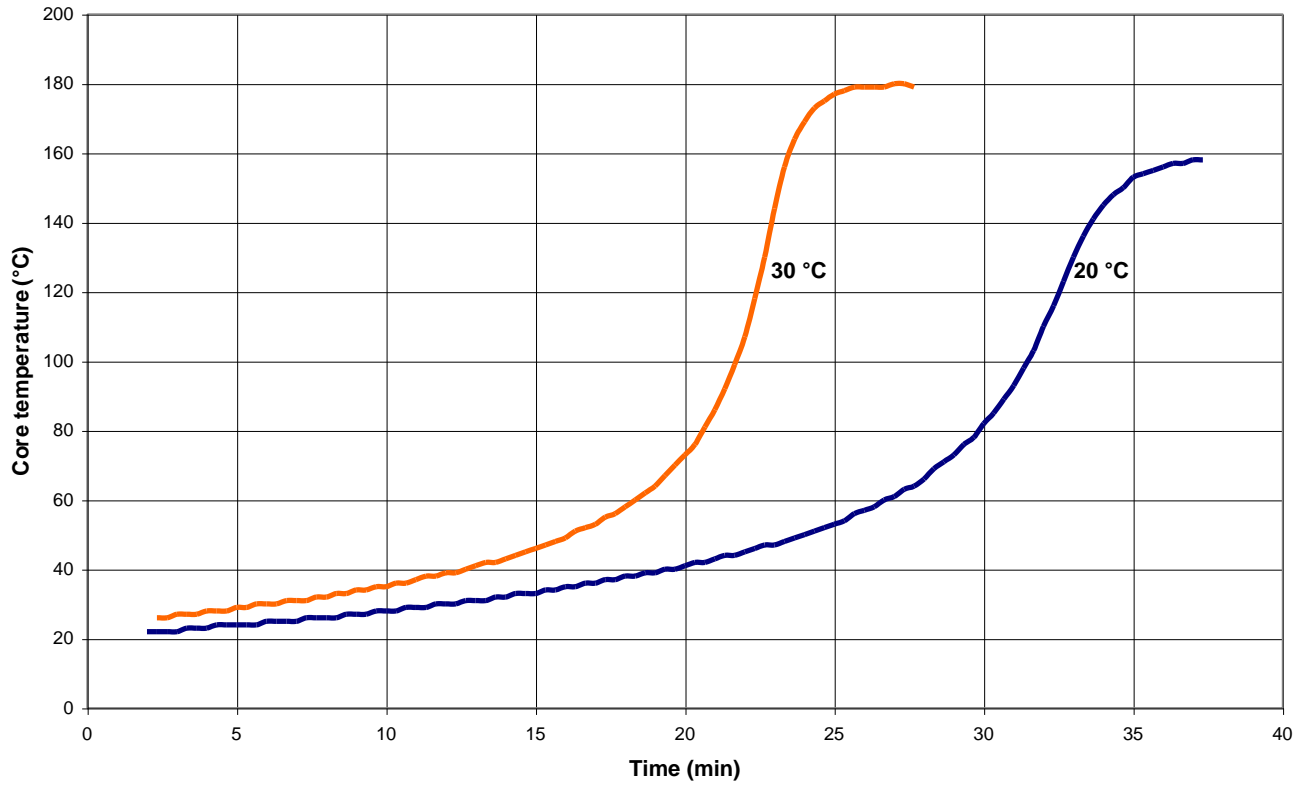
Mixing nozzle instructions of use:

- Unscrew and take off the red cap. It should be kept to shut the cartridge in case it is not used in one shot.
- After having placed the cartridge in the gun, squeeze out gently until resin and hardener are on same level.
- Clean the cartridge output and screw the mixing nozzle if needed.
- Do not use the first grams if its colour is not homogenous.

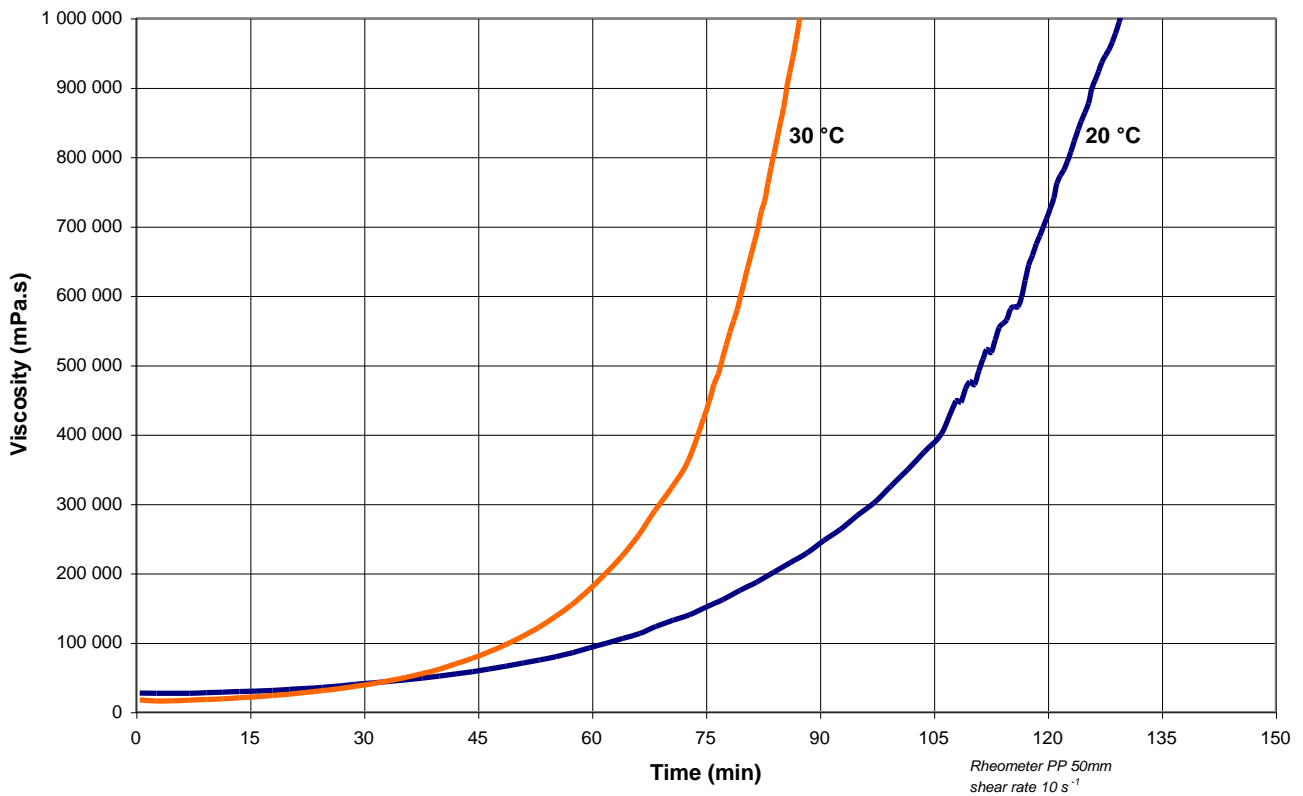
If the cartridge is used without a nozzle just for mixing ratio, a very good care should be taken to the mixing precision. Continue mixing until colour is homoge

### Mass Reactivity

		<b>ISOBOND SR 735 / ISOBOND SD 735</b>
Exothermic peak on 100 g mix:	20 °C	158 °C
	30 °C	180 °C
Time to reach exothermic peak on 100 g mix:	20 °C	37'
	30 °C	27'
Time to reach 50 °C on 100 g mix:	20 °C	24'
	30 °C	16'



### Reactivity – Viscosity Evolution On A 1 Mm Film



### Mechanical Properties On Pure Resin:

		<b>ISO BOND SR 735 / ISO BOND SD 735</b>
Curing cycle		24 h 23 °C + 8 h 60 °C
<b>Tension</b>		
Modulus of elasticity	N/mm <sup>2</sup>	3205
Max resistance	N/mm <sup>2</sup>	59
<b>Compression</b>		
Compressive yield strength	N/mm <sup>2</sup>	95
<b>Tensile shear</b>		
Tensile shear max resistance	N/mm <sup>2</sup>	17
<b>Glass transition</b>		
Tg1	°C	84
Tg1 max.	°C	88

Tests carried out on samples of pure cast resin, without prior degassing, between steel plates.

Measures undertaken according to the following norms:

Tension: NF T 51-034

Compression: NF T 51-101

Tensile shear

Glass transition DSC: ISO 11357-2: 1999 -5°C to 180°C under nitrogen gaz

Tg1 or Onset: 1st point at 20 °C/mn

Tg1 maximum or Onset: second passage

The information given by writing or verbally, in the context of our technical assistance and our trials, do not engage our responsibility. We advise the users of SICOMIN products, to check by some practical trials they are suitable for the envisaged processes and applications. The customer's storage, the use, the implementation and the transformation of the supplied products, are not under our control and your responsibility only will respond for it.

If our responsibility should nevertheless be involved, it would be, for all the damages, limited to the value of the goods supplied by us and implement by the customer. We guaranty the non-reproachable quality of our products, in the general context of sales and delivery.