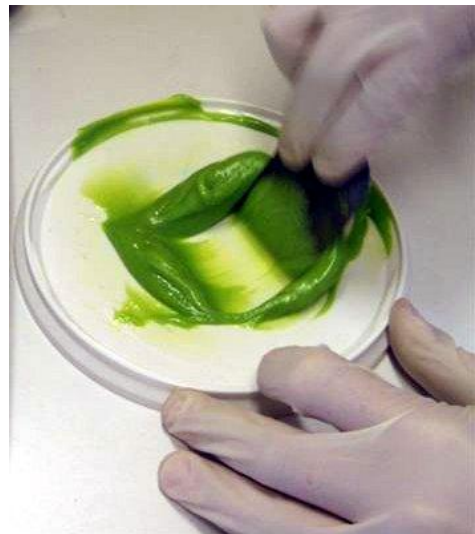


ISOBOND 735 Two Component Epoxy Adhesive in Cartridge

ISOBOND 735 is a two component epoxy adhesive in cartridges allowing fast composite / composite and some metal / composite bonding.

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.



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

		ISOBOND SR 735	
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 ⁻¹	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

		ISOBOND SD 735	
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 ⁻¹	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

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

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 If the mix colour is not homogenous, the first 10-15 grams should be withdrawn.

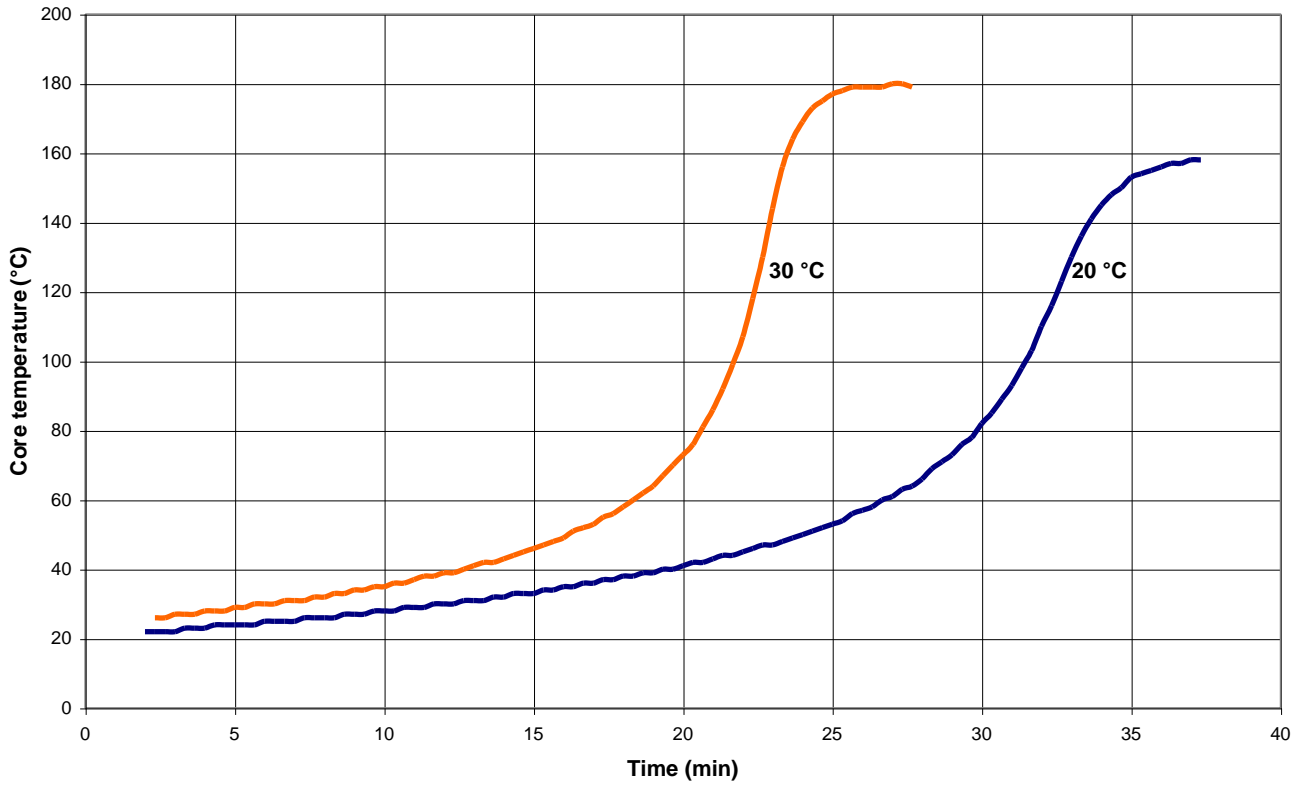
Mixing nozzle instructions of use:

- 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.

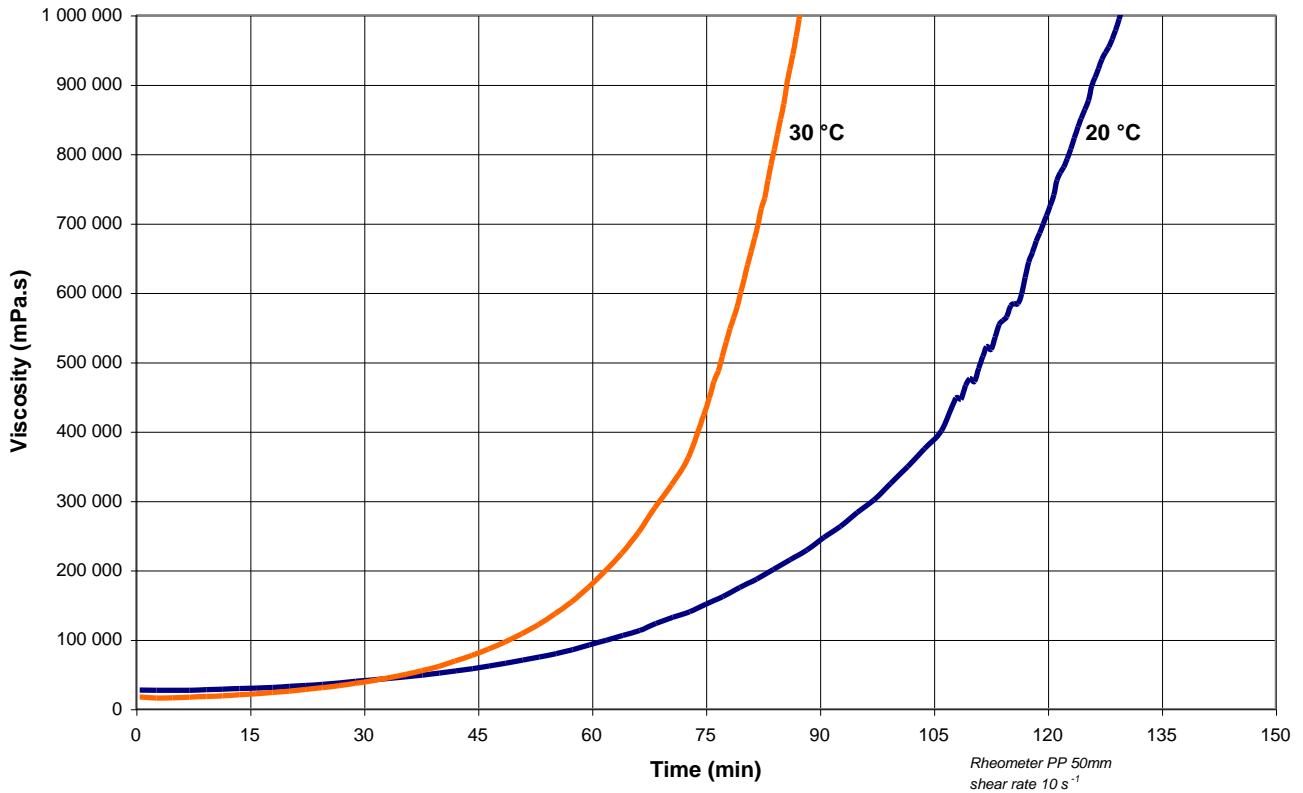
If the cartridge is used without a nozzle just for mixing ratio, a very good care should be taken to the mixing precision. Continue mixing until colour is homoge

Mass Reactivity

		ISOBOND SR 735 / ISOBOND SD 735
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:

		ISOBOND SR 735 / ISOBOND SD 735
Curing cycle		24 h 23 °C + 8 h 60 °C
Tension		
Modulus of elasticity	N/mm ²	3205
Max resistance	N/mm ²	59
Compression		
Compressive yield strength	N/mm ²	95
Tensile shear		
Tensile shear max resistance	N/mm ²	17
Glass transition		
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

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