Instructions for use
of two-component ergo.® adhesives out of double cartridges

General
ergo.® epoxy resins and methyl methacrylate adhesives (MMA) are two-component structural adhesives used to bond, cast and coat surfaces primarily in the electrical engineering and electronics industry, as well as mechanical engineering, tool-making and aggregate construction. They are usually packaged as double cartridges, and are easy to mix and dispense using a dispensing gun and static mixer. This system is used throughout industry. For more details, please refer to respective the Technical Data Sheet.

Curing
2-K products start to cure when the two components are mixed at room temperature. When the pot life has been exceeded, viscosity increases until full cure is achieved. This process, which depends on the individual product as well as on the quantity, can be very quick and produce a strong exothermic reaction. Fast-cure products should be worked in small quantities due to the exothermal reaction. If required, good heat dissipation should be provided. Working in a higher temperature environment reduces the cure time and increases the bond strength.

Preparation of mating surfaces
For optimum bond strength, mating surfaces must be free of oil, grease and other contaminants. ergo.® 9190 Cleaner available in an aerosol spray can may be used to clean surfaces. In some cases, it might not be possible to clean the components. In many cases, the as-delivered condition of the components meets requirements. In any event, we recommend that the suitability and strength of the adhesive is tested for its intended use.

Application
2-K products comprise a resin and a hardening agent, which once they have been thoroughly blended into a homogenous mixture give the finished product. The adhesive is applied using a dispensing gun directly from the double-chamber cartridge. The homogenous mixture is produced in a static mixer tube, which fits on the top of 50 ml or 200 ml cartridges.
This prevents mixing errors.

If using a new double-cartridge proceed as follows:
1. Press the securing lever of the pistol and pull the piston rod to the end stop
2. Insert the double-cartridge into the pistol and secure it
3. Push the piston rod forwards until resistance can be felt
4. Remove the closing cap
5. Use the pistol carefully and slowly, until product comes out both nozzles
   The chambers are overfilled, so that no loss occurs while equalizing the content.
6. Attach and fix the static mixer tube and lock it either by a 90° turn or by using the swivel nut
7. Before use, press out one tube-content and waste it.

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8. Normally, the adhesive is applied to one component only; however, it may also be applied to both sides. Once the adhesive is applied, assembly and any fixing should be completed taking the pot life into account.
9. If interruptions in the process are shorter than the pot life of the individual product, the mixer can be reused.
10. If the process is complete or if there are longer interruptions, the mixer can be left on the cartridge as a cap.
11. Before the process can resume, the old mixer must be replaced by a new mixing-tube.

For more details, please refer to the Technical Data Sheets.

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