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## TECHNICAL DATA SHEET

### **ergo® 1907** (ergo® 1905 resin + ergo® 1906 hardener)

#### **Product - Description**

This **low odor ergo® - grade** was developed to bond metals like aluminum, steel, brass and its alloys as well as ferrite, a wide range of plastics and combinations of those materials.

It is a two-component system and cures after mixing into a dry, high-strength and impact resisting polymer film. The best mixture-ratio is 1:1 (volume) and is obtainable without problems by using the common double-cartridges.

#### **Advantages**

- Fast curing system
- High tensile shear strength
- Resists against impacts as well as again peeling
- Good gap-filling behaviour up to 0,10mm
- Free of solvents
- Short fixture times

#### **Physical Properties (liquid product)**

**Chemical base** : modified acrylic

**Viscosity** :

Brookfield RVT, Sp.4, 25°C, 20 rpm : 6000 – 8500 mPas

**Density** : 1,06 – 1,14 g/cm<sup>3</sup>

**Colour** resin (ergo® 1905) : white

hardener (ergo® 1906) : dark grey-green

**Shelf life** : 6 month at room temperature

#### **Cured product:**

tensile shear strength acc. to DIN EN 1465, parts only degreased

**aluminum/ aluminum**

after 24 h at 23°C : > 20 N/mm<sup>2</sup>

**steel/ steel**

after 24 h at 23°C : > 22 N/mm<sup>2</sup>



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**brass/ brass**

after 24 h at 23°C

: > 17 N/mm<sup>2</sup>

**ABS/ ABS**

after 24 h at 23°C

: > 6 N/mm<sup>2</sup> (stripe fail ed)

**PVC, hard/ PVC, hard**

after 24 h at 23°C

: > 3 N/mm<sup>2</sup> (stripe fail ed)

**Impact resistance**

: > 20 kJ/m<sup>2</sup> (steel, sand blasted)

**T-Peeling**

: > 40 N/cm (steel, sand blasted)

**Shore D – hardness**

: 54

**Thermal range**

: - 40°C bis + 110°C

**Resistance against solvents**

: good

**Curing**

**Curing system**

: 2-component-system  
ratio 1:1 (volume)

**Potlife**

: 2 - 5 minutes (2g-mixture)

**Initial strength**

: ~ 10 minutes at 23°C

**Final strength**

: ~ 12 hours at 23°C

**How to use the product**

**Resin ergo® 1905** and **hardener ergo® 1906** is normally applied by using the double-cartridge-system with static mixture tube. ATTENTION: Potlife in the tube will be, depending on room-temperature, between 3 - 6 minutes. Apply the mixed glue on one part and spread it carefully over the whole bonding area. Fit the parts together and fix them at least as long as the potlife time, better 10 minutes.

The product may be used also in bead on bead manner.

In this case, cure speed and final strength will be on a slightly lower level and has to be checked by the customer in his real application.

**WARRANTY INFORMATION - PLEASE READ CAREFULLY**

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