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## TECHNICAL DATA SHEET

### **ergo® 1925** (ergo® 1923 resin + ergo® 1924 hardener)

#### **Product - Description**

This **very low odor and slow curing ergo® - grade** was developed to bond metals like aluminum, steel, brass and its alloys as well as ferrite, but also a wide range of plastics (ABS, PVC, PC, PS) and combinations of those materials. The two-component system cures after mixing into a dry, tough and impact resisting polymer film. The best mixture-ratio of 1:1 (volume or weight) is obtainable by using the common double-cartridges with static mixer tube. Due to its insensitiveness to changing mixture ratios, it may be applied also as rope beside rope and mixed by hand

#### **Advantages**

- Very low odor
- Non-flammable liquid
- Wide range of mixture ratio
- Free of solvents
- Contains 100µm spacer to optimize gap and mechanical properties
- Good gap-filling behavior
- Excellent adhesion
- Low shrinkage
- High tensile shear strength
- Resists against impacts as well as against peeling
- Resists against paint baking
- Compatible with spot welding procedure
- Long fixture time allows adjustment of joined parts, even if big areas are involved

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

**Chemical base** : modified, toughened acrylic

**Viscosity** ergo 1923 (resin) : ~ 20.000 mPas

ergo 1924 (hardener) : ~ 20.000 mPas

**Density** ergo 1923 (resin) : 1,02 g/cm<sup>3</sup>

ergo 1924 (hardener) : 1,03 g/cm<sup>3</sup>

**Colour** resin (ergo® 1923) : pale yellow

hardener (ergo® 1924) : dark blue green

mixed and cured : dark brown grey

**Flash point** : 101°C

**Shelf life** : 6 month below 30°C

12 month below 6°C

/2

## Curing @ 23°C

Curing system

: 2-component-system  
best mixture ratio 1:1 (volume or weight)

Potlife

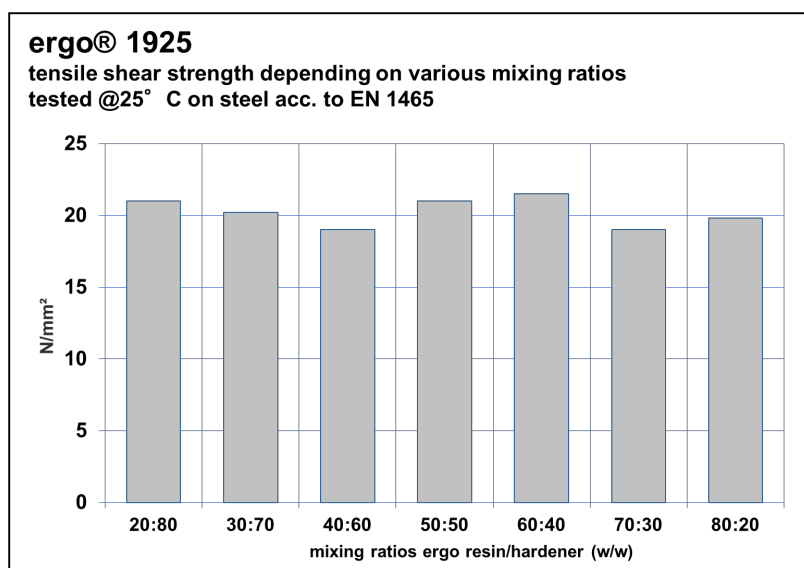
: ~ 20 minutes

Initial strength

: ~ 25 minutes

Final strength

: ~ 4 hours



## Cured product:

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

**aluminum/ aluminum**

after 12 h at 23°C

: > 19 N/mm<sup>2</sup>

**steel/ steel**

after 12 h at 23°C

: > 20 N/mm<sup>2</sup>

**stainless steel/ stainless steel**

after 12 h at 23°C

: > 23 N/mm<sup>2</sup>

**galvanized steel/ galvanized steel**

after 12 h at 23°C

: > 20 N/mm<sup>2</sup>

**Impact resistance**

: > 16 kJ/m<sup>2</sup> (steel, sand blasted)

**Peel strength (ISO 4578)**

: > 70 N/cm (steel, sand blasted)

**Shore D – hardness**

: 60

**Shrinkage after curing**

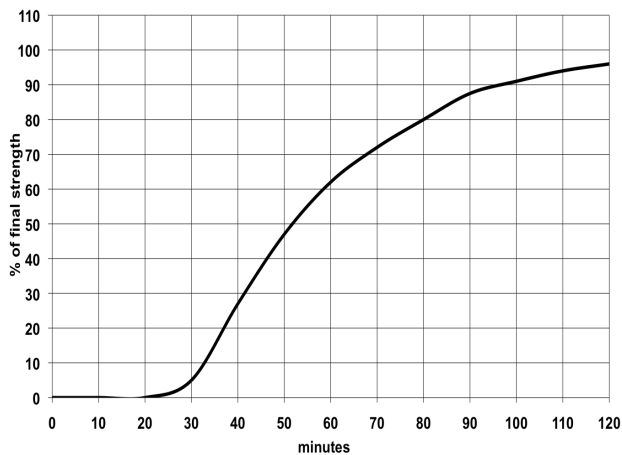
: < 8%

**Thermal range**

: - 40° C up to + 110° C

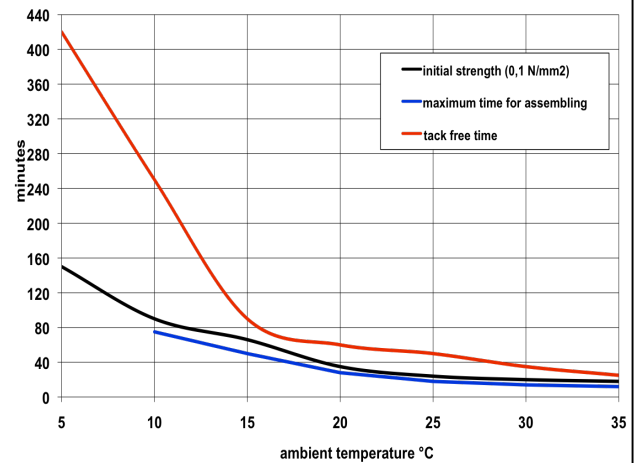
## Cure-speed ergo® 1925

tested @ 23° C



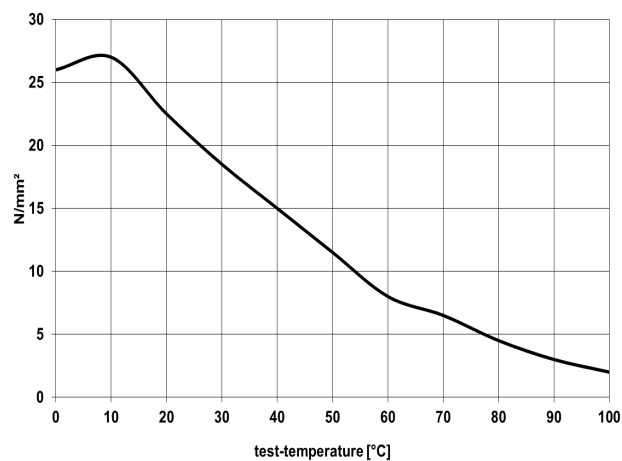
## Curing properties of ergo® 1925

depending on ambient temperature



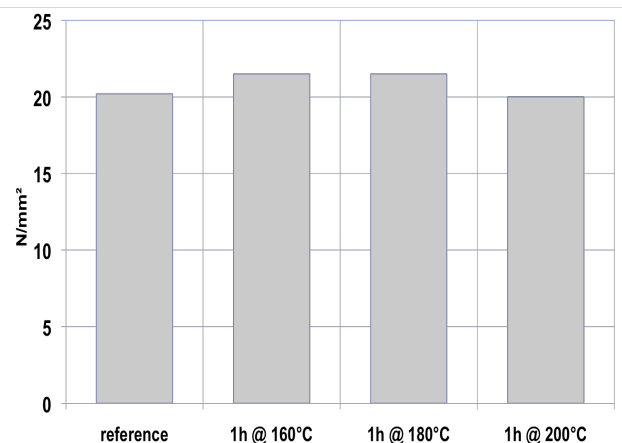
## Tensile shear strength of ergo® 1925

after 24 hours @ test-temperature (EN 1465)



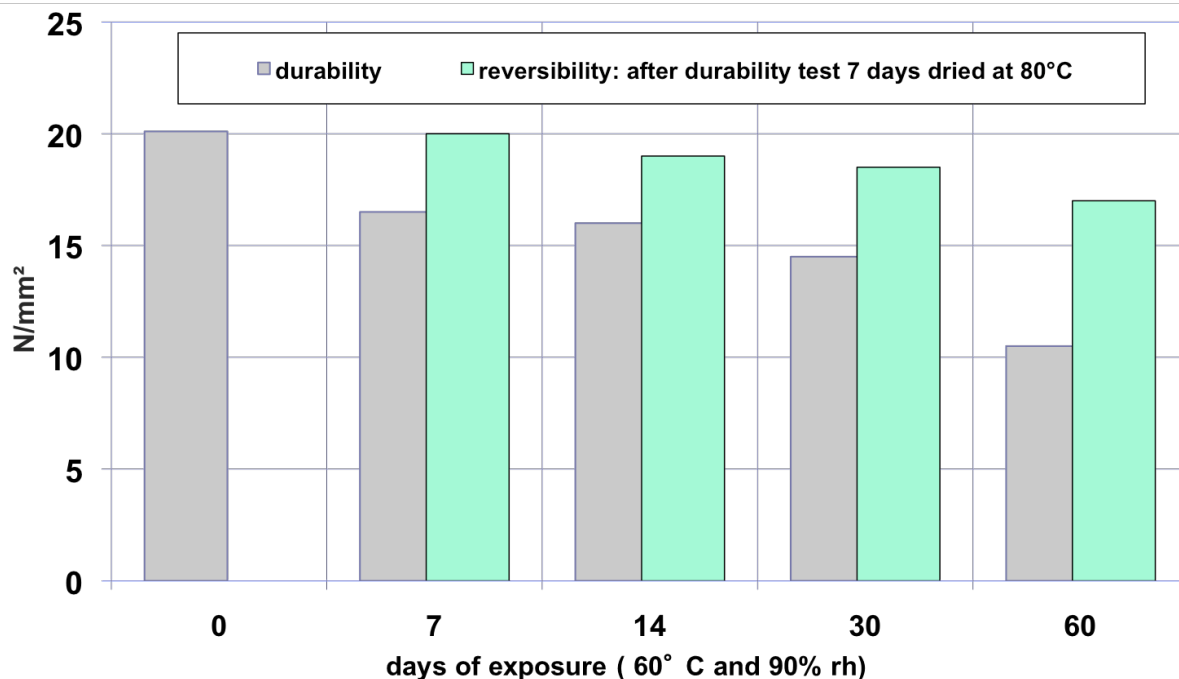
## ergo® 1925

tensile shear strength after short time heating  
tested @25° C on steel acc. to EN 1465



## ergo® 1925

**tensile shear strength after influence of high relative humidity  
tested @25° C on steel acc. to EN 1465**



## How to use the product

**Resin ergo® 1923 and hardener ergo® 1924** 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 18 - 22 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 25 minutes (please refer to the relating curves on page 3). The product may be used also in bead on bead or bead beside bead manner.

### WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that KISLING products are safe, effective, and fully satisfactory for the intended end use. KISLING sole warranty is that the product will meet the KISLING sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. KISLING specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless KISLING provides you with a specific, duly signed endorsement of fitness for use, KISLING disclaims liability for any incidental or consequential damages. Suggestions of uses should not be taken as inducements to infringe any particular patent.