



**resoltech**  
ADVANCED COMPOSITE TECHNOLOGY

# 3050F

## **COLD CURE EPOXY STRUCTURAL ADHESIVE**

RESOLTECH 3050F is a high performance adhesive formulated for ambient temperature bonding. It is suitable for composites, PVC & honeycomb cores, steel, aluminium alloys and even concrete.

3050F is non-flammable, easy to use, does not require post curing and can be used to bond materials with different dilatation properties.

### **MIXING RATIO**

The mixing ratio is constant whatever the hardener selected.

By weight: 2 + 1

By volume: 2 + 1

Hardener(s) available: 3054.

**WARNING:** The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties. The mixture should be thoroughly stirred to ensure full homogeneity.

It is important to note that epoxy systems tend to heat up much faster in a pot than as a thin film. It is therefore necessary to only mix the necessary amount usable within the given pot life. Keeping the mixture in flat open containers reduces the risks of exothermic reaction.

### **APPLICATION**

RESOLTECH 3050F is an ambient temperature cure adhesive formulated for a large range of bonding applications. It is suitable for core bonding and also for composite to composite bonding.

For steel bonding, ensure the surfaces are clean, degreased and sanded.

For aluminium alloy bonding, an etching treatment is required prior to bonding.

For bonding onto concrete and porous materials, ensure the surface is dry and dustfree.

The standard procedure of working with epoxy systems applies to the RESOLTECH 3050F.

RESOLTECH 3050F does not contain any solvents and provides a long working time.

For more information, please refer to the applications technical bulletins (TechNotes), available on request.

### **CURING**

Workshop conditions: 18 to 25°C, 70% humidity maximum.

Pot life            3 hours            for 300g @ 25°C

Full cure         7 days @ 25°C

RESOLTECH 3050F does not require a post cure, although a post cure at an elevated temperature will improve mechanical properties and accelerate the cure.

## MECHANICAL PROPERTIES

|                                     |                     |
|-------------------------------------|---------------------|
| Tensile/shear strength:             |                     |
| Cured for 24H @ 25°C                | 20N/mm <sup>2</sup> |
| Cured for 7 days @ 25°C             | 29N/mm <sup>2</sup> |
| Cured for 7 days @ 25°C + 2H @ 70°C | 31N/mm <sup>2</sup> |
| Maximum service temperature         | 75°C                |
| Maximum TG                          | >140°C              |

## PHYSICAL PROPERTIES

|                    |                 |
|--------------------|-----------------|
| Resin aspect:      | Visquous liquid |
| Hardener aspect:   | Visquous liquid |
| Resin viscosity    | 25,000 mPas     |
| Hardener viscosity | 20,000 mPas     |
| Density of mixture | 1.15            |

Above values given at 25°C.

## PACKING & STORAGE

Resoltech 3050F is available as follow:

1.5kg, 7.5kg, 30kg, 300kg packs.

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold.

## HEALTH AND SAFETY

It is advised to follow basic rules such as avoiding skin contact, wear masks when producing dust. Please read our standard health and safety sheet for more information.

In case of eye contamination, wash with water and seek medical advice.

More information is available on [www.resoltech.com](http://www.resoltech.com).

The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.

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resolving your engineering challenges  
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