

Date: 21 December 2011

Information Sheet No.: TDS01665

## EVO-STIK CONTROL TUBE

### A TWO PART, MULTIPURPOSE EPOXY RESIN ADHESIVE

Evo-Stik Control is a solvent free, low odour, two-part repositionable epoxy adhesive. Evo-Stik Control will bond a wide range of materials including metal, wood, masonry, ceramics, glass, leather, rubber, chipboard, concrete, cardboard, fabric and most plastics. Before using this product refer to the relevant Health & Safety Data Sheet.

#### Uses

- Bonds in minutes
- Can be roughly handled after 16 hours
- Will not rust
- Oil resistant

#### Product Characteristics

Colour	Resin: Milky / Hardener: Amber
Form	Liquid
Specific Gravity	1.1
Composition	Epoxy Resin/Amine Hardener
Product Code	<b>808518</b> 1x6 15ml metal tubes in blisters
Shelf life/storage	1 year when stored in cool dry conditions in sealed containers. Store in dry conditions between 5°C and 25°C.

#### Typical Performance Data (approx.)

Flammability	No
UN Number	Resin: 3082 / Hardener: Not classified for transport
Setting Time	About 16 hours @ 23°C
Temperature	-40°C to + 70°C
Sandability	Sandable. Please wear dust mask.
Paintability	Good, but confirm by test. Fine sanding helps. Please wear dust mask.

#### Directions for use

##### IMPORTANT

Before using this Evo-Stik Control Epoxy refer to the relevant Health & Safety Sheet. Available at [www.bostik.co.uk](http://www.bostik.co.uk) named as the code above.

#### Preparation

1. Make sure surfaces are dry, clean and free from dust, dirt and grease. For even better bonding slightly roughen surfaces with a suitable abrasive paper.
2. Following the instructions on the back of the blister card, dispense equal volumes of resin and hardener onto a clean disposable surface or the tray provided. Wearing gloves is recommended. Not missing according to instructions will weaken the bond. Stir well for 45 seconds with the plastic spatula provided, ensuring a thorough mix. Use within 2 hours. Attach the resealable cap to the nozzles as soon as possible.

#### Application

1. Apply the mixed adhesive to both surfaces of the joint and assemble carefully (a layer of adhesive 0.10 to 0.20 mm thick will normally impart the greatest lap shear strength to the joint).
2. Keep the joint supported until set (using clamps or tape etc) for at least 6 hours. Allow 16 hours before rough handling/machining. Under normal conditions Evo-Stik Control attains its full strength after 24 hours. Exact setting time depends on temperatures and the quantities mixed. Setting times may be shorter in hot weather. In cold conditions the rate of curing of the mixed adhesive may be slowed down significantly and weak joints may result. For the best results use between 20°C and 25°C.
3. For a perfect finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

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## Cleaning

1. Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners or acetone. Solvents must always be handled with due care as they may be hazardous or flammable.
2. Please note the solvents may attack some rubbers, plastics, painted surfaces, fabrics etc. Bear this in mind if intending to use solvent to remove excess adhesive, and carry out a preliminary test first.
3. Cured adhesive residues can usually be dissolved from tools by soaking in commercial paint stripper. Refer to the paint stripper manufacturer's instructions for use and safe handling. Assess a small trial area before general work.
4. The adhesive may be removed from the skin using a suitable propriety hand cleaner. Contact with the skin

should however be avoided. Do not use solvents in contact with the skin. Always open and use adhesive products over a protected surface, and avoid contact with clothing.

## Precautions in Use

Do not use to repair or make items that will contain food or drink. Not recommended for bonding polyolefin's (e.g. polythene or polypropylene). Thorough mixing is the key to getting a good cured product. Simply stirring leaves unmixed materials at the margins. Always fold in the does then re-stir. Cured adhesive may slightly yellow if exposed to sunlight for long periods, even through windows. Not suitable for bonding oven doors or car mirrors.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet Evo-Stik Control Syringe.

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Sales & Technical contacts at Bostik	Telephone	Facsimile	Email addresses
Sales	0844 371 1192	01785 241818	<a href="mailto:customer.service@bostik.com">customer.service@bostik.com</a>
Technical advice	0844 371 1197	01785 272867	<a href="mailto:technical.service@bostik.com">technical.service@bostik.com</a>
Technical Data & COSHH (MSDS) sheets	01785 272625	01785 212962	<a href="mailto:stafford.gatehouse@bostik.com">stafford.gatehouse@bostik.com</a>

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