The products of the Structalit® 88xy series are due to its medium viscosity setting an all-purpose 1K-epoxy adhesive and potting compound. It is particularly suitable for bonding of materials that have a similar coefficient of thermal expansion e.g. metal/metal, glass/glass or plastic/plastic.

This product is available in different leveling characteristics named Structalit 8801, 8802, 8803, 8804. In this case 8801 has the lowest; 8804 the highest leveling potential.

**Shelf life:**
Store in original, unopened containers for 6 months at max. 0-10 °C

**Technical Data**
- **Color**: beige
- **Resin**: 1K-Epoxy
- **Filler**: Kreide

**UNCURED PROPERTIES**
- **Viscosity (Brookfield LVT/25 °C) [mPa·s]**
  - PE-Norm P001: 30000 to 45000
  - PE-Norm P050: > 100
  - PE-Norm P003: approx. 1.37
- **Flash point [°C]**
- **Density [g/cm³]**

**Thermal Curing**
- 180 minutes at 80 °C
- 15 minutes at 100 °C
- 5 minutes at 130 °C

**CURED PROPERTIES**
- **Temperature Resistance [°C]**
- **Hardness [Shore D]**
- **Shrinkage [Vol-%]**
- **Water Absorption [mass-%]**
- **Tg [°C] (DSC)**
- **CTE [ppm/K]**
- **Thermal conductivity [W/m-K]**

As a rule, the guidelines for application, storage and so on contained in our general Data Sheet on Structalit® apply.

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TECHNICAL DATASHEET

Mechanical Data

Lap Shear Strength (Alu/Alu) [MPa] [PE-Norm P013] approx. 12.1
Lap Shear Strength (Steel/Steel) [MPa] [PE-Norm P013] approx. 29.2
Lap Shear Strength (Messing/Messing) [MPa] [PE-Norm P013] approx. 18.0

Instructions for Use

Surface Preparation

The surfaces to be adhered should be free of dust, oil, fat or any other dirt in order to optimise reproducible bonds. Lightly soiled surfaces can be cleaned with cleaner IP, whereas substrates with low surface energy (such as polyethylene, polypropylene or Teflon) need to be treated physically using plasma or corona to create a suitable working surface.

Application

Our products are delivered ready for use. As soon as you receive them, you can dispense them, be it by hand from the container, or semi/fully automatically. When applied automatically, we recommend the use of air pressure with the appropriate cartridge/piston combination to dispense the adhesive at the required speed and accuracy. If help is required, please consult our engineering department.

Please read the corresponding Safety Data Sheet for this product.