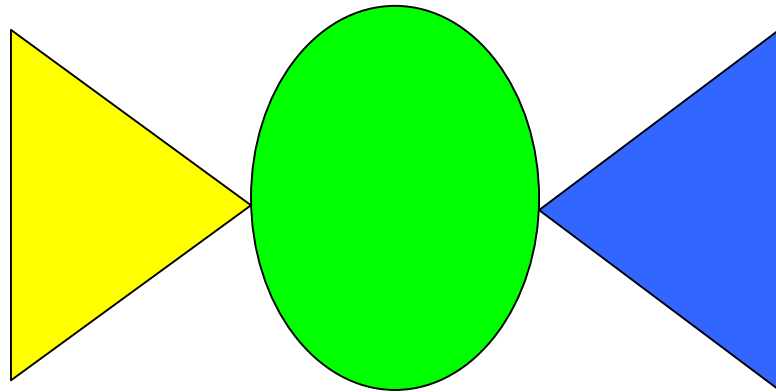


BYLAPOX

Epoxy Adhesives



one- and two-component systems

solvent free

heat resistant

chemical resistant

vibration proof

room temperature curing

Bylapox Type	No. of Comp.	Mixing Ratio	Application	Viscosity	Pot Life	Shelf Life
5 min EP	2	1 : 1	general purpose	medium	rapid cure	12 months
3125	2	1 : 1	metals, plastics, high temperature	medium	medium	12 months
7235	2	2 : 1	medical use	low	long	12 months
7240	2	2 : 1	medical use	medium	long	12 months
7285	2	2 : 1	general purpose	low	medium	12 months
2325	2	1 : 1	general purpose, metals	medium	medium	12 months
OP-32	1	----	metals, activation temp. 150°C	high	heat curing	6 months
OP-95	1	----	metals, activation temp. 95°C	low	heat curing	4 months

BYLAPOX 5 MIN EP

Type	Fast curing epoxy-system, 5 minutes
Application	Bonding of metals, wood, many plastics, china, etc.
Mixing ratio	1 : 1
Density	1,1 g/ml
Viscosity at 25°C	Part <A>: max. 9.000 mPas, Part : max. 14.000 mPas
Pot life	2 - 3 minutes
Shelf life at RT	1 year
Containers	PE bottles 100 ml each Bylamix 2K50 with 50 ml (25 ml/component) Bylamix 2K400 with 400 ml (200 ml/component) drums with 25 kg drums with 200 kg

Tensile shear strength DIN 53283 on steel

Curing time	Strength [N/mm ²]
10 min	1
15 min	5
30 min	11
1 h	13
4 h	15
3 days	25

Above stated instructions are indicative only and no responsibility can be assumed. We recommend to check suitability of our products for your purpose by doing tests on your own.

BYLAPOX 3125 (A+B)

Description

Bylapox 3125 (A+B) is a solvent free, two part epoxide-system modified with rubber for bonding especially for bonding stainless steel and problematic plastics..

Other materials: Steel, aluminium, copper, brass, many plastics, china, wood, etc.

Technical Data

	A	B
Colour index [Gardner]	< 6	< 12
Density [g/ml]	1,16	0,98
Epoxy equivalent [g/Equ.]	206	
Amine equivalent [g/Equ.]		160
Dry content [%]	100	100
Mixing proportion by volume	1 : 1 by volume, 1 : 0,8 by weight	
Viscosity of mixture	c. 20.000 mPas	
Pot life at room temperature	30 ~ 45 min	
Final strength at RT.	after c. 20 hours	
Tensile-shear strength [N/mm ²] Steel/Steel		
Curing at RT	22	
Curing at 120°C, 1 hour	40	
Security warnings	irritating	

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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BYLAPOX 7235 A + B

Description

7235 A + B is a solvent free, two part epoxy-system characterised by low viscosity and long pot life.

It has been developed for bonding small parts – bonding needles into hubs for syringes and similar – and has excellent adhesion to steel and glass.

Technical Data

	A	B
Appearance	white	ruddy.brown
Density [g/ml]	1,17	0,94
Dry content [%]	100	100
Mixing proportion by weight	2	1
Viscosity of mixture	400 - 700 mPas	
Pot life at room temperature	c. 5 hours	
Final strength at RT.	after c. 48 hours	
Tensile-shear strength [N/mm ²] Steel/Steel Hardening at RT. Hardening at 120°C, 1 hour	18 31	
Shelf life	1 year in original containers at 20° C	
Before mixing with part B	Please stir part <A>	
Security warnings	irritating	

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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BYLAPOX 7240 A+B

Description

7240 A + B is a solvent free, two part epoxy-system characterised by medium viscosity and long pot life.

It has been developed for bonding small parts

Technical Data

	A	B
Chemical Base	Modified Epoxy Resins based on Bisphenol A	Polyaminoamide
Appearance	slightly yellow	red-brown
Density [g/ml]	1,17	0,98
Viscosity [mPas]	1000	450 at 70°C
Epoxy equivalent [g/Equ.]	185	
Amine equivalent [g/Equ.]		110
Dry content [%]	100	100
Mixing proportion by weight	2	1
Pot life at room temperature	90 ~ 120 minutes	
Final strength at RT.	14 ~ 16 hours	
Tensile-shear strength [N/mm ²] Steel/Steel Hardening at RT. Hardening at 120°C, 1 hour	18 31	
Shelf life	1 year in original containers at 20° C	
Security warnings	irritating	

Health and Safety



The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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BYLAPOX 7285 A + B

Description

7285 A + B is a solvent free, two part epoxy-system characterised by low viscosity and long pot life.

Technical Data

	A	B
Appearance	colourless, slightly yellow	colourless, slightly yellow
Density [g/ml]	1,17	1,04
Dry content [%]	100	100
Mixing proportion by weight	2	1
Viscosity of mixture	400 - 700 mPas	
Pot life at room temperature	30 ~ 60 minutes	
Final strength at RT.	8 ~ 12 hours	
Tensile-shear strength [N/mm ²] Steel/Steel Hardening at RT. Hardening at 120°C, 1 hour	18 31	
Shelf life	1 year in original containers at 20° C	
Security warnings	irritating	

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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BYLAPOX 2325

Description

Bylapox 2325 (A+B) is a solvent free, two part epoxide-system characterised by medium viscosity and normal pot life.

It has been developed for bonding steel, aluminium, copper, brass, many plastics, china, wood, etc.

Technical Data

	A	B
Appearance	colourless	red-brown
Density [g/ml]	1,14	0,98
Epoxy equivalent [g/Equ.]	226 ~ 234	
Amine equivalent [g/Equ.]		120 ~ 160
Dry content [%]	100	100
Mixing proportion by volume	1	1
Viscosity of mixture	35 ~ 40 Pas	
Pot life at room temperature	60 ~ 90 min	
Final strength at RT.	after c. 12 hours	
Tensile-shear strength		
Wood [N/mm ²]	12	
Metals [N/mm ²]	32	
Security warnings	irritating	

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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Bylapox OP-32

Description

Bylapox OP-32 is a solvent free, **one part** epoxy-system characterised by high viscosity and rel. low activation temperature.

It has been developed for bonding metals and shows high impact resistance and heat resistance.

Technical Data

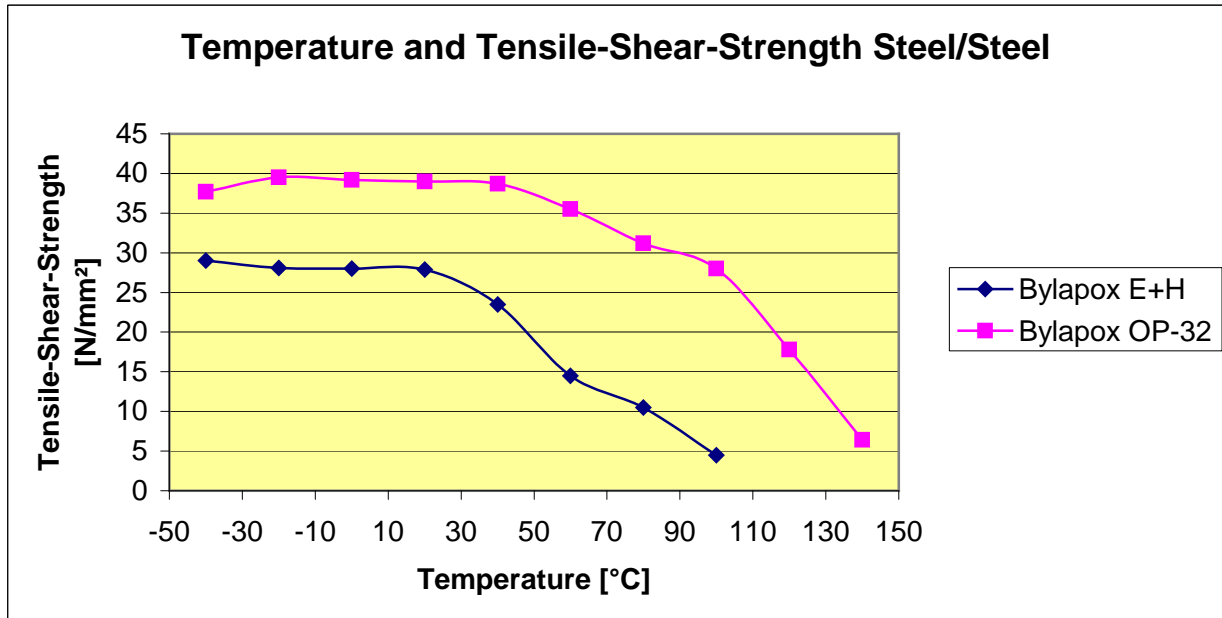
Appearance	uncured: creamy white, cured: white
Density [g/ml]	1,17
Dry content [%]	100
Viscosity [mPas]	paste
Gel point at 180° C	ca. 5 Minuten
Curing (minimum conditions)	30 minutes bei 120° C 15 minutes bei 150° C 10 minutes bei 180° C
Tensile-Shear-Strength [N/mm ²]	look figure on next page
Lagerfähigkeit	6 Monate bei 20° C, 9 Monate bei 4° C
Security warnings	irritating

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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BYLAPOX OP-32



Preparation: Steel grinded and cleaned

Curing of Bylapox E+H: 7 days at room temperature
1 hour at 100° C

Curing of Bylapox OP-32: 30 minutes at 150° C

Above stated instructions are indicative only and no responsibility can be assumed. We recommend to check suitability of our products for your purpose by doing tests on your own.

Bylapox OP-95

Description

Bylapox OP-95 is a solvent free, **one part** epoxy-system characterised by low viscosity and low activation temperature.

It has been developed for bonding small parts, especially to bond needles into hubs for cannulas.

Technical Data

Appearance	uncured: creamy white, cured: white
Density [g/ml]	1,1
Viscosity [mPas]	1.000 ~ 2.000
Dry content [%]	100
Gel point at 75° C (1,0 g)	15 minutes
Cure speed at 95° C	< 30 min
Tensile strength [N]	> 80 Hub/Needle (0,8 mm)
Final strength at RT.	14 ~ 16 hours
Shelf life	3 months at 20° C, 6 months at 4° C
Security warnings	irritating

Health and Safety

The material may cause allergic reaction of skin. Therefore contact to skin should be avoided. If there is contact to the eyes spoil with a sufficient amount of water and attend a physician. Take care for good ventilation, do not inhale vapour!

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