

LHVHVHLWLH3URGXNWVVDPPHVVXQVWVUJLH9HUVZGXQDQHUELQXQLWZLWUHUCLLVHQQHU*HEUDXFKVDZLVXQ
 EHVWLPPWQOHDWHZUGHQXVWVSLFKHP3URGXNWLRODPDWHULDOHUVVWHOOWXQVWHOQHHLB3URGXNWVSHJLNDWLRQDU

0,68+(181+5+81*

(,*(168+57	(,167	Spabond™ 345	68(15b57(5	*(0,68(6687(0	TEST METHOD(
Erscheinungsbild - Farbe	Beschreibung	Gelb	Schwarz	Dunkel Grau	-
Erscheinungsbild - Form	Beschreibung	Thixotropische Paste			-
Mischungsverhältnis nach Gewicht	Teile nach Gewicht	100	48	-	-
Mischungsverhältnis nach Volumen	Teile nach Volumen	100	50	-	-
Dichte bei 21 °C	g/cm ³	1.17	1.08	1.14	Archimedisches

VISKOSITÄT DER KOMPONENTEN UND DES GEMISCHTEN SYSTEMS

EIGENSCHAFT	EINHEIT	15 °C	20 °C	25 °C	30 °C	TEST METHODE
Spabond™ 345 Harz Viskosität	P	1250	1050	950	700	-
Spabond™ 345 Schneller Härter (Schwarz) Viskosität	P	450	300	200	150	-
Anfangsviskosität des gemischten Systems	P	520	420	340	270	-
Gelierzeit (150 g, in Wasser gemischt)	Std:min	00:39	00:28	00:20	00:15	-
Einspannzeit* (Zeit bis 2kN Spaltfestigkeit)	Std:min	07:50	05:30	03:55	02:45	BS 5350 Part C1
XUFKELHXZGHUVWDQ	mm	17	16	15	14	-

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0(&+\$.68+(,*(168+57(1	SYMBOL	(,1+(,7	28 78(1% 21°C	16 6781(1% 50°C**	5 6781(1%70°C*	* TEST STANDARD
5LZLOGXQXIGWDE	F _{cleavage}	kN	12	12	13	BS 5350 Part C1
hEHUODSSHQH6FKUXQDQWDE	τ _{steel}	MPa	37	37	42	BS 5350 Part C5

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0(&+\$.68+(,*(168+57(1	SYMBOL	(,1+(,7	28 78(1%21°C	16 6781(1%50°C*	5 6781(1%70°C*	* TEST STANDARD
*ODEZHUDWHPHUDWXU	T _{g1}	°C	57	68	76	ISO 6721 (DMA)
XMKUWHWHLFWH	ρ _{ply}	g/cm ³	-	-	1.17	Archimedisches
9ROXPHWULVFKH6FKUXPSIXQ		%	-	-	3.4	Archimedisches

Die Verarbeitungszeit hängt stark von den Umgebungsbedingungen ab und sollte als ungefähre Richtlinie für alle Spabond™ 345-Systeme verwendet werden **Anfangshärtung von 24 Stunden bei 21°C

SPABOND™ 345 & SLOW HARDENER

This 1 page product summary is intended for use in conjunction with further advice provided under the Instructions for Use section. All data has been generated from typical production material and does not constitute a product specification.

MIXING AND HANDLING

PROPERTY	UNITS	Spabond™ 345 RESIN	SLOW HARDENER	MIXED SYSTEM	TEST METHOD
Appearance - colour	Description	Yellow	Red	Pink	-
Appearance - form	Description	Thixotropic Paste			-
Mix ratio by weight	Parts by weight	100	48		-
Mix ratio by volume	Parts by volume	100	50	-	-
Density at 21 °C	g/cm ³	1.17	1.10	1.15	Archimedes

COMPONENT & MIXED SYSTEM VISCOSITY

PROPERTY	UNITS	15 °C	20 °C	25 °C	30 °C	TEST METHOD
Spabond™ 345 Resin Viscosity	P	1250	1050	950	700	-
Spabond™ 345 Slow Hardener Viscosity	P	1250	850	500	300	-
Initial Mixed System Viscosity	P	1060	870	750	640	-
Gel Time (150 g, mixed in water)	hrs:min	05:15	03:50	02:48	02:00	-
Clamp Time* (time to 2kN cleavage strength)	hrs:min	16:32	12:10	09:44	06:24	BS 5350 Part C1
Sag resistance*	mm	30	28	26	24	-

ADHESIVE PERFORMANCE

MECHANICAL PROPERTIES	SYMBOL	UNITS	28 DAYS AT 21 °C	16 HOURS AT 50 °C**	5 HOURS AT 70 °C**	TEST STANDARD
Cleavage on steel	F _{cleavage}	kN	12	16	15	BS 5350 Part C1
Lap shear on steel	τ _{steel}	MPa	38	39	40	BS 5350 Part C5

CURED MECHANICAL AND THERMAL PROPERTIES

MECHANICAL PROPERTIES	SYMBOL	UNITS	28 DAYS AT 21 °C	16 HOURS AT 50 °C**	5 HOURS AT 70 °C**	TEST STANDARD
Glass Transition Temperature	T _{g1}	°C	56	74	84	ISO 6721 (DMA)
Cured Density	ρ _{ply}	g/cm ³	-	-	1.17	Archimedes
Volumetric Shrinkage		%	-	-	5.7	Archimedes

*working time properties are highly subjective to ambient conditions and should be used an approximate guideline for all Spabond™ 345 systems

**initial cure of 24 hours at 21 °C

SPABOND™ 345 EXTRA-SLOW HARDENER

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MIXING AND HANDLING

PROPERTY	UNITS	Spabond™ 345 RESIN	X-SLOW HARDENER	MIXED SYSTEM	TEST METHOD
Appearance - colour	Description	Yellow	Blue	Green	-
Appearance - form	Description	Thixotropic Paste			-
Mix ratio by weight	Parts by weight	100	48		-
Mix ratio by volume	Parts by volume	100	50	-	-
Density at 21 °C	g/cm ³	1.17	1.01	1.12	Archimedes

COMPONENT & MIXED SYSTEM VISCOSITY

PROPERTY	UNITS	15°C	20°C	25°C	30°C	TEST METHOD
Spabond™ 345 Resin Viscosity	P	1250	1050	950	700	-
Spabond™ 345 Extra-Slow Hardener Viscosity	P	120	70	50	40	-
Initial Mixed System Viscosity	P	740	440	360	240	-
Gel Time (150 g, mixed in water)	hrs:min	08:27	06:00	04:10	02:55	-
Clamp Time* (time to 2kN cleavage strength)	hrs:min	26:04	19:25	14:19	10:42	BS 5350 Part C1
Sag resistance*	mm	30	28	26	24	-

ADHESIVE PERFORMANCE

MECHANICAL PROPERTIES	SYMBOL	UNITS	28 DAYS AT 21°C	16 HOURS AT 50°C**	5 HOURS AT 70°C**	TEST STANDARD
Cleavage on steel	F _{cleavage}	kN	11	13	13	BS 5350 Part C1
Lap shear on steel	τ _{steel}	MPa	29	37	36	BS 5350 Part C5

CURED MECHANICAL AND THERMAL PROPERTIES

MECHANICAL PROPERTIES	SYMBOL	UNITS	28 DAYS AT 21°C	16 HOURS AT 50°C**	5 HOURS AT 70°C**	TEST STANDARD
Glass Transition Temperature	T _{g1}	°C	56	71	79	ISO 6721 (DMA)
Cured Density	ρ _{ply}	g/cm ³			1.13	Archimedes
Volumetric Shrinkage		%			0.9	Archimedes

*working time properties are highly subjective to ambient conditions and should be used as an approximate guideline for all Spabond™ 345 systems

**initial cure of 24 hours at 21°C

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TECHNICAL CONTACT INFORMATION

For all other enquiries such as technical queries:

Telephone + 44 1983 828000 (08:30 – 17:00 GMT)
Email technical.support@gurit.com

24-HOUR CHEMICAL EMERGENCY NUMBER

For advice on chemical emergencies, spillages, fires or exposures:

Europe +44 1273 289451
Americas +1 646 844 7309
APAC +65 3158 1412

E customer.support@gurit.com

W www.gurit.com