



Technical Sheet

STRUCTURAL ADHESIVE

Xepox 40.3/5 Capillary

Standard for

Difficult spaces and conditions in large structures.

Easily pourable, even with pressurized equipment

Moderate temperatures.

General		Polymeric synthetic binder, formulated as a structural adhesive with an epoxy base, bicomponent, RTC.
Characteristics		Very fluid liquid, easily pourable, with solid loads - filler - average reactivity, good wetting against materials of different nature - wood, iron, steel, concrete, etc.; after polymerization, elevated adhesion and cohesion values.
Employment		Bonding - for casting - of connecting elements between preformed metal and wood/cls structures.
Application		For casting or injection with suitable equipment. 1 ÷ 2 mm thickness. Application temperature of 10 ÷ 35 °C and max relative humidity of 90 %.
Provision	Canisters	
		Component a 3.33 liter or 2 liter canister Component b 1.67 liter or 1 liter canister
Conservation and expiration		The two separated components have a shelf life of at least 12 months, but they must be stored at moderate temperatures.

Test characteristic	Reference regulation	Unit of measure	Values
Specific weight at 23 ± 2 °C	ASTM D 792-66	kg/dm ³	ca 1.40
Stoichiometric ratio by volume	-	A : B =	100 : 50
Pot life at 23 ± 2 °C for 150 cc	ERL 13-70	Minutes	50 ÷ 60
Working time of the mixture at 23 ± 2 °C	ERL 13-70	Minutes	25 ÷ 30
Coefficient of linear thermal expansion	ASTM D 696	°C ⁻¹	ca 7.5x10 ⁻⁵
Max glass transition	ASTM D 3418	°C	55
Compression breakage unit load	ASTM D 695	MPa	≥ 75
Flexion-traction breakage unit load	ASTM D 790	MPa	≥ 45
Traction breakage unit load	ASTM D 638	MPa	≥ 30
Cutting breakage unit load	ASTM D 732	MPa	≥ 45
Elastic modulus for compression	ASTM D 695	MPa	≥ 6500
Wood compliance (spruce) by extension	ASTM D 1870	Type of break	100% wood cohesion
Wood/iron flexion-traction breakage unit load	ASTM D 1870	Type of break	100% wood cohesion
Shrinkage	ASTM D 2566	%	ca 0.15 x 10 ⁻²

The test values are obtained in the laboratory and are indicative of material usage, but do not constitute a guarantee.

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Application
outline

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K	how it's composed	2 components <table><tr><td>component A</td><td>3.33</td><td>2</td><td>Litres</td></tr><tr><td>component B</td><td>1.67</td><td>1</td><td>Litres</td></tr></table>	component A	3.33	2	Litres	component B	1.67	1	Litres
component A	3.33	2	Litres							
component B	1.67	1	Litres							
γ	what is its mixing ratio	(by volume) A : B = 100 : 50 ⇒ components have been packaged in pre-measured, ready-for-use quantities								
👍	where it is applied	For the gluing of parts connecting preformed metal and wood/concrete structures; in the creation of large joints with metallic concealed point joints between substantially large components. For the filling of voids smaller than 2 mm.								
§	how to prepare the structure	• remove any dust with an air blast or industrial vacuum • remove grease and/or brush the metal • dry if wet								
B	what equipment	Blend with a spatula after having thoroughly mixed the two separate parts. Alternatively, use utensils with a double helicoid mixer. Pour or inject into a high pressure electric pump.								
≈	what thicknesses	approximately 1 ÷ 2 mm								
⌚	hardening time	Differs according to environmental temperatures. Use is not however recommended in environments with permanent temperatures below 10°C.								
O	how to protect yourself	It is important to handle products with necessary precaution, wearing the proper protective gear.								
#	where to dispose of waste	Do not litter residue or empty containers but dispose of them in accordance with current regulations.								

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