



Technical Sheet

STRUCTURAL ADHESIVE

Xepox 235.4 Beam

Standard for

Anchorage-conjunctions.

Injectable with biaxial extruder

2÷6 mm

Moderate temperatures.

General		Polymeric synthetic binder, formulated as a structural adhesive with an epoxy base, bicomponent, RTC.
Characteristics		Thixotropic liquid, with solid loads - filler -, of average reactivity, good wetting against materials of different nature - wood, iron, steel, concrete, etc.; after polymerization, elevated adhesion and cohesion values.
Employment		For the bonding of structural elements in cls, brick, wood, metal. Specific for the fixing of anchors in reinforced cement and wood and for the insertion of connectors in cracked beams.
Application		For injection with 2:1 bicomponent biaxial extruder. 2 ÷ 6 mm thickness. Application temperature of 5 ÷ 40 °C and max relative humidity of 90 %.
Provision	Cartridge 	Biaxial type: component a + b 400 ml
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 2.00
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 10x10 ⁻⁵
Max glass transition	ASTM D3418	°C	64
Compression breakage unit load	ASTM D 695	MPa	≥ 90
Flexion-traction breakage unit load	ASTM D 790	MPa	≥ 45
Traction breakage unit load	ASTM D 638	MPa	≥ 40
Cutting breakage unit load	ASTM D 732	MPa	≥ 45
Elastic modulus for compression	ASTM D 695	MPa	≥ 9000
Wood compliance (spruce) by extension	ASTM D 1870	Type of break	100% wood cohesion
Wood/iron flexion-traction breakage unit load		Type of break	100% wood cohesion
Shrinkage	ASTM D 2566	%	Ca 0.30x10 ⁻³

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

**STRUCTURAL
ADHESIVE**

Xepox 235.4

K	how it's composed	Biaxial bicomponent cartridges with 400 ml disposable mixer
γ	what is its mixing ratio	(by volume) A : B = 100 : 50 <i>⇒ components have been packaged in pre-measured, ready-for-use quantities</i>
	where it is applied	For the gluing of structural components in concrete, brick, wood, metal. Applicable for injections in horizontal and vertical holes.
§	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	Manual or pneumatic Cenci Legno biaxial bicomponent extruder. MC 18 type disposable mixer with holding brace.
≅	what thicknesses	approximately 2 ÷ 6 mm
	hardening time	Differs according to environmental temperatures. Use is not however recommended in environments with permanent temperatures below 5°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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