



Structural Adhesives Ltd

S-106E

Technical Datasheet
Version: 9 26/03/20

Structural heat cured toughened epoxy adhesive, S-106E

S - 106E is a single part, heat cured, epoxy adhesive. It contains an in-built rubber-toughening component to enhance peel strength and impact resistance. It displays high shear strength in many hostile environments. S-106E cures in 30 minutes at 160°C

Applications

S-106E bonds most metals and plastics that are not affected by the curing temperature and so finds applications in the engineering industry.

Instructions

Reference should be made to the Material Safety Data Sheet. The adhesive may be applied by spreading with a trowel, roller or extrusion gun. The adhesive does NOT have any green strength or grab, therefore the articles or assemblies to be bonded must be supported in jigs or clamps until full cure has been reached.

S-106E will bond oil-contaminated surfaces; however, lightly abraded and clean surfaces will achieve the highest results. S-4089M can be used to degrease the substrate surface before bonding.

Properties

Property	S-106E
Appearance	Viscous, white paste
Alternative colours	Black, grey
Specific gravity	1.3
Viscosity, 25°C (poise)	2000
Hardness, Shore D	80-90

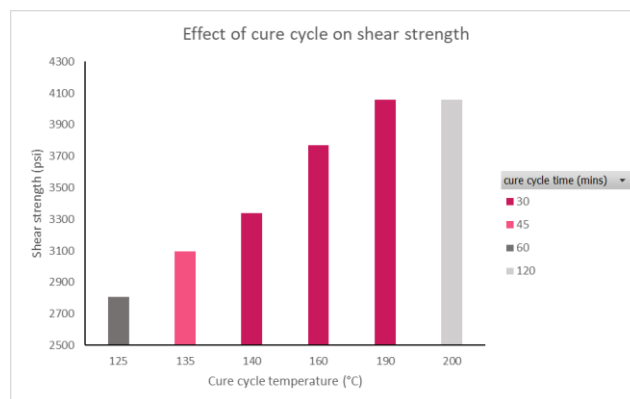
Test results

Peel strength

After curing at 160°C for 30 minutes peel strength is 11 N/mm or 631 bs/inch.

Effect of cure cycle on shear strength

Shear strength on steel 10mm overlap, 25mm wide bond.



Contact Us

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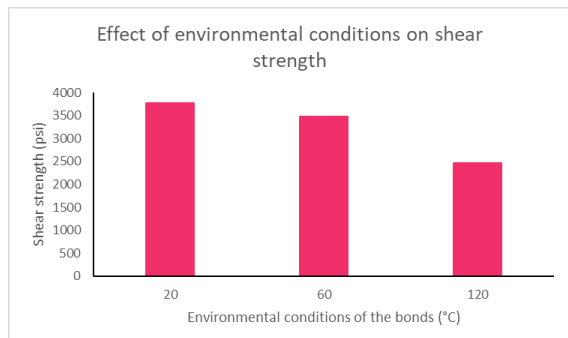
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Hot bond strengths.

Shear strength on steel 10mm overlap, 25mm wide bond.

◆ Packaging

310ml cartridge.

Others by arrangement.

◆ Storage

Store in dry conditions between 5 and 25° C.

◆ Shelf-life

6 months in above conditions.

◆ NOTE

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