



## TECHNICAL DATA SHEET

### **ergo® 1910** (ergo® 1908 resin + ergo® 1909 hardener)

#### **Product - Description**

This **ergo® - grade** is suitable for bonding of metals like aluminum, steel, brass and its alloys as well as ferrite and a wide range of plastics and combinations of those materials.

It is a two-component, good flowing system and cures after mixing into a dry, high-strength and impact resisting polymer film. The best mixture-ratio is 1:1 (volume) and is obtainable without problems by using the common double-cartridges.

#### **Advantages**

- Fast curing system
- High tensile shear strength
- Resists against impacts as well as against peeling
- Good flowing behaviour
- Good gap-filling behaviour up to 0,15 mm
- Free of solvents
- Short fixture times
- Dry surface after short time

#### **Physical Properties (liquid product)**

**Chemical base** : modified acrylic

#### **Viscosity**

Brookfield RVT, Sp.6, 25°C, 20 rpm : 6000 – 8000 mPas (thixotropic)

**Density resin** (ergo® 1908) : 1,04 g/cm<sup>3</sup>

hardener (ergo® 1909) : 1,05 g/cm<sup>3</sup>

**Colour resin** (ergo® 1908) : white

hardener (ergo® 1909) : green

**Shelf life** : 6 month between 2°C – 7°C

#### **Cured product:**

**Tensile strength** (DIN 53504 S2)

after 24 h at 23°C : ~ 36 N/mm<sup>2</sup>

**Elongation @ break** (Din 53504 S2)

after 24 h at 23°C : ~ 8 %



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**tensile shear strength acc. to DIN EN 1465, parts only  
degreased after 24 hours @ 23°C**

<b>aluminum/ aluminum</b>	: > 20 N/mm <sup>2</sup>
<b>steel/ steel</b>	: > 22 N/mm <sup>2</sup>
<b>brass/ brass</b>	: > 20 N/mm <sup>2</sup>
<b>ABS/ ABS</b>	: > 6 N/mm <sup>2</sup> (stripe failed)
<b>PVC, hard/ PVC, hard</b>	: > 3 N/mm <sup>2</sup> (stripe failed)
<b>GFR polyester/ GFR polyester</b>	: > 6 N/mm <sup>2</sup>
<b>GFR epoxy/ GFR epoxy</b>	: > 6 N/mm <sup>2</sup>
<b>Impact resistance</b>	: > 18 kJ/m <sup>2</sup> (steel, sand blasted)
<b>T-Peeling</b>	: > 20 N/cm (steel, sand blasted)
<b>Thermal range</b>	: - 50° C bis + 180° C
<b>Resistance against solvents</b>	: good

## **Curing**

<b>Curing system</b>	: 2-component-system ratio 1:1 (volume)
<b>Potlife</b>	: ~ 2,5 minutes (2g-mixture)
<b>Initial strength</b>	: ~ 10 minutes at 23°C
<b>Final strength</b>	: ~ 12 hours at 23°C

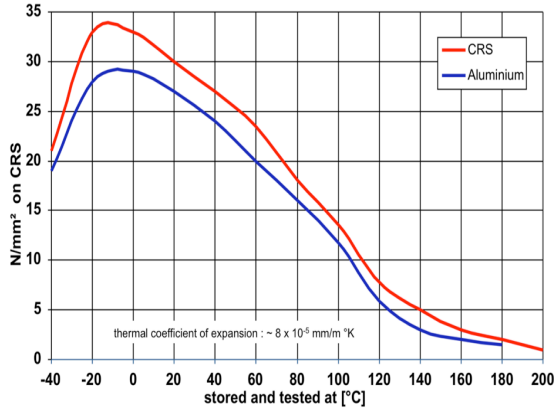
## **How to use the product**

**Resin ergo® 1908** and **hardener ergo® 1909** is normally applied by using the double-cartridge-system with static mixture tube. ATTENTION: Potlife in the tube will be, depending on room-temperature, ~ 2,5 minutes.

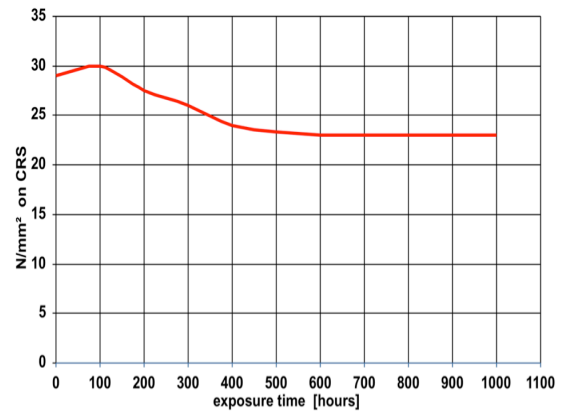
Apply the mixed glue on one part and spread it carefully over the whole bonding area. Fit the parts together and fix them at least as long as the potlife time is, but better 10 minutes. The product may be used also in bead on bead manner. In this case, cure speed and final strength will be on a slightly lower level and has to be checked by the customer in his real application.



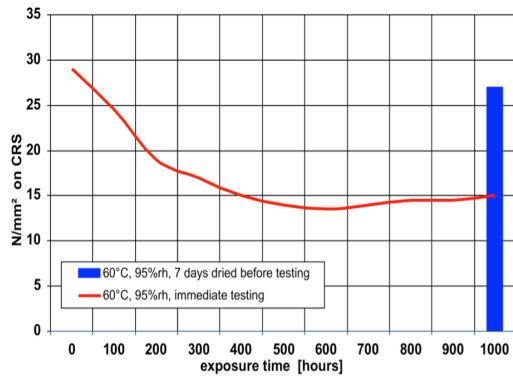
**Tensile shear strength acc. to EN 1465**  
after 24 hours @ mentioned test temperature



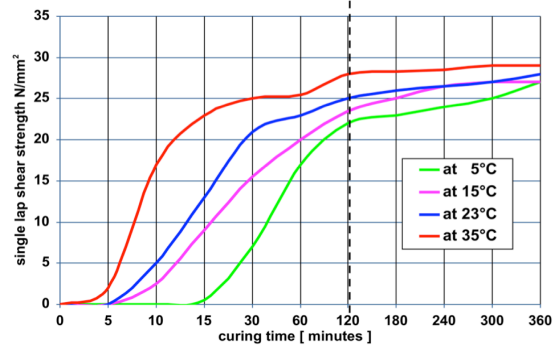
**Tensile shear strength acc. to EN 1465**  
after storage @180°C, tested @ 25°C



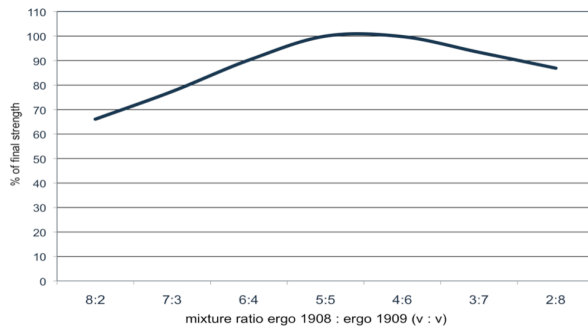
**Tensile shear strength acc. to EN 1465**  
after storage @ 60°C and 95%rh, tested @ 25°C



**Cure-speed dependent on temperature**  
tested acc. to EN 1465 on CRS



**lap shear strength**  
tested acc. to EN 1465 on CRS  
depending on various mixture ratios



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