

# Technical Data Sheet



## K219 5 Minute Gel - Epoxy Adhesive System

### DESCRIPTION:

K219 (Previously known as K2002) is a versatile rapid curing industrial grade epoxy adhesive with good handling properties for many applications

### TYPICAL FEATURES | BENEFITS:

- Simple 1:1 Mix.
- Interior | exterior application.
- User friendly.
- Low temperature cure.
- Short process time.
- Cure above 0°C.
- Bonds to many surfaces.
- Gap filling.
- Very rapid cure.

### PERFORMANCE DATA:

Properties	Values
Minimum application temperature: Air	+0°C
Flash point:	>100°C
Lap Shear Strength:	15
Water Absorption % /24hrs	1.1 - 1.5
Compressive strength:	30 - 40 MPa
Flexural strength:	30 - 40 MPa
Maximum operating temperature:	+40°C
Adhesion Properties to correctly prepared surface:	
~ Composites	Excellent
~ Concrete	Excellent
~ Metal	Excellent
~ Rubber	Very Good
~ Timbers	Excellent
Appearance:	Cream Paste Opalescent paste - strong odour
SG kg/litre:	~ Resin 1.10 ~ Hardener 1.10
Density Kg/Litre -cured:	1.10
Coverage:	Use as required: (0.001m <sup>3</sup> = 1 Litre) e.g. 1 litre covers 1m <sup>2</sup> @ 1mm thick  ~ General Bonding 3m <sup>2</sup> /Litre is normal depending on gap filling required.
Pot Life: (Usable Life) Pot life is based on 100gram samples. Large quantities of mixed epoxy will generate heat and the pot life may be significantly reduced.	0°C– 50%RH Long +15°C– 50%RH 8 minutes +20°C– 50%RH 5 minutes
Cure Time:	0°C –50%RH 8 hours +10°C– 50%RH 4 hours +23°C– 50%RH 2 hours
Clean up:	Wash hands with warm soapy water after any skin contact Solvent HA for tools
NZ Dangerous Goods Class:	~ K219 Refer: SDS
Packaging:	~ K219 Kit 1 kg
Shelf Life:	24 months from date of manufacture. (After this period consult with allnex).

**RECOMMENDED USES:**

- Bonds Concrete | Metals | Timbers | Composites | Some plastics.
- Boat Building.
- Laminates Plywood.
- Flooring adhesive for timber flooring.
- Construction | Industrial uses.
- Golf club heads.
- Flooring adhesive for rubber to concrete or timber.
- Flooring adhesive for most rigid vinyl tiles.

**NOT RECOMMENDED:**

- Application below 0°C air temperature.
- Bonding Polypropylene and polyethylene.
- Application to incorrectly prepared surfaces.

**HEALTH & SAFETY:** Refer safety data sheets (SDS).

- Wear gloves wherever possible.
- Wash hands with warm, soapy water after any skin contact.
- Re-seal all containers tightly.

**SURFACE PREPARATION:**

The surface to be filled/repared must be clean and sound.

Remove all dust, dirt, oil, scale, laitance, paint or any other contaminates.

Concrete: Acid etch | Shot blast | Diamond grind | Needle gun.

Metals: Degrease with Acetone > Abrade with medium grit abrasive paper > Degrease with Acetone again.

Timber: Prepare by way of mechanical sanding using 80 grit paper.

Composites: Composites: Degrease > Mechanically abrade > Degrease.

**MIXING RATIO****K219 Mixing Ratio - By weight**

Element	Value
Resin	1 part
Hardener	1 part

**K219 Mixing Ratio - By volume**

Element	Value
Resin	1 part
Hardener	1 part

*Refer: Cautions Section*

The mix ratio must not be altered.

The mix ratio is the only acceptable formula.

Adding more hardener will make the mix softer and it will be uncured.

Increased hardener levels will result in a weaker product.

**MIXING METHOD:**

Carefully mix the product according to the stated mix ratio.

Mix until uniform and no streakiness is evident.

**APPLICATION METHOD:**

Notched Trowel | Spatula

**General bonding:**

Apply the mixed adhesive to the substrate with a notched trowel or spatula at the recommended spread rate.

Clamp surfaces together for curing period, or hold without movement for required cure period.

**Note**

Work rapidly as the product has a very short pot life.

**CAUTION:**

K219 is a two part epoxy that is mixed in the specified ratio. Only this ratio will produce a hard, non-softening product. Adding more hardener (with the aim of making the product cure faster) will not work and will only result in making the product softer. The more hardener that is added, then the softer it will become. No matter how long it is left, it will never harden.

**Only the stated mix ratio will work and exhibit the stated performance data.**

## OTHER EPOXIES AVAILABLE:

- K36 - Clear Laminating Resin.
- K78 - Crack Repair.
- K80 - Pourable Grout.
- K83 – Machinable Epoxy Grout
- K102 - High Viscosity Mortar.
- K106 - Structural 24 hour Adhesive.
- K125 - Concrete Repair Paste.
- K130 - Control Joint Filler.
- K138- High Strength, Structural Heat Resistant Adhesive.
- K214 - General Purpose Adhesive
- K219- Structural 5 Minute Adhesive.
- K273- Underwater Cure Mortar.
- K2005 - High Peel Strength Structural Adhesive.
- Fairing Cream - Sandable Smoothing Paste.
- Truestik EA - Flexible Adhesive – Multipurpose.

## EPOXY SELECTION:

Refer: Epoxy Selection Chart.

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The logo for Allnex, featuring the word "allnex" in a bold, lowercase, sans-serif font. The letters "a", "l", "l", "n", and "e" are in a dark blue color, while the "x" is in a lighter blue. A horizontal bar with a gradient from purple to green is positioned above the "x".

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