

Applications

Adhesive for ebaboard EP 138
Adhesive for ebaboard EP 139
Adhesive for ebaboard EP 120

Properties

heat resistance	152 °C
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Processing data

Product		Mixture	Resin	Hardener
		ebafix 552	ebafix 552 Harz	ebafix 552 Härter
Colour		yellowish-transparent	yellowish-transparent	yellowish-transparent
Mixing ratio	p.b.w.		100	14
Viscosity at 25 °C	mPas	5000 ± 1000	20000 ± 8000	30 ± 20
Density at 20 °C	g/cm ³	1,15 ± 0,05	1,15 ± 0,05	1,00 ± 0,05
Pot Life	Minutes	20 - 25		
Demoulding time	Hours	16		

Physical data

Properties	Inspect. Requirements	Unit	Value
Flexural strength	EN ISO 178*	MPa	115 ± 15
Flexural modulus	EN ISO 178*	MPa	3275 ± 325
Tensile strength	EN ISO 527*	MPa	85 ± 10
Elongation at tensile strength	EN ISO 527*	%	3,7 ± 0,2
Tensile modulus	EN ISO 527*	MPa	3215 ± 300
Compressive strength	EN 604*	MPa	125 ± 15
Heat deflection temperature HDT	DIN EN ISO 75-1*	°C	152 ± 5
Glass transition TG	DSC	°C	~143
Shore hardness	DIN ISO 48-4*	Shore D	88 ± 3

* based on

Sales units (packages)

adhesive 552 resin, yellow transparent, 0,877 kg tin
adhesive 552 hardener, yellow transparent, 0,123 kg tin
adhesive 552 resin yellow transparent, 4.386 kg bucket
adhesive 552 hardener yellow transparent 0.614 kg bottle

Processing instructions

Material- and processing temperature: between 18 - 25 °C.

Close containers after use.

The mixing ratio of resin and hardener must be adhered to according to the specifications.

Components A and B must be mixed thoroughly.

ebafix should be applied within 5-10 minutes.

We recommend applying ebafix with a fine notched spatula.

Consumption: approx. 500 - 600 g/m²

Resin residues on stirring rods, etc., can be easily cleaned with ebaclean.

After a room-temperature pre-cure of approx. 12-16 hours, the blocks must be heated stepwise in the oven and then held for approx. 10 hours at a minimum of 80 °C.

For higher temperature resistance, we recommend the following post - curing cycles:

8 h at 80 °C: approx. 108 °C HDT B

8 h at 100 °C: approx. 123 °C HDT B

8 h at 120 °C: approx. 141 °C HDT B

8 h at 140 °C: approx. 150 °C HDT B

We recommend heating and cooling rates of max. 5 °C per hour.

For every 100 mm of model thickness, the blocks should be kept at the maximum oven temperature for approx. 1 additional hour.

After cooling, the blocks should remain overnight in the switched-off and closed oven/autoclave until the core has returned to room temperature.

General

ebafix 552 is a temperature-resistant two-component epoxy resin which is particularly well suited for bonding epoxy plates

All specified characteristic values were determined after thermal conditioning at 150 °C for 8 hours.

The pot life was determined in accordance with internal test procedures using a 200 g sample at room temperature (approx. 23 °C).

The demolding times refer to demolding at room temperature.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Please refer to the product labels for the shelf life of the material.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material.

Please refer to the respective safety data sheets

Waste Disposal

The cured materials can be disposed of as household or commercial waste in consultation with the respective competent authority.

Uncured products must be properly disposed of in consultation with the competent authority.

For further questions, our product safety department is at your disposal.

Compliance & Legal

The information and recommendations provided are based on careful evaluation and practical experience. They reflect the state of our knowledge at the time of provision. Updates may be made without notice.

The information is intended as general guidance and does not constitute a warranty of specific characteristics or properties of the product. Due to the wide range of potential applications and processing methods, not all individual use cases can be covered.

The product must be used in accordance with the applicable safety and usage instructions. No liability will be accepted for improper use or application outside the intended purpose.

Unless otherwise agreed, it is the responsibility of the user to independently assess the suitability of the product for the intended application and processing method.

The information provided does not release the user from the obligation to seek individual advice in cases of uncertainty regarding specific applications.

Statutory warranty rights remain unaffected.