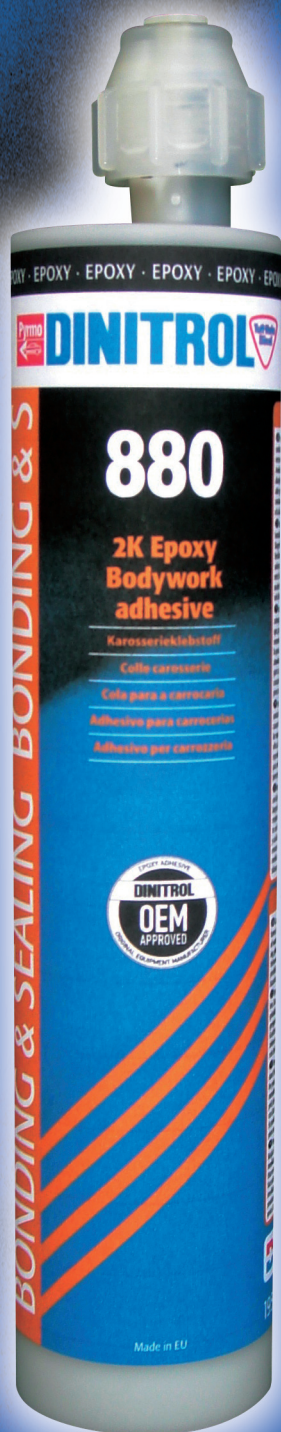


# DINITROL 880

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## 2C Epoxy Bodywork Adhesive



- OEM Approved
- Better adhesion on Metals
- Extended processing time
- Low odor





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## 2C Epoxy Body Work Adhesive

### General description

DINITROL 880 is a 2-component Epoxy adhesive with a high strengths and because of that it can be mainly used for structural bondings for vehicles in cases of repair. With the use of the epoxy adhesive DINITROL 880 the stiffness of the car-body will explicit increase. The further properties of the DINITROL 880 are:

- Excellent adhesion properties on all kind of steel plates, which are used in the automotive industry.
- Very good adhesion on coated steels and also on pretreated aluminium.
- Reconstitution of the stiffness of the car-body.
- Very good resistant against ageing and chemicals.
- Suits also for sealing and protects the steel plate but also the spot welds against corrosion.
- Compatible with other thermally joining technologies.

### Application

The process and application of the DINITROL 880 is made with a 2-component cartridge. (Mixing ratio 2:1 / statical) DINITROL 880 can be cold applied. To reach with the DINITROL 880 the best possible wetting of the substrates, it is necessary that these substrates are stored at least at 15°C.

### Pot life (23°C)

60 min.

### Working time (23°C)

90 min.

### Handling time (23°C)

4 h

### Ready for operations (23°C)

24 h

### Curing conditions

- Ambient temperature
- Thermal acceleration up to 150°C

### Tensile strength

(after 4 hrs./23°C)

0.75 until 1.0 MPa

### Tensile strength

(after 7 days/23°C)

approx. 30 MPa

### Elongation

30%

### Working- and handling recommendations

- The handling of the cartridges can be done with commercial cartridge-guns.
- For a repair application (curing less than 60°C) we recommend to clean ahead the bonding area with DINITROL 582. If the bonding will be made on oily steel plates, adhesion failures can be happen.
- When using the 2-component Epoxy adhesive, confirm correct mixing by extruding a small quantity of both components.
- Under certain circumstances during the storage process a crystallization of the B-component can happen. This special activity of the B-component is reversible just with heating of the cartridge with a temperature of 40° – 50°C. There will be no changes regarding the properties of the product.

### Cleaning

As long as the adhesive DINITROL 880 has not cured, as long it's possible to remove the adhesive with the cleaning agent DINITROL 582.



### Lab-Shear-Strengths after 7 days at 23°C

Steel (1.5 mm)	27.8 MPa
Steel (0.8 mm)	23.7 MPa
Hot dip galvanised Steel (0.7 mm)	12.6 MPa
Galvanised Steel (0.7 mm)	18.5 MPa
Aluminium alloy 6111 (0.9 mm)	11.3 MPa
Aluminium alloy 5052 (0.6 mm)	12.4 MPa
ABS	3.0 MPa
SMC	8.8 MPa

All data recommendations are the result of careful tests by our laboratories. These data can only be considered as recommendations, which correspond to the level of experience today. These data are given in good faith. However, in view of the multiplicity of applications and working methods, we are not in a position to assume any responsibility or obligations derived from the use of our products.