



# EVO-STIK Epoxy Control

**A TWO PART, MULTIPURPOSE EPOXY RESIN ADHESIVE**

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Fact Sheet No.: TDS01665

## YOUR SMART ADVANTAGES

- Extra strong, long lasting bond but repositionable for up to 2 hours
- Can be roughly handled after 16 hours
- Oil resistant

## USES

EVO-STIK Epoxy Control is a solvent free, low odour, two-part repositionable epoxy adhesive. EVO-STIK Control will bond a wide range of materials including metal, wood, masonry, ceramics, glass, leather, rubber, chipboard, concrete, cardboard, fabric and most plastics.

## PRODUCT CHARACTERISTICS

Colour	Resin: Milky Hardener: Amber
Form	Liquid
Specific Gravity	1.1 approx.
Composition	Resin: Epoxy Resin Hardener: Amine Hardener
Product Code	30613669 1 x 6 15ml metal tubes in blisters
Storage/Shelf Life	Store for up to 24 months from date of manufacture when stored in original, unopened packaging under cool, dry conditions within the temperature range of +5°C to +25°C.

## TYPICAL PERFORMANCE DATA (Approx.)

Application Temperature	+5°C to +25°C
Service Temperature	-40°C to +70°C
Flammability	Non-flammable
Setting Time	Approx. 16 hours at 23°C
Sandability	Sandable. Please wear a dust mask
Paintability	Good, but confirm by test. Find sanding helps. Please a wear dust mask.

## DIRECTIONS FOR USE

IMPORTANT: Before using EVO-STIK Epoxy Control refer to the relevant Health & Safety Data Sheet, available at [www.bostik.co.uk](http://www.bostik.co.uk).

## PREPARATION

1. Make sure surfaces are dry, clean and free from dust, dirt and grease. For even better bonding slightly roughen surfaces with a suitable abrasive paper.
2. Following the instructions on the back of the blister card, dispense equal volumes of resin and hardener onto a clean disposable surface or the tray provided. Wearing gloves is recommended. Not mixing according to instructions will weaken the bond. Stir well for 45 seconds with the plastic spatula provided, ensuring a thorough mix. Use within 2 hours. Attach the re-sealable cap to the nozzle as soon as possible.

## APPLICATION

3. Apply the mixed adhesive to both surfaces of the joint and assemble carefully (a layer of adhesive 0.10 to 0.20mm thick will normally impart the greatest lap shear strength to the joint).



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Bostik Limited, Common Road, Stafford, ST16 3EH, UK. Tel: +44 (0) 1785 272625 [www.bostik.co.uk](http://www.bostik.co.uk)

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4. Keep the joint supported until set (using clamps or tape etc.) for at least 6 hours. Allow 16 hours before rough handling/machining. Under normal conditions EVO-STIK Epoxy Control attains its full strength after 24 hours at 23°C. Exact setting time depends on temperatures and the quantities mixed. Setting times may be shorter in hot weather. In cold conditions the rate of curing of the mixed adhesive may be slowed down significantly and weak joints may result. Best results are achieved between 5°C and 25°C.
5. For a perfect finish carefully remove any excess adhesive with a sharp knife before the adhesive has fully hardened.

#### CLEANING

6. Uncured resin/hardener mixtures can be cleaned from tools using cellulose thinners, acetone or methylated spirits, which is more readily available. Solvents must always be handled with due care as they may be hazardous or flammable.
7. Please note the solvents may attack some rubbers, plastics, painted surfaces, fabrics etc. Bear this in mind if intending to use solvent to remove excess adhesive, and carry out a preliminary test first.
8. Cured adhesive residues can usually be dissolved from tools by soaking in commercial paint stripper. Refer to the paint stripper manufacturer's instructions for use and safe handling. Assess a small trial area before general work.
9. The adhesive may be removed from the skin using a suitable proprietary hand cleaner. Contact with the skin should however be avoided. Do not use solvents in contact with the skin. Always open and use adhesive products over a protected surface, and avoid contact with clothing.

#### PRECAUTIONS IN USE

Do not use EVO-STIK Epoxy Control to repair or make items that will contain food or drink. Not recommended for bonding polyolefins (e.g. polythene or polypropylene). Thorough mixing is the key to getting a good cured product. Simply stirring leaves unmixed materials at the edges. Always fold in from edges, and then re-stir. Cured adhesive may slightly yellow if exposed to sunlight for long periods, even through windows. Not suitable for bonding oven doors or car mirrors.

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit [www.bostik.co.uk](http://www.bostik.co.uk) for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK Epoxy Control, available at [www.bostik.co.uk](http://www.bostik.co.uk).

BOSTIK HOTLINE

Smart help +44 (0) 1785 272625



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Sales	Tel: 0844 371 1192	Fax: 01785 241818	<a href="mailto:customer.service@bostik.com">customer.service@bostik.com</a>
Technical Advice	Tel: 0844 371 1197	Fax: 01785 272867	<a href="mailto:technical.service@bostik.com">technical.service@bostik.com</a>
Technical Data & COSHH (MSDS) Data Sheets	Tel: 01785 272625	Fax: 01785 212962	<a href="mailto:stafford.gatehouse@bostik.com">stafford.gatehouse@bostik.com</a>



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