

OPT.PBX195

# OPTIMA 195ML PANEL BONDER ADHESIVE

## Technical Data Sheet

### PRODUCT DESCRIPTION

Optima Panel Bonder Adhesive is a two-component structural epoxy adhesive system intended for use in metal and composite panel bonding.

### FEATURES AND BENEFITS:

- Room Temperature curing, heat acceleration possible
- Bond line thickness is controlled by 0,25mm glass beads
- Withstands automotive e-coat, powder prime, and paint oven temperatures up to 230°C
- Spot-weldable
- Excellent corrosion protection

### TYPICAL CURE CHARACTERISTICS:

	Temperature	Time
Open Time	@ 23°C	60 min
Working Time	@ 23°C	90 min
Handling time	@ 23°C	4 hours
Full cure	@ 23°C	24 hours

### APPLICATION GUIDE:

Cure	Ambient or heat accelerated cure (max 150°C)
Optimum Bondline Thickness	0,25mm (glass bead incorporated)
Paint Bake	up to 230°C
Gap Filling	Very Good
Sag Resistance	For vertical applications
Consumption, 1/4" Diameter Round Bead	app 35g / m Consumption, 1/2"
Diameter Round Bead	app 141g / m

### SURFACE PREPERATION:

Substrate	Surface preparation – Ambient Cure	Surface preparation – Heat Cure
Metal	Abrasion & degreasing	Abrasion & degreasing
Composite (SMC, RTM, CFRP)	Abrasion	Solvent wipe

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**PPE:** Always wear appropriate PPE in line with your Risk assessment & COSHH assessment policy for using this product

**HEALTH & SAFETY:** For Health and Safety information please refer to the material Safety Data Sheet (SDS).

**STORAGE:** Store between +15°C and +32°C

The packaging must be protected from direct sunlight and heat.

After dispense the used mixer should be left attached to the cartridge to ensure sealing from humidity.

**SHELF LIFE:** 2 years in the unopened original packaging.

**PACKAGING:** 195ml cartridge

**DISCLAIMER**

All statements, technical information and recommendations are based on tests we believe to be reliable but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

**For Professional use only**

These products are for professional use only and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

**Optima Products**, Newberry House, Michigan Drive, Tongwell,  
Milton Keynes, Buckinghamshire, MK15 8HQ  
**Tel:** 01908 611117 **Email:** [Optimaproducts@LKQCoatings.com](mailto:Optimaproducts@LKQCoatings.com)