



RAZON

Razon Bond – 40 (Resin & Hardner)

Two pack, ambient curing, chemical- water- oil resistant, air drying solventless epoxy mortar imparts very high bond strength to metals and non metallic substrates, and exhibit good thermal shock resistance; such properties best describe the epoxy adhesive “P.A.Bond-40”. It also has excellent electrical resistance properties.

Features of Razon Bond 40 are:-

- 1) It is resistant to saline environment & mild acids alkalies, solvents, oils and most chemicals.
- 2) Exhibits excellent electrical resistance.
- 3) Great bonding strength.
- 4) Solvent Free & Non Shrink
- 5) Withstands thermal shock.
- 6) High compressive and tensile shear strength.
- 7) Can be easily applied horizontal, vertical and overhead surfaces due to its thixotropic nature.
- 8) Good pot life.
- 9) Mixing proportion of resin & hardner is 1:1, which eliminates erroneous proportioning

Method of use:

The substrate to receive the adhesive must be thoroughly cleaned. Surface oil / grease must be removed using a suitable de-greaser, and surface must be cleaned with acetone/ trichloroethylene.

It is vital that appropriate surface roughing with emery paper is done which improves the bond

In a clean receptacle thoroughly mix the Resin & Hardner in the proportion of 1:1. A thixotropic paste will be obtained, which is ready for use.

For bonding application:-

Use a spatula, or painters knife to apply the adhesive on both faces to be adhered. A thickness of upto 0.5 mm is sufficient to provide a good bond strength. Apply an even pressure to hold the joint and ensure proper contact of the faces to be bonded.

For high strength applications it is better to maintain a positive pressure on the joint upto 24 hours.

For Gap filling applications:-

Use a spatula, or painters knife to push the prepared Razon bond-40 into the gap. Try pushing in excess material to ensure contact between the adhesive and substrates.

For a smooth finish dip the spatula in a solution of Water + few drops of liquid handwash and swipe on the adhesive’s surface.

Curing:-

Razon Bond-40 sets within 24 hours at ambient temperature. It is fully cured at 10 days.

Characteristics of Razon Bond -40

PARTICULARS	PERFORMANCE
Mix Proportion	1:1 - Resin : Hardner by wt.
Mix Density	1.65 gms/ltr
Viscosity after mixing	20,000 – 30,000 mPas
Pot Life	60 mins at 30 ⁰ C
Final cure	10 days
Shore D Hardness	80
Compressive strength	60-70 MPa at 10 days
Tensile Strenght	20-25 MPa in 10 days
Lap shear Strength	> 125 kg / cm ² @ 24 hours
Coefficient of thermal expansion	5.0 x 10 ⁻⁵ per ⁰ C 10 ⁰ – 40 ⁰ C
Volume Change	Nil, non shrink hardening

Applications: -

- 1) Industrial applications
- 2) Sealing of rigid joints/ voids.
- 3) High performance joints

Compatible Substrates as a adhesive:-

Aluminum, Steel, Iron, Glass
 Concrete or cementitious mortars
 Plasters/ mortars/ Blocks/ Bricks etc
 Wood
 Polyester /Fibre-epoxy
 Natural Stones- (rough or polished)

PRODUCT – DATA	
Appearance	Creamy Paste
Color	Resin:- Dark Grey Hardner:- White Mixed:- Grey
Density	Mixed approx 1.65 gms/ltr
Mixing ratio	As provided in factory weighed containers. 1 :1 parts by weight
Pot life after mixing	0.5 to 4 hours depending on temperatures, lower pot life at higher temperature & higher pot life at low temperature.
Flash Point	> 100 ⁰ C for both Resin and Hardner
Shelf life	24 months in their sealed original containers. Keep away from sunlight
Saftey	Use relevant PPE during use of any chemicals and this Product. Use Gloves while handling the resin and or hardner and or mixed system. In case of direct contact it must be washed off with soap and water immediately, incase of contact with eyes, wash immediately with plenty of water.
Spillage	In case of spills, use a shovel to collect the spilled material. Dispose the spilled material in a suitable closed container. Do not discard the product through the sewage system. Disposal of any chemical must always be in accordance with federal, state or local regulations, as applicable.



RAZON ENGINEERING COMPANY PRIVATE LIMITED

660, Taboot Street, P.O.Box No.49, Pune-411001 [India] Website: www.razonengg.com
Ph: +91-20-2613 0791, +91-20-2613 2217, Tele`fax: +91-20- 2613 0017 E-mail: razonengg@gmail.com,

AN ISO 9001:2008 ACCREDITED MANUFACTURER

It is strongly recommended that site trials be conducted using site conditions and available raw materials to evaluate the product. Since site materials and conditions are beyond our control and since above suggestions and recommendations are based on our site trials and laboratory product evaluation & trials, and since methods of use at site are beyond our control. Hence, no guarantee can either be implied or enforceable