



Technical Data Sheet

NM Lim 623

Utg: 2002-05-15

Ers: 2017-12-19

Rev: 2021-09-09

General Description

NM Lim 623 is a two component solvent free epoxy adhesive optimized for gluing and priming of stainless steel.

Applications

NM Lim 623 is specially developed for a good adhesion to materials with low surface energy such as stainless steel

NM Lim 623 is also recommended when gluing carbon fibre parts and gluing to concrete.

Surface Preparation

Surfaces to be glued must be absolutely free from oil, dust, chemicals, etc. Treated and degreased surfaces must not be touched with the fingers. Gluing must be done as soon as possible after finishing.

Blasting is recommended.

Processing Instructions

NM Lim 623 is thixotropic and can be applied as a string. It does not flow during curing.

For higher thixotropy, **NM Tix 150** is recommended.

Curing can take place at an elevated temperature. At +70°C/158°F the curing time is approximately 60 minutes.

Typical Properties

Resin NM Lim 623 A
Hardener NM Härdare 623 B

Mixing ratio:

Resin - Hardener 100 – 50 by weight

Density: 1070 kg/m³
Viscosity at 25°C / 77°F: Thixotropic
Pot life 100g 20°C / 68°F: about 60 min

Flexural strength [ISO 178]: 31 MPa
E-modulus, bend [ISO 178]: 2.9 GPa
T_G, 1 h 70°C / 158°F: 44°C / 111°F
T_G, 7 d, RT: 46°C / 115°F
Hardness, Buchholz: 64.5^{*1}

Adhesion to stainless steel:

Blasted: 8.4 MPa^{*1}
Blasted: 9.0 MPa^{*1}
Washed: 6.4 MPa^{*1}
Grinded: 8.0 MPa

Adhesion to concrete

Grinded: 9.0 MPa^{*2}

Tear resistance: 7 N/nm^{*1}

Colour: Light yellow

Normal packaging: 1.2 kg

Cleaning solvent: Acetone

^{*1} Curing time 1 hour at +70°C / 158°F.

^{*2} Concrete fails.

Flexural strength and E-modulus according to ISO 178

T_G measured with DSC 20K/min

Tear resistance according to DIN 53 515

Hardness according to SS EN 2815:1998

Disclaimer

This product's technical specifications are developed by experience in field and laboratory by us.

The curing time is seven days at +23°C and 50 % RH.

We reserve the right to change products as well as data. Current data sheets are available at our website and with us. We cannot assume responsibility for use in areas that we do not know. The user shall always evaluate products for their intended use and we guarantee only the material properties. For every product we offer reference objects separately.

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