



Technical data sheet

NM Lim 893

Utg: 2018-10-16

Ers: 2018-10-16

Rev: 2021-10-25

General Description

NM Lim 893 is a one component, internal flexibilized, heat curing epoxy adhesive.

NM Lim 893 has very high strength values.

NM Lim 893 has very good surface wetting ability which guarantee a good adhesion to most substrates.

Execution

All surfaces in contact with the adhesive need to be completely free from any contaminations such as oil, grease, dust etc. All contaminations will have a negative effect on the adhesion. Some metals require a special pre-treatment. If any uncertainty arises, please contact Nils Malmgren AB.

Release agent

We recommend a film forming release agent such as Marbocote 220.

Wax based release agents are normally not recommended. If used tests must first be conducted.

Curing

The curing reaction is activated at approximately 150°C which is why that is the minimum curing temperature.

Curing temperatures above 180°C should be avoided.

At 150°C the curing time is 30 minutes and at 180°C the curing time is 10 minutes.

The curing time starts when the adhesive in the joint has reached the chosen temperature.

It is important that the temperature is raised slowly until it reaches the final curing temperature. It is usually a combination of the thickness of the joint and the construction that determines the speed in which the temperature can be raised. The optimal curing cycle must be determined for each case individually.

Post curing

To ensure adhesion to the next layer the surface must be sanded.

Technical data

Name	NM Lim 893
<i>Density, 20°C:</i>	1120 kg/m ³
<i>Viscosity, 25°C:</i>	40 – 100 Pa·s
<i>Shear strength: (30 min 150°C)</i>	25 MPa
<i>Linear coefficient of Thermal expansion:</i>	60·10 ⁻⁶ m/m·°C
<i>Maximum working temperature:</i>	120°C
<i>Tg:</i>	125°C
<i>Storage stability +4°C:</i>	6 months
<i>Storage stability -20°C:</i>	24 months
<i>Colour:</i>	Opaque
<i>Normal packaging:</i>	0.250 kg
<i>Cleaning solvent:</i>	Acetone

*Shear strength according to DIN 53283
Tg using DSC 20K/min*

Disclaimer

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

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.