



Technical Data Sheet

NM Lim 623

Utg: 2002-05-15

Ers: 2021-09-09

Rev: 2025-06-04

General Description

NM Lim 623 is a two-component, solvent-free epoxy adhesive optimized for bonding and priming stainless steel.

Applications

NM Lim 623 is specifically developed to achieve strong adhesion to low surface energy materials, such as stainless steel.

NM Lim 623 is also well suited for bonding carbon fiber components and for adhesive bonding to concrete surfaces.

Surface Preparation

Surfaces to be bonded must be completely free from oil, dust, chemicals, and other contaminants. Treated and degreased surfaces must not be touched by hand. Bonding should be carried out as soon as possible after surface preparation.

Blasting of the parts is recommended.

Processing Instructions

NM Lim 623 is thixotropically modified and can be applied in beads. It does not run during curing.

For increased thixotropy, our product **NM Tix 150** is recommended.

Curing can be accelerated by elevated temperature. At +70°C/158°F, full cure is achieved in 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]: 50 MPa
E-modulus, bend [ISO 178]: 1.0 GPa
T_G, 1 h 70°C / 158°F: 44°C / 111°F
T_G, 7 d, RT: 56°C / 133°F
Hardness, Buchholz: 64.5^{*1}

Adhesion to stainless steel:

Blasted: 25 MPa^{*1}
Blasted: 22 MPa
Washed: 20 MPa^{*1}
Grinded: 21 MPa^{*1}
Grinded: 23 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

The technical data for this product is based on both field experience and laboratory testing.

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

We reserve the right to modify both products and technical data. The current data sheet is available on our website and from our office. We cannot assume responsibility for applications in areas unknown to us. It is the responsibility of the user to evaluate the product for their specific application. We guarantee only the material properties. Reference projects are available upon request for each specific product.

NILS MALMGREN AB

P.O Box 2039
S-442 02 YTTERBY, SWEDEN

Phone: +46 303-936 10

Quality certified since 1990

E-mail: info@nilsmalmgren.se
Home site: www.nilsmalmgren.se