BONDING +
SEALING +
ENCAPSULATION

Kisling

TECHNICAL DATASHEET

1315
(Resin 1313 + Hardener 1314)

Description
This low odour grade was developed to bond metals like aluminum, steel, brass and its alloys as well as ferrite, a wide range of plastics and combinations of those materials. It is a two-component system and cures after mixing into a dry, high-strength and impact resisting polymer film. The best mixture-ratio is 1:1 (volume) and is obtainable without problems by using the common double-cartridges.

Advantages
- Very fast curing system, short fixture times
- High tensile shear strength
- Resists against impacts as well as again peeling
- Good gap-filling behaviour up to 0.1 mm
- Passes test acc. to UL-94 HB at layer thickness of 3 mm
- Free of solvents, 100% reactive substance

Physical properties (liquid product)

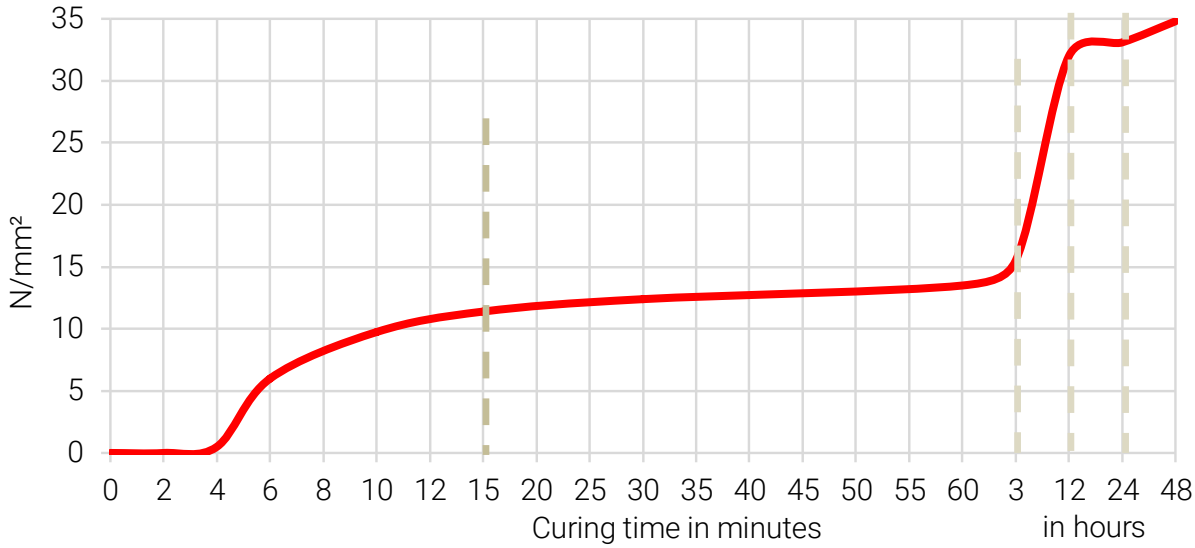
Chemical base			Modified methacrylate
Curing System			2-component-system
Mixing ratio by volume and mass			1 : 1 (Resin 1313 : Hardener 1314)
Shelf life in 50ml cartridges			9 months at ≤ 25°C
Shelf life in 2.5kg bottles/hobbocks			3 months at ≤ 25°C
Colour	Resin	1313	Off-white translucent (blue fluorescent)
	Hardener	1314	Dark blue-green
	Mixture		Green-brown
Viscosity at 25°C (cone 25, 35s^{-1})			5'500 – 7'500 mPa•s
Density			~ 1.03 – 1.10 g/cm³

Kisling AG | Motorenstrasse 102 | 8620 Wetzikon | Switzerland
P +41 58 272 01 01 | info@kisling.com | www.kisling.com

Curing properties

Pot life at 23°C; ~2g	1 – 2 minutes
Fixture time at 23°C (>1 N/mm²)	3 – 4 minutes
Function time at 23°C (>10 N/mm²)	~ 11 minutes
Final strength at 23°C	~ 12 hours

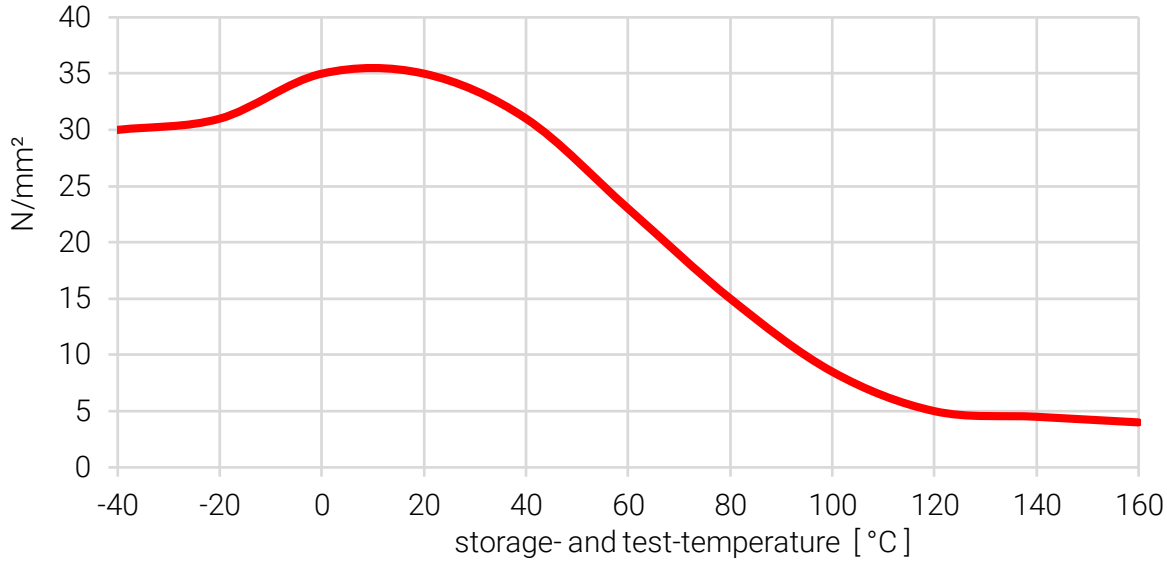
Strength-build up on steel (corundum-blasted and degreased)
Tensile shear strength at 23°C (EN 1465)



Physical properties (cured product)

Thermal range	- 40 °C up to 150 °C

Tensile shear strength on steel (corundum-blasted and degreased) acc. to EN 1465
After 24 hours curing at 23 °C and 1 hour at mentioned test temperature



Tensile strength after 24 hours at 23°C	~ 21 N/mm²
Elongation at break after 24 hours at 23°C	~ 20 %
Shore D hardness	~ 72

Tensile shear strength acc. to DIN EN 1465
Curing and test temperature: 23 °C; metals corundum blasted / plastics cleaned

Steel	> 22 N/mm²
Aluminium	> 20 N/mm²
Brass	> 17 N/mm²
ABS	> 5 N/mm² (Material failure)
PS	> 2.5 N/mm² (Material failure)

Precautions

For your own safety, please refer to the information of the concerned MSDS and for the correct handling the "user instructions".

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