



**Kisling AG**

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## TECHNICAL INFORMATION ergo.<sup>®</sup> 7415

consists out of resin ergo.<sup>®</sup> 7413 and hardener ergo.<sup>®</sup> 7414

Base: two-component-epoxy-resin

Curing : at room temperature.  
accelerating possible by temperature increase

Application: High strength and fast curing product with good adhesion to metals, ceramic, glass, rubber, hard plastics and a wide range of other common materials.

Use : Both components must be mixed in advance. The best mixture ratio is 1:1  
Using the double-cartridge system with static mixture tube is very easy and avoids failures. The surfaces must be clean, which means, dry and free of dust and grease. For this reason it is recommended to use either the ergo.<sup>®</sup> Cleaner 9190 (for metal) or the ergo.<sup>®</sup> Cleaner 9195 (for plastics)

**Mixture ratio** resin : hardener, by weight 100 : 93,3  
resin : hardener, by volume 1 : 1

**Colour** resin, hardener, mixture white, black, grey

**Viscosity** acc. to Brookfield cone/plate – system  
at 25°C, cone MK25, D=35s<sup>-1</sup>

Resin 135 – 145 Pa•s  
Hardener 30 – 40 Pa•s

**Density** of mixed product at 23°C 1,20 – 1,22 g/cm<sup>3</sup>

**Thermal range** -60°C to +100°C

**Potlife**  
2,6 g resin + 2,4 g hardener at 23°C ~ 3,5 minutes

**Glass transition point** 52 °C  
Curing: 16 hours at 40°C

**Shore D - hardness** ~ 75  
Curing: 16 hours at 40°C

**Fixture time** (> 1 N/mm<sup>2</sup>) at 23°C ~ 6 minutes

**Functional strength** (> 10 N/mm<sup>2</sup>)  
at 23°C ~ 60 minutes  
at 40°C ~ 35 minutes  
at 60°C ~ 10 minutes  
at 100°C ~ 2 minutes

**Final strength** 48 hours



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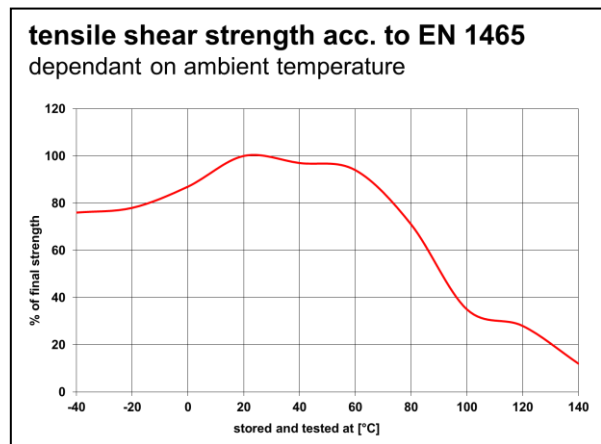
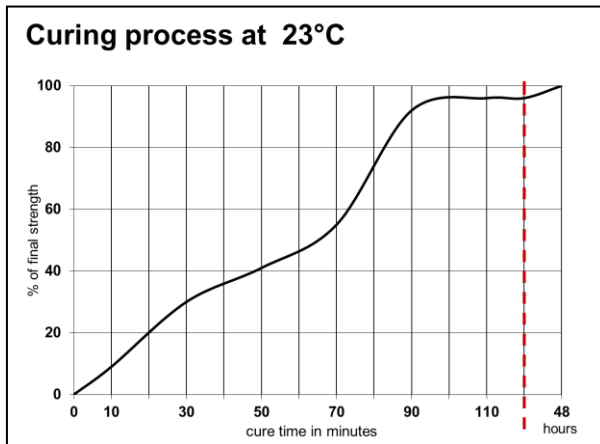
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- 2 -

**Tensile shear strength** acc. to EN 1465, metals sandblasted

Curing: 16 hours at 40°C, tested at 23°C

Steel	> 18 N/mm <sup>2</sup>
Stainless steel	> 15 N/mm <sup>2</sup>
Aluminium	> 13 N/mm <sup>2</sup>
Copper	> 14 N/mm <sup>2</sup>
Brass	> 14 N/mm <sup>2</sup>
GFRP, Epoxy	> 10 N/mm <sup>2</sup>
Polyamide 6	~ 3 N/mm <sup>2</sup>
ABS	~ 4 N/mm <sup>2</sup>
PVC	~ 4 N/mm <sup>2</sup>
Polycarbonate	~ 4 N/mm <sup>2</sup>



Storage stability between +2°C and +30°C

2 years

**WARRANTY INFORMATION - PLEASE READ CAREFULLY**

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that KISLING products are safe, effective, and fully satisfactory for the intended end use. KISLING sole warranty is that the product will meet the KISLING sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. KISLING specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless KISLING provides you with a specific, duly signed endorsement of fitness for use, KISLING disclaims liability for any incidental or consequential damages. Suggestions of uses should not be taken as inducements to infringe any particular patent.