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HXTAL NYL - 1

Appearance

Colourless, clear two part epoxy resin.

Technical Data

Tensile Strength	5400 psi
Tensile Modulus	316,000 psi
Elongation	3%
Flexural Strength	10,100 psi
Flexural Modulus	365,000 psi
Impact Strength	0.14 ft lbs/in
Heat Distortion Temp 264/66psi	37.5 / 39.0 C
Shore D Hardness 0/10 sec	78/73
Gel Time, 110g mass	25.8 min @ 150°F 262.7 min @ 100°F
Cure of 0.2mm film at 25 degrees C	Cure to the touch: 15.3 hours Full cure: 30.9 hrs

GENERAL

HXTAL is a two part low viscosity epoxy adhesive that has exceptional non yellowing and high strength characteristics. Its clarity makes it ideal for the bonding of glass and is used by many glass artists and in industry where a high strength clear bond is required.

If penetrated fully into glass cracks it can make the crack disappear.

HXTAL is also used in ceramic restoration for thin bond lines and crack filling applications. The thin bond line helps prevent a step in the repair.

MIXING

For best results HXTAL should be accurately mixed. cure time will be affected by incorrect mixing.

The mixing ratio is: Three parts of A to One part of B

Mix in a clear glass or polythene container, ensure parts are thoroughly mixed.

APPLICATION

Once mixed HXTAL will be very thin and is suitable for all applications where a thin bond line is required, this however may be too thin for porous parts or parts that require an amount of gap filling.

For porous parts and small gap filling a thicker consistency is required,. To thicken the adhesive cover the container allow it to stand for a few hours.

Freshly mixed HXTAL is very thin and penetrates deep into the smallest crack, to increase the penetration, warm the crack first with a hair dryer or low wattage lamp.



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CURE TIME

Hxtal is a slow curing adhesive.

At 75°F: Handling strength is achieved in approximately 24- 30 hours. 90% of cure is achieved in 7 days.

To increase the speed of cure warm the bonded parts to 90 – 100°F for 1 to 2 days. If this warming is started too soon after application of the adhesive, the adhesive will thin and run away from the joint.

FASTER BONDS

For faster bonds it is suggested that the freshly mixed adhesive is allowed to thicken.

To thicken stand the mixing pot into hot water at about 120°F for 10 – 15 minutes, you can judge the thickness.

Apply the adhesive to the joints and assemble.

Allow to stand for 36 hours and then place into a warm oven or hot box at 90 – 100°F for 2 days.

CLEAN UP

To clean surplus adhesive from the repair . Allow HXTAL to cure for 24 – 30 hours and scrape away with a one sided razor blade.

Solvents soaked into a cloth may be used away from the joint but remember that, should the solvent come into contact with the adhesive it may penetrate the joint weakening or even breakage the joint.

Disclaimer

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the suitability for use. HXTAL, Sylmasta or its agents accepts no liability arising out of the use of this information or the products described herein.