



### Graphi-Bond 551-RN/669

#### Description

Based on graphite, these products prove their worth especially in applications under special atmospheres. These adhesives are particularly suitable for bonding and coating graphite parts.

**Graphi-Bond 551-RN** has proven its worth in the repair and reconditioning of fixtures and shells as used in the glass-to-metal casting atmosphere.

**Graphi-Bond 669** excels when used in oxidizing atmosphere.

#### Technical Data

Characteristics	Graphi-Bond 551-RN	Graphi-Bond 669
Main Components	Graphite	Graphite
Max. Temperature	2985 °C	760 °C
Viscosity	Paste	200 – 400 g/cm/s
Spec. Weight	1.45 – 1.50 g/cm <sup>3</sup>	1.45 – 1.50 g/cm <sup>3</sup>
CTE	7.4 cm/cm/°C x 10 <sup>6</sup>	7.6 cm/cm/°C x 10 <sup>6</sup>
Dielectric Strength	2.95 KV/mm at RT	4.13 KV/mm at RT
Torque Strength	40675 N/mm	35251 N/mm
Hardness	4.0 Moh's Skala	6.0 Moh's Skala
Components	1	1
Moisture Resistance	Excellent	Excellent
Alkali Resistance	Good	Good
Acid Resistance	Good	Good
Dispenser Usable	No	Yes
Atmosphere Resistant for	Reduced atmosphere High vacuum resistant	Oxidizing atmosphere

#### Handling

Graphite surfaces must be dust-free, avoid grinding or sandblasting.

Dry graphite at 120 °C for 10 minutes in the oven, cool down at room temperature

Mix the adhesive well before use and apply a thin layer to each surface.

Use a clamp or similar tool to apply even pressure to the bond.

The adhesive layer should have a thickness of 0.2 - 0.5 mm.

The application can be done with a brush, spatula or a dispenser.

#### Hardening

##### **Graphi-Bond 551-RN**

- 1 – 4 hours air cure
- 4 hours heat cure at 130 °C
- +2 hours final cure at 260 °C

##### **Graphi-Bond 669**

- 1 – 4 hours air cure
- 2 hours final cure at 90 °C

Alle hier gemachten Angaben dienen der Information und sind keine rechtsverbindlichen Zusagen. Sie entbinden den Anwender nicht von eigenen Vorversuchen.  
Wir haften nicht für Verarbeitungsergebnisse

<b>Rechnungsanschrift</b> T-E-Klebertechnik H.-P. Thielgen Vahrenwalder Str. 131 30165 Hannover	<b>Kunden-Center + Lieferanschrift</b> T-E-Klebertechnik Großer Kolonnenweg 3 30163 Hannover	<b>Telefon</b> Verkauf 0511/353982-0 Einkauf 0511/353982-11 Technik 0511/353982-31 Lohnarbeiten 0511/353982-12	<b>Telefax</b> 0511-353982-40 <b>UST-ID Nr.:</b> DE 115640309	<b>e-mail</b> infotek@t-e-klebertechnik.de <b>Internet</b> www.t-e-klebertechnik.de
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Erfüllungsort ist Sitz des Lieferanten. Die Ware bleibt bis zur restlosen Bezahlung Eigentum des Lieferanten. Es gelten unsere Geschäftsbedingungen