



TECHNICAL LEAFLET

SUNSTAR ENGINEERING INC.

One-Part Structural Epoxy Based Adhesive PENGUIN CEMENT #1064

Penguin Cement #1064 is a one-part epoxy based structural adhesive with superior rust prevention.

a). Characteristics

1. Cures perfectly within 1 hour at above 150°C. Good stability in storage is guaranteed for 3 months at room temperature (20°C)
2. Applicable for spot welding
3. Shows good adhesion to oily surface
4. Provides superior rust prevention of both border and inner part of the adhered substances
5. Good electro-deposit coating property because of high conductivity

b). Physical Properties

Appearance	: Black Paste
Viscosity (20°C)	: 130 x 10 ⁴ cps
Specific Gravity	: 1.56
Non-Volatile Content (%)	: 99.0 %
Flash Point	: 240°C
Ignition Point	: None

c). General Performances

1. Initial Performances

Items	Records
i). Normal Adhesive Strength (20°C) Shear Strength (kgf/cm ²)	280
ii). Adhesive Strength to oily Surface (20°C) Shear Strength (kgf/cm ²)	262

2. Lasting Adhesive Strength

Items	Records
iii). Adhesive Strength at 80°C Shear Strength (kgf/cm ²)	195
iv). Heat Aging Resistance (80°C/14days) Shear Strength (kgf/cm ²)	270
v). Water Immersion Resistance (7days) Shear Strength (kgf/cm ²)	210
vi). Thermal Shock (5 cycles) Shear Strength (kgf/cm ²)*	248
vii). Over Baking Resistance (190°C/20 min) Shear Strength (kgf/cm ²)	235
viii). Rust Prevention Salt Spray (1,000 hours)	Normal

d). Precautions

1. As Penguin Cement #1064 is a one-part type adhesive, it should be stored in dark and cool place ($\approx 10^{\circ}\text{C}$) with its cap or lid closely tightened.
2. During application, wear protectors like gloves or apron so that the adhesive does not stick to the skin
3. In case #1064 does stick to skin, immediately wipe it off with thinner and wash with soap and water

e). Packaging

Pail can	25kg
Cartridge	333ml