

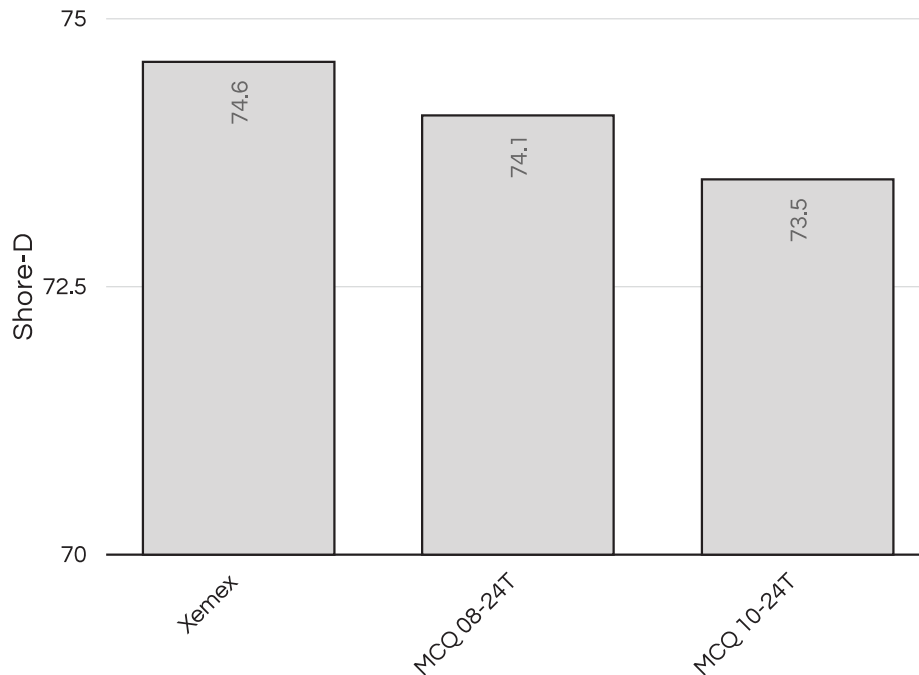


Purpose To compare the mixing performance of the Xemex® Static Mixer with commercially available mixers.

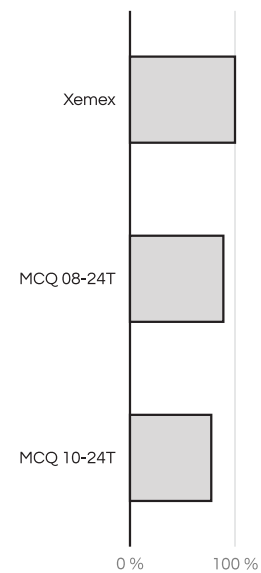
Experimental The 2-part formulation was dispensed using Re Mixer’s automated cartridge dispenser, having preset flow rate and purge routines. After curing at room temperature for 48 hours, hardness was determined through a single-blind collection using Rex Gauge’s RX-DD Series Durometer, and in accordance with ASTM D2240.

3M™ Scotch-Weld® LSB60

Cured Hardness



Relative Pressure*



*Normalized from 0.1 mL/s constant flow rate data

Mixing Performance The hardness data suggests that Xemex yielded the best mixing performance for 3M™ Scotch-Weld® LSB60 adhesive. With a retained volume of only 2.5 mL, Xemex outperformed mixers with 24 elements, which have retained volumes in the order of 5 to 10 mL. These results suggest that Xemex is a candidate for applications using LSB60.

Back Pressure From this data, one should expect back pressures with Xemex to be comparable to MCH 08-24T and slightly higher than MCQ 10-24T at equivalent flow rates.

Formulation	Type	Mix Ratio**	Mixed** (cP)	Part A**	Part B**	Worklife** (min)	Keywords
3M™ Scotch-Weld® LSB60	Epoxy	1:1	—	17,200	68,200	90	Filled
Laboratory Technician		Cured Time		Laboratory		Report Prepared by	
Lukas Duddleston, MS		48 hours		23±2 °C 35±5 % RH		Lukas Duddleston, MS	

**As reported in 3M’s Technical Data Sheet

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