

Description

This is a quick-set 2-part epoxy adhesive. Bonded parts need only be held together for eight to ten minutes before handling. It offers excellent adhesion to a wide range of materials that are difficult to bond with, including glass, fiberglass, concrete, ceramics, woods, and most metals and plastics.

This is a general-purpose adhesive suitable for household, industrial and manufacturing applications.

Features and Benefits

- Quick set time
- Low shrinkage
- Provides strong electrical insulation
- Protects against thermal and mechanical shocks
- Strong resistance to humidity, salt water, acids, bases, and aliphatic hydrocarbons
- Comes in convenient dual cartridges, suitable for automated dispensing applications

Storage and Handling

Store between 16°C and 27°C in a dry area. To maximize shelf life, recap product firmly when not in use.

Usage Parameters

Working Time	: 3 to 5 min
Set Time	: 8 to 10 min
Functional Cure @ 22°C	: 5h
Mix Ratio by Volume	: 1:1
Mix Ratio by Weight	: 1:1

Cured Properties

Breakdown Voltage	: 23 200 V
Dielectric Strength	: 250 V/mil
Resistivity	: $1.7 \times 10^{14} \Omega \cdot \text{cm}$
Hardness	: 82D
Tensile Strength	: 34 N/mm ²
Compressive Strength	: 63 N/mm ²
Lap Shear (stainless steel)	: 4.9 N/mmV
(aluminum)	: 5.9 N/mm ²
Glass Transition Temperature	: 64°C (T _g)
CTE Prior T _g	: 76 ppm/°C
CTE After T _g	: 175 ppm/°C
Service Temperature Range	: -40–150°C

Uncured Properties

Mixed Density	: 1.14 g/mL
Viscosity @ 25°C (A)	: 12 Pa·s
(B)	: 14 Pa·s
Shelf Life	: 3 y

Syringe or Cartridge

1. Twist and remove the cap from the cartridge or syringe. Do not discard cap.
2. Dispense a small amount to ensure even flow of both parts.
3. (Optional) Attach a static mixer.
 - a. Dispense and discard 3 to 5 mL of the product to ensure a homogeneous mixture.
 - b. After use, dispose of static mixer.
4. Without a static mixer, dispense material on a mixing surface or container, and thoroughly mix parts A and B together.
5. To stop the flow, pull back on the plunger.
6. Clean nozzle to prevent contamination and material buildup.
7. Replace the cap on the cartridge or syringe.

Part Number Table

Description	Part Number
Epoxy Adhesive, Fast Set, 25mL	MP014777

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