

RoHS  
Compliant



## 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 <sup>2</sup>
Compressive Strength	: 63 N/mm <sup>2</sup>
Lap Shear (stainless steel)	: 4.9 N/mmV
(aluminum)	: 5.9 N/mm <sup>2</sup>
Glass Transition Temperature	: 64°C (Tg)
CTE Prior Tg	: 76 ppm/°C
CTE After Tg	: 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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