

### PRODUCT DESCRIPTION

provides the following product characteristics:

|                                                |                                                                                                                                                                                                                                                                                     |
|------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Technology</b>                              | Epoxy                                                                                                                                                                                                                                                                               |
| <b>Color</b>                                   | Milky, translucent                                                                                                                                                                                                                                                                  |
| <b>Cure</b>                                    | Room temperature cure or Heat cure                                                                                                                                                                                                                                                  |
| <b>Operating Temperature</b>                   | -60 to 130 °C                                                                                                                                                                                                                                                                       |
| <b>Product Benefits</b>                        | <ul style="list-style-type: none"> <li>• Low vapor pressure</li> <li>• Thixotropic</li> <li>• Solvent-free</li> <li>• Excellent environmental resistance</li> <li>• Electrically Insulating</li> <li>• Room temperature cure</li> <li>• Non-sag</li> <li>• Two component</li> </ul> |
| <b>Components</b>                              | Two component - requires mixing                                                                                                                                                                                                                                                     |
| <b>Mix Ratio, by weight - Resin : Hardener</b> | 100 : 22                                                                                                                                                                                                                                                                            |
| <b>Application</b>                             | Staking compound                                                                                                                                                                                                                                                                    |
| <b>Typical Assembly Applications</b>           | Critical electronics applications, Aerospace applications and Industrial applications                                                                                                                                                                                               |
| <b>Substrates</b>                              | Glass, Rigid plastics, Ceramic, Metals and Wood                                                                                                                                                                                                                                     |

adhesive is designed for bonding and enhancing the mechanical and structural rigidity of assemblies. bonds offer resistance to weather, galvanic action, most petroleum solvents, lubricants, gasoline, jet fuel, alcohol, salts and mild acids and alkalis.

passes NASA outgassing standards.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

|                         |         |
|-------------------------|---------|
| Viscosity @ 25 °C, cP:  |         |
| After Mixing            | 100,000 |
| Specific Gravity, mixed | 1.26    |
| Pot Life , minutes      | 30      |
| Flash Point - See MSDS  |         |

### TYPICAL CURING PERFORMANCE

#### Cure Schedule

24 hours @ 25°C

#### Alternative Cure Schedule

4 hours @ 65°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

### TYPICAL PROPERTIES OF CURED MATERIAL

#### Physical Properties:

|                                            |                       |
|--------------------------------------------|-----------------------|
| Coefficient of Thermal Expansion, cm/cm/°C | 5.5×10 <sup>-05</sup> |
| Glass Transition Temperature (Tg), °C      | 115                   |
| Hardness, Shore D                          | 90                    |
| Izod Impact Strength, ft-lb/in. of notch   | 0.22                  |
| Reactive solids contents, %                | 100                   |

#### Electrical Properties:

|                                |                      |
|--------------------------------|----------------------|
| Volume Resistivity, ohms-cm:   |                      |
| @ 25°C                         | 6.0×10 <sup>13</sup> |
| @ 100°C                        | 1.0×10 <sup>10</sup> |
| Dielectric Strength, volts/mil | 415                  |
| Dielectric Constant @ 25°C :   |                      |
| 1kHz                           | 4.5                  |
| Dissipation Factor @ 25°C:     |                      |
| 1kHz                           | 0.01                 |

#### Outgassing Properties:

|                                        |      |
|----------------------------------------|------|
| Total Mass Loss, %                     | 1.01 |
| Volatile Condensable Material (VCM), % | 0.05 |

### TYPICAL PERFORMANCE OF CURED MATERIAL

Lap Shear Strength, psi:

1 hour @ 65°C

| Substrate            |      |
|----------------------|------|
| Aluminum to Aluminum | 2500 |

### GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

### DIRECTIONS FOR USE

1. Carefully clean and dry all surfaces to be bonded
2. Remove clamp and thoroughly mix the epoxy adhesive system components in the handy BIPAX mixing-dispenser package until color is uniform throughout
3. Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured
4. Some separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use

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5. Some ingredients in this formulation provided in BIPAX, TRA-PAX and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 125°C for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results

#### **Not for product specifications**

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

#### **Storage**

The expiration date for pre-mixed and frozen materials is based upon dry storage conditions at or below the temperature indicated on each package. Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

#### **Optimal Storage: 27 °C**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative. Contents may separate during storage. Resin or hardener .

#### **Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$