



“Our strength is in our formulations”

PRELIMINARY HANDLING INFORMATION

PRODUCT NUMBER: XR5 1511 / XH6 1512

DESCRIPTION: A MEDIUM VISCOSITY, TWO COMPONENT EPOXY STRUCTURAL ADHESIVE DEVELOPED FOR BONDING ALUMINUM. THE PRODUCT HAS EXCELLENT ADHESION TO WELL PREPARED SURFACES AND WILL CURE AT ROOM TEMPERATURE.

HANDLING: (NOTES 1, 2 & 5)

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| MIX RATIO BY WEIGHT: | 100:86 (100:100 PBV) |
| MIXED VISCOSITY @ 22 ⁰ C | 25,000 cps. |
| POT LIFE (20 gm. MASS) @ 60 ⁰ C: | 30 Minutes |

CURE SCHEDULE: (NOTE 3)

16 HRS @ 65⁰C (149⁰F) OR 7 DAYS @ RT.

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

| | | |
|--|---------------|-------------------------|
| COLOUR: | | GREY |
| DENSITY / SPECIFIC GRAVITY (RESIN): | (ASTM D 792) | 1.26 gm/cm ³ |
| DENSITY / SPECIFIC GRAVITY (HARDENER): | (ASTM D 792) | 1.08 gm/cm ³ |
| SHORE HARDNESS: | (ASTM D 2240) | 80D |
| TENSILE (LAP SHEAR) STRENGTH (psi): | (ASTM D 638) | 3750 |
| HEAT DEFLECTION TEMPERATURE (HDT): | | 59 ⁰ C |

Continued...

NOTES:

- 1) If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.
- 2) The mix ratio must be within $\pm 2\%$ of the stated value and thorough mixing is required to avoid degraded properties.
- 3) Other cure schedules may yield satisfactory results however; these should be determined by the customer for his given application.
- 4) Unless otherwise specified, all measurements are taken at 22^oC.
- 5) These products may trigger allergic reactions in some individuals. Prevent contact with skin; wash with plenty of soap and water if contact occurs and **Read the Material Safety Data Sheet** before using the materials. **Do Not Breathe Vapours** provide good ventilation and exercise good housekeeping at the work area.
- 6) If stated, the values under “**Electrical Characteristics**” may be based on supplier data for products with similar compositions. They are provided only as a guide and the recipient must test each material to determine its suitability for the intended application.
- 7) If indicated, the “**Guide to Operating Temperature**” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of a product for a particular operating temperature is application dependent and **may change according to the demands placed upon it in service.**

IMPORTANT

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