



# CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS

ISO

9001

REGISTERED  
QUALITY SYSTEM

SINCE 1981

**TECHNICAL BULLETIN: XR5 2092 / XH6 2093**

## PRODUCT DESCRIPTION:

A MEDIUM VISCOSITY, ROOM TEMPERATURE CURING, TWO COMPONENT EPOXY ADHESIVE. PRODUCT WAS DEVELOPED WITH IMPROVED THIN FILM SET TIME WHEN BONDING METAL SUBSTRATES.

SALES SPECIFICATION	XR5 2092	XH6 2093
COLOUR	WHITE	BLACK
VISCOSITY (NOTE 1, NOTE 4)	60000 - 80000 CPS @ 22 °C	25000 - 45000 CPS @ 22 °C
SPECIFIC GRAVITY	1.20 ± 0.03 gm/cm <sup>3</sup>	1.20 ± 0.03 gm/cm <sup>3</sup>
SHELF LIFE	6 MONTHS	12 MONTHS

## HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:100 (by vol. 100:100.0)
MIXED VISCOSITY (NOTE 4)	35000 cps @ 22 °C
POT LIFE OF 100 gm. mass (NOTE 4)	15.00 Min. @ 22 °C
GEL TIME OF 100 gm. mass (NOTE 4)	35.00 Min. @ 22 °C

## CURE SCHEDULE (NOTE 3):

RECOMMENDED CURE SCHEDULE	48 Hrs. @ 22 °C
ALTERNATE CURE SCHEDULE	4 Hrs. @ 60 °C

## CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	GREY
DENSITY (gm/cm <sup>3</sup> )	1.20
SHORE HARDNESS	85D
THERMAL CONDUCTIVITY W/(m•K)	0.4
TG (°C) ASTM E1545	92.00
CTE BELOW TG (x10 <sup>-6</sup> in/in°C) ASTM E831	66.81
CTE ABOVE TG (x10 <sup>-6</sup> in/in°C) ASTM E831	182.10

## **NOTES**

Note1 If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.

Note2 Mix ratio must be within  $\pm 2\%$  of the stated amount and thorough mixing is required to avoid degraded final properties.

Note3 Other cure schedules may give satisfactory results, however, these should be determined by the customer for their given circumstances.

Note4 All measurements taken at 22°C unless otherwise specified.

Note5 These products may trigger allergic responses in some individuals. Prevent contact with skin, wash with plenty of soap and water immediately if contact occurs. Do not breathe vapours, provide good ventilation and exercise good housekeeping at work area. Read the Material Safety Data Sheet.

Note6 The “Guide to Operating Temperature” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of this product for a given operating temperature is application dependent and may change according to the demands placed upon it in operation.

Note7 If indicated, 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.

## **IMPORTANT**

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6430 Vipond Drive, Mississauga, Ontario, Canada L5T 1W8 Phone: 1-800-563-3769, (905) 673-0510, Fax: (905) 673-0519 Web site: [www.crosslinktech.com](http://www.crosslinktech.com) , E-mail: [info@crosslinktech.com](mailto:info@crosslinktech.com)