

Advanced Materials**Epibond® 1210-A/B****EPOXY ADHESIVE**

- General Purpose Adhesive
- Room Temperature Cure
- Variable Properties

DESCRIPTION :

Epibond® 1210-A/B epoxy adhesive is a two-part system with a semi-paste consistency. This adhesive product is ideal for spacecraft applications due to its low outgassing properties. Epibond® 1210-B hardener can be used at varying ratios up to 100 parts by weight with Epibond 1210-A resin to achieve a more flexible bondline. Epibond® 1210-A/B epoxy adhesive may be applied by brush, spatula, or automatic dispensing equipment. The epoxy adhesive is designed for bonding metal, wood, wood products, glass, ceramics, most plastics and many other materials.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1210-A Resin</u>	<u>1210-B Hardener</u>	<u>1210-A/B System</u>	<u>Test Method</u>
Color	Tan	Amber	Tan	Visual
Specific gravity	1.5	1.00	1.30	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	250,000	30,000	Semi-Paste	ASTM-D-2393
Flash Point, COC, °F (°C)	490 (254)	275 (135)	--	ASTM-D-92
Work life, 100 gms at 77°F (25°C), minutes	--	--	50-75	ASTM-D-1338
Solids, %	--	--	100	ASTM-D-1644

MIX RATIO :

To 100 parts by weight of Epibond 1210-A resin, add 65 parts by weight of Epibond 1210-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing. Up to 100 parts by weight of Epibond 1210-B hardener may be used for more flexible bonds.

CURE SCHEDULE :

48 hours at 75-80°F (23-26°C), or 2 hours at 150°F (66°C), required for full cure.

TYPICAL CURED PROPERTIES (Not for specification purposes)

Test	Result	Test Method
Maximum service temperature, °F (°C)	200 (93)	ASTM-D-648
Tensile lap shear, Al/Al, at 77°F (25°C), psi (MPa)	2,500 (17.2)	ASTM-D-1002
steel to steel at 77°F (25°C), psi (MPa)	2,500 (17.2)	--
steel to steel at 150°F (66°C), psi (MPa)	500 (3.4)	--
polyester to polyester at 77°F (25°C), psi (MPa)	1,800 (12.4)	--
Fluid Immersion 7 days at 75°F (23°C), psi (MPa)		ASTM-D-1002
JP-4	2,550 (17.5)	--
Skydrol	2,600 (17.9)	--
Distilled Water	2,700 (18.6)	--
Outgassing: TML, %	0.65	ASTM-E-595
CVCM, %	0.01	--
Hardness, Shore D	80	ASTM-D-2240

STORAGE :

Epibond® 1210-A/B should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). The product should not be exposed to direct sunlight. Under these storage conditions, and when supplied under Huntsman standard certification, this product has a shelf life of 1 year (expiration date may differ based on customer specification).

Material temperatures should be above 18°C (65°F) when mixing. After use, tightly reseal containers.

PRECAUTIONARY STATEMENT :

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN**FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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