

EASYPOXY[®] K-45

TECHNICAL PRODUCT BRIEF



DESCRIPTION

EASYPOXY K-45 is a 100% solids two-component paste adhesive that is mixed at a 1-to-1 ratio by weight or by volume and offers a quick set time of 4-6 minutes at room temperature. EASYPOXY K-45 is designed for bonding steel, aluminum, glass, wood, cork, fabrics, ceramics, and most hard plastics. Electrical insulation properties of EASYPOXY K-45 are good and it has good optical clarity in thin bond lines.

Features	Benefits
1-to-1 Mix Ratio by Weight or Volume	Easy to use
Paste Consistency	Non-flow
24 Hour Cure Time	High production rate

CHARACTERISTICS AND PROPERTIES

Table 1 | Product Description

Property	Resin PART A	Curative PART B
Viscosity @ 25°C (77°F)	Light Paste	Light Paste
Specific Gravity @ 25°C (77°F)	1.16	1.19
Color	Clear	Amber
Solids Content	100%	100%
Mix Ratio, Parts by Weight or Volume (A/B)	100	100
Shelf Life, from date of manufacture in original unopened containers	18 months	18 months

Table 2 | Cured Properties

Property	Value
Color	Light Amber
Hardness, Shore D	85
Flexibility	Semi-Flexible
Tensile strength, psi Etched AL/AL, 25°C (77°F) Etched AL/AL, -55°C (-67°F) Etched AL/AL, 82°C (180°F)	2520 1800 440
Linear shrinkage, %	1.00%
Water Absorption, 24 hr. immersion @ 25°C (77°F), %	1.30%
Flexural Strength, psi	7800
Compressive Strength, psi	15,000
Tensile Strength, psi	3000
Thermal Conductivity, cal/sec/cm ² /°C/cm x 10 ⁻⁴	5.0
Fungus Resistance	Non-nutrient
Values are average, based on several determinations and are not intended for use in preparation of specifications.	

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Table 3 | Electrical Properties

Property	Value @ 25°C (77°F)
Dielectric Constant, 1 kHz	4.10
Dissipation Factor, 1 kHz	0.018
Volume Resistivity, ohm-cm	2.5×10^{14}

SURFACE PREPARATION

Apply to dry, oil-free surfaces. Remove mold releases from plastic surfaces. When bonding metals, degrease and dry. Chemical etching of the metal surface gives optimum results. For specific recommendations, request Cytec's **Surface Preparation Guide**, Bulletin AC-107.

PROCESSING PARAMETERS

Mix equal parts of Part A and Part B by weight or by volume to a uniform color.

Pot life of mixture is 4-6 minutes @ 25°C. Gelation is 10 minutes @ 25°C, and cure is achieved in 24 hours at 25°C. Cure can be accelerated by heating @ 65°C for 1 hour.

Apply adhesive with spatula or stiff brush to each surface. Apply light pressure to ensure good wetting and contact of bonded surfaces.

Clean equipment before the adhesive hardens; a good hydrocarbon solvent is recommended.

In case of crystallization;

These materials may crystallize. If this occurs, place tubes or can into a container and fill with warm tap water. Do not submerge container. Let stand until the epoxy returns to a liquid state. It may be necessary to replenish the warm water to accelerate the melting process. Once melted remove the tube or container from the water bath and let it stand until the material returns to room temperature before using.

CAUTION

For Industrial Use Only! Always read the Material Safety Data Sheets before using. Uncured materials contain epoxy resins, which are strong eye and skin irritants. Absorption through skin or breathing of vapors may cause serious health conditions. Avoid skin contact. Wear neoprene or nitrile gloves if hand contact is a possibility. If skin contact does occur, clean immediately with denatured alcohol, followed with soap and water. Use only in a well-ventilated area, or wear respirator with organic vapor cartridges, particularly if heated. Always ventilate and provide respiratory protection for sanding or grinding.

HANDLING AND STORAGE INSTRUCTIONS

Recommended storage temperature is 20°C-30°C (68°F-86°F). If material is crystallized on opening see instructions above to liquefy.

EASYPOXY K-45 Part A and Part B have a shelf life of 18 months from date of manufacture when stored in their original, unopened containers at 20°C-30°C (68°F-86°F).

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AVAILABILITY

EASYPOXY K-45 is available in gallon, 5-gallon, and 55-gallon units as well as 6.5 oz. repair kits.

See the **Comparison Chart for the EASYPOXY[®] Series** to compare properties.

CAUTION: Responsible handling of Cytec Industries Inc. products requires a thorough review of safety, health, and environmental issues prior to use. Review the Material Safety Data Sheets(s) for the specific Cytec Industries Inc. product(s) and container label information before opening containers. Ensure that employee exposure issues are understood, communicated to all workers, and controls are in place to prevent exposures above Permissible Exposure Limits (PELs). Review safety and environmental issues to be certain controls are in place to prevent injury to employees, the community, or the environment, and ensure compliance with all applicable Federal, State, and Local laws and regulations. For assistance in this review process, please call your Cytec Industries Inc. representative or our office noted below.

CONTACT INFORMATION

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DISCLAIMER: The data and information provided in this document have been obtained from carefully controlled samples and are considered to be representative of the product described. Because the properties of this product can be significantly affected by the fabrication and testing techniques employed and since Cytec Engineered Materials (CEM) does not control the conditions under which its products are tested and used, CEM cannot guarantee that the properties provided will be obtained with other processes and equipment. CEM has the right to change any data or information when deemed appropriate.

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