

Advanced Materials**Epibond® 1210-A Resin
Hardener 9615A****EPOXY ADHESIVE**

- General Purpose Adhesive
- Room Temperature Cure
- Variable Properties

DESCRIPTION :

Epibond® 1210-A resin/Hardener 9615A epoxy adhesive is a two-part system with paste consistency. This adhesive product is ideal for spacecraft application due to its low out-gassing properties. The adhesive may be applied by spatula, or automatic dispensing equipment. Epibond® 1210-A resin/Hardener 9615A epoxy adhesive bonds 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>9615A Hardener</u>	<u>1210-A/9615A System</u>	<u>Test Method</u>
Color	Tan	Tan	Tan	Visual
Specific gravity	1.5	1.1	1.4	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	250,000	Paste	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
Shelf life at 77°F (25°C), unopened, months	12	12	--	FTM-204
Solids, %	--	--	100	ASTM-D-1644

MIX RATIO :

To 100 parts by weight of Epibond® 1210-A resin, add 65 parts by weight of Hardener 9615A. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

CURE SCHEDULE :

48 hours at 75-80°F (23-26°C), or 3 hours at 150°F (66°C), required for full cure.

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
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)	1,800 (12.4)	--
polyester to polyester at 77°F(25°C), psi (MPa)	1,500 (10.3)	--
Fluid Immersion 7 days at 75°F (23°C), psi (MPa)		ASTM-D-1002
JP-4	2,000 (13.8)	--
Skydrol	2,000 (13.8)	--
Distilled Water	2,300 (15.8)	--
Hardness, Shore D	80	ASTM-D-2240

STORAGE/ SHELF LIFE : Epoxy resins and hardeners should be stored in a dry place in their original, sealed containers at temperatures from 60-100°F (16-38°C). Material temperatures should be above 65°F (18°C) when mixing. After use, tightly reseal containers.

Under these conditions, epoxy resins and hardeners will remain useable for 12 months from date of shipping from Huntsman.

CAUTION :

Huntsman Advanced Materials Americas Inc. 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. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to adhesives_group@huntsman.com.

FIRST AID !

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation: Remove subject to fresh air.

Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

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

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