

Advanced Materials**Epibond® 1337-A Resin
Hardener 9615-A**

EPOXY ADHESIVE

- Room Temperature Cure
- Non-Flow Paste
- Long Work Life

DESCRIPTION :

Epibond® 1337-A resin/Hardener 9615-A epoxy adhesive is a two-part, aluminum-filled, non-flowing paste that is designed for general-purpose metal bonding. Smooth and creamy in consistency, Epibond® 1337-A resin/Hardener 9615-A epoxy adhesive may be faired, trowelled, or splined in position and will hold on vertical surfaces. The epoxy adhesive is also available in a shorter work life version - Epibond® 1337-A resin/Hardener 9514-A epoxy adhesive.

TYPICAL PROPERTIES AS RECEIVED :

Property	<u>1337-A Resin</u>	<u>9615-B Hardener</u>	<u>1337-A/9615-A System</u>	<u>Test Method</u>
Color	Gray	Tan	Gray	Visual
Density, g/cc.	1.12	1.01	1.08	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	Paste	Paste	Non-flow paste	ASTM-D-2196
Work life, 100 gms at 77°F (25°C), minutes	--	--	90-150	ASTM-D-1338
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

MIX RATIO :

To 100 parts by weight of Epibond 1337-A resin, add 100 parts by weight of Hardener 9615-A or 1:1 by volume. Mix for 3-5 minutes to insure complete and uniform blending.

CURE SCHEDULE

48 hours at 77°F (25°C) or gel at room temperature plus 1-2 hours at 150°F (66°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Tensile lap shear: AL/AL, at -67°F (-55°C), psi (MPa)	3,100 (21)	ASTM-D-1002
at 77°F (25°C), psi (MPa)	1,800 (12.4)	--
at 180°F (83°C), psi (MPa)	400 (2.7)	--

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

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