

BD5400HT Epoxy Adhesive

1. DESCRIPTION:

BD5400HT is a one-part, high viscosity, thermosetting epoxy adhesive designed for bonding various metals over a wide range of temperatures. It gives structural strength with exceptional water, chemical & heat resistance, and good shear strengths. This is designed to give excellent environmental resistance properties. For optimum bonding performance, proper surface preparation is recommended.

A handling cure is normally achieved at 135°C within 20 minutes. The recommended minimum cure temperature is 125°C. Higher cure temperatures will generally increase the heat resistance and physical properties of the fully cured system. Properties below are based on the product being cured for one hour @ 135°C. This product is specifically designed for withstand 400F for 30 minutes, for powder coating operations.

2. CHARACTERISTICS:

Elevated Temperature Cure Properties

Fixture Time:	30 minutes @ 275°F 20 minutes @ 325°F 10 minutes @ 350°F 5 minutes @ 400°F
Operating Temp.	-40°C to 250°C
Density:	11 to 12 lb./gal
Flash Point:	251°C (>484°F)
Viscosity:	Non-Sag Paste
Color:	Gray
Hardness:	90 Shore D
Lap Shear strength:	1000psi, 10min. @250F(aluminum) 1150 psi @ water immersion For a week @130F
Flexural Strength:	15,500 psi
Elongation:	3 to 6%
Izod Impact:	0.33 ft lb/in
Shelf life:	@ 100°F = 2 weeks @ 70°F = 3 months @ 40°F = 6 months @ 0°F = 12 months

3. Handling and Storage:

- A. Bring to room temperature prior to use. Cure at elevated temperatures.

- B. All the surfaces to be bonded should be clean and dry. Dispense material using a caulking gun. Excess adhesive must be cleaned up before curing.
- C. Follow safety precautions in handling and curing of the adhesive.

4. ADDITIONAL INFORMATION

NOTE: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use or handling of its chemical products since conditions and use are beyond our control. In every case, we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own operating conditions. Statements concerning possible use of our products are not intended as recommendations to use our products in the infringement of any patent, or for any particular purpose or application. These products are intended for industrial use only.