

BD54125 Epoxy Adhesive

1. DESCRIPTION:

BD54125 is a two-part, unfilled, room temperature cure, epoxy adhesive designed for bonding metals and plastics. The product gives very good vibration and impact resistance with high peel and shear strength. It has a low viscosity for good substrate penetration and adhesion. It gives excellent resistance to water, salt spray, inorganic acids and bases and most organic solvents. It is especially formulated for a 1:1 mix ratio for use in side by side cartridges, or to be used by hand mixing, or use with Meter Mix Equipment.

2. CHARACTERISTICS:

Room Temperature Cure Properties

Work Time:	20 to 30 minutes (at 75°F/ 24°C)
Fixture Time:	8 hours (at 75°F/ 24°C)
Full Cure:	8 hour movement; 24 – 48 hours for full properties
Operating Temp.	-40°F(40°C) to 300°F (150°C)
Mixed Density:	9.5 lbs/gal (1.15 g/cc)
Flash Point:	Greater than 200°C (392°F)
Viscosity:	Resin (Part A) 7,000 CPS Hard (Part B) 5,000 CPS
Color:	Resin (Part A) Clear Activator (Part B) Clear Mixed: Clear
Mix Ratio:	1 Part A to 1 Part B (1:1)
Hardness:	70 Shore D
Tensile Strength:	> 2,500 PSI (AL to AL)
Tensile Strength	7,100 PSI
Elongation:	5 %
Dielectric Constant:	6.3 (at 77°F/ 25°C, 1 KHz)
Volume Resistivity:	1.0 x 10 ¹¹ ohm-cm
Impact Resistance:	> 150 inch/lb
Water Absorption:	< 1% (24 hours)
Shelf Life:	24 Months
VOC Content:	0% by weight

3. Handling and Storage:

- A. Bring both components to room temperature prior to mixing. Mix 1 part A to 1 part B by volume or weight thoroughly for 30 seconds minutes.
- B. Dispense mixed material over properly positioned devices to be glued together. Do not pour more than 1/2" thick as the product may exotherm too high and may boil. As this is a very quick adhesive, you must work quickly to bond the pieces together.
- C. Parts may be shipped within 48 hours but parts can be moved in 8 hours.

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.