

BD54490 Epoxy Adhesive

1. DESCRIPTION:

BD54490 is a two-part, epoxy hybrid room temperature cure adhesive designed for industrial bonding, structural bonding, and anywhere high strength and toughness are required. This 2-part adhesive cures at room temperature and develops high strength, low shrink bonds to most materials including fiberglass, ceramics, metals and many plastics. It has great dimensional stability over a wide range of temperatures. Fully cured BD54490 is a durable with resistance to water, weather, ozone and oxygen, various solvents, fuels, oils, alcohols, mild acids and alkalis and many other organic compounds including diesel fuel and gasoline. It is especially formulated for a 2:1 mix ratio for use in side by side cartridges, or to be used by hand mixing, or use with Meter Mix Equipment.

A handling cure is normally achieved at room temperature within 120 minutes with a full cure at room temperature within 24 hours. To accelerate the final cure, or to quicken the handling simply elevate the temperature.

2. CHARACTERISTICS:

Room Temperature Cure Properties

Work Time:	90 minutes (at 75°F/ 24°C)
Fixture Time:	4 to 6 hours (at 75°F/ 24°C)
Full Cure:	24 to 48 hours for full properties
Operating Temp.	-60°F(-76°C) to 302°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) Non-Sag Paste Hard (Part B) Non-Sag Paste
Color:	Resin (Part A) Clear, grey, white, or black Activator (Part B) Off White
Mixed:	Off-white, grey, white, or black
Mix Ratio:	2 Part A to 1 Part B (2:1)
Hardness:	75 - 80 Shore D
Lap Shear Strength:	> 4,000 PSI (AL to AL)
Tensile Strength:	6,600 PSI
Elongation:	2.5%
Impact Resistance:	> 150 inch/lb
Water Absorption:	< 1% (24 hours)
Dielectric Constant	4.5 (at 25C, 100Hz)
Dielectric Strength	1,100 v/mil
Volume Resistivity	2.4 x 10 ¹⁴ ohm-cm
Shelf Life:	12 Months
VOC Content:	0% by weight

3. Handling and Storage:

- Bring both components to room temperature prior to mixing. Mix 2 parts A to 1 part B by volume or 213 grams part a to 100 grams part B by weight thoroughly for 30 to 60 seconds.
- Dispense mixed material over properly positioned devices to be glued together.
- Parts may be shipped within 48 hours but parts can be moved in 4 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.