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POLYBOND - 5

100% SOLID FAST SET EPOXY ADHESIVE

DESCRIPTION

Polybond-5 is a fast curing epoxy system that develops handling strength in approximately 3-5 minutes, even in thin films. It is formulated to have an easy 1:1 mixing ratio which will bond most metals, wood, plastic, concrete, and paper. It is very well suited to applications in electronics and general product assembly as well as for fiducial filling.

PROPERTIES – UNCURED

	Part A	Part B
Color , visual	Black	Neutral
Viscosity, ASTM-D-2393 (c.p.s. @ 25° C)..	12-14,000	8-10,000
Specific Gravity	1.2	1.1
Mix Ratio (by wt.)	1:1	
Mixed Viscosity, ASTM-D-2393 (@ 25° C)	14,000 cps	
Pot Life @ 25°C (100 grams)	3-5 minutes	
Shelf Life @ 70° F	12 months	

PROPERTIES – CURED

PHYSICAL

Flexural Modulus (psi)	3.0 x 10 ⁴
Thermal Shock	Passes
Operating Temperature (°C)	-60 – 140
Lap Shear Strength, psi	
Aluminum to Aluminum	1800
SS304, Abraded	2200
Electrogalvanized Steel, IPA Wipe	1900
ABS, IPA Wipe	550
Brass, Abraded	1800
Copper, Abraded	1100
Dielectric Strength, ASTM-D-149 (volts/mil)	370
Volume Resistivity, ASTM-D-257 (ohm-cm)	1.8 x 10 ¹²
Hardness, ASTM-D-2240 (Durometer, Shore D) ...	83-85

MIXING INSTRUCTIONS

Pre-mix Part A and Part B separately. Then measure 1:1 parts by volume (A to B). Mix thoroughly scraping the sides and bottom of the container and apply immediately. In the case of cartridges, place tube in the dispensing machine and attach the mixing head. Dispense amount as needed for application.

CURE SCHEDULE

Room temperature 70-75°F will cure in 5-7 minutes.

PACKAGING

2lb Kit	1lb Part A+ 1lb Part B
Gallon Kit	1 Gallon Part A + 1 Gallon Part B
50ml Kit	50ml Cartridge
400ml Kit	400 ml Cartridge