Laboratory Data Sheet

Armstrong A-40 Epoxy Resin Adhesive

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PRODUCT DESCRIPTION

Armstrong A-40 Resin system consists of two components Part A and Part B which are mixed together prior to use. Part A consists of an epoxy resin and inert fillers. Part B consists of a polyamide amide and inert fillers. The working life of a 175 gram quantity of A-40 will be as follows:

@ 55°F	Approximately three hours
@ 70°F	Approximately 2 - 21/2 hours
@ 90°F	Approximately 45 minutes

The mix ratio for A-40 is 5 parts of Part A to 2 parts of Part B by weight. The concentration of Part B may be varied = 10% of the recommended amount without seriously affecting the physical properties other than the working life. For best results, the temperature of the Part A and Part B should be between 70° to 90°F. Before mixing. Lower and higher temperatures can be employed but the working life will be reduced as the temperature is increased and the working life will be extended as the temperature decreases. At lower temperatures, the material is quiet vouches and not as easy to mix.

A-40 should not be thinned with solvent at any time. The Part A and the Part B must be thoroughly mixed before the system is ready for use.

Storage

Store below 25°C out of sunlight and in original unopened containers. Refer to packaging specific quote for shelf life information.

Surface Preparation

Surfaces to be bonded should be clean and dry. For critical applications, refer to our suggested surface preparation procedures -- Bulletin No. 964

Method of Application

Property mixed material may be applied to the surfaces being bonded with a mechanical applicator or any clean tool such as a metal spatula, trowel, wooden coffee-stirrer, or equivalent. The material should be spread thinly and evenly. Glue lines as thick as 0.101" will provide good strength but the general rule is-- the thinner the better. The important thing is that the surfaces being bonded are thoroughly "wetted out" with the resin system. Once applied, the joints being bonded should be assembled immediately; under no circumstances would this open assembly times exceed 30 minutes. No pressure is required other than that necessary to hold to assembly in position until the resin cures. Then uncured material may be removed from mixing utensils etc. with solvent such as Methyl Ethyl ketone (MEK) and/ or Cellosolve or equivalent.

Cure Schedule

A-40 should be cured as follows: 7 days at room temperature or 2 hours at 210°F. Where military specification qualification is necessary the 2 hour cure at 210°F must be followed.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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