

EPIBOND® 1210 A-1/B Epoxy Adhesive

Product Description

EPIBOND® 1210 A-1/B epoxy adhesive is a two-part system with a semi-paste consistency. This adhesive product is ideal for spacecraft applications due to its low outgassing properties. EPIBOND® 1210 B hardener can be used at varying ratios up to 100 parts by weight with EPIBOND® 1210 A-1 resin to achieve a more flexible bondline. EPIBOND® 1210 A-1/B epoxy adhesive may be applied by brush, spatula, or automatic dispensing equipment. The epoxy adhesive is designed for bonding metal, wood, wood products, glass, ceramics, most plastics and many other materials.

Features

- General purpose adhesive
- Room temperature cure
- Variable properties

Typical Properties*

Property	Test Method	1210 A-1 Resin	1210 B Hardener	Mixed System
Appearance	Visual	Tan	Tan	Tan
Density at 25°C, g/cm ³	ASTM D792	1.5	1.00	1.30
Viscosity at 25°C, cP	ASTM D2393	250,000	30,000	Semi-paste
Flash point, COC, °F (°C)	ASTM D92	490 (254)	275 (135)	--
Solids, %	ASTM D1644	--	--	100

*Properties are based on Huntsman test methods. Copies are available upon request.

Processing

Mix Ratio

Product	Parts by weight
EPIBOND® 1210 A-1 Resin	100
EPIBOND® 1210 B Hardener	65

Material temperatures should be above 65°F (18°C) when mixing. Mix both components thoroughly for several minutes to insure complete and uniform mixing. Up to 100 parts by weight of Epibond® 1210 B hardener may be used for more flexible bonds.

Processing Data

Parameter	Value
Work life, 100 g at 25°C, min	50 - 75
Typical cure cycles	48 hours at 23 - 26°C, or 2 hours at 66°C

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

Property	Test Method	Value
Maximum service temperature, °F (°C)	ASTM D648	200 (93)
Tensile lap shear, psi (MPa) Al-Al at 25°C steel to steel at 25°C steel to steel at 66°C polyester to polyester at 25°C	ASTM D1002	2,500 (17.2) 2,500 (17.2) 500 (3.4) 1,800 (12.4)
Fluid Immersion 7 days at 23°C, psi (MPa) JP-4 Skydrol Distilled water	ASTM D1002	2,550 (17.5) 2,600 (17.9) 2,700 (18.6)
Hardness, Shore D	ASTM D2240	80
CTE, ppm/°C		α1: 76.6ppm/C α2: 216.7ppm/C
Thermal Conductivity, W/mK		0.41
Outgassing TML, % CVCM, %	ASTM E595	0.65 0.01

Storage

EPIBOND® 1210 A-1/B should be stored in a dry place in the original sealed containers at temperatures between 2°C and 40°C (36°F and 104°F). After use, tightly reseal containers. Under these storage conditions, and when supplied under Huntsman standard certification, the product has a shelf life of **1 year** from date of shipment. The product should not be exposed to direct sunlight.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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