

**Advanced Materials****Epibond<sup>®</sup> 1539-A/B-10****EPOXY PASTE ADHESIVE**

- Bonds Plastic and Metal
- Good Composite Bonding

**DESCRIPTION :**

Epibond<sup>®</sup> 1539-A/B-10 epoxy adhesive is a blue, two-part paste developed specifically for bonding thermoset, fiberglass reinforced plastics, metals and a variety of other materials. Epibond<sup>®</sup> 1539-A/B-10 epoxy adhesive meets the requirements of BMS 5-25C, Type 2, Grade 1. Surfaces to be bonded should be clean and thoroughly degreased. Best results are achieved on metal surfaces which have been chemically cleaned.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>1539-A Resin</u>	<u>1539-B-10 Hardener</u>	<u>1539-A/B-10 System</u>	<u>Test Method</u>
Color	Off-White	Blue	Blue	Visual
Density, g/cc.	1.10	1.05	1.10	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	Paste	Paste	Paste	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), hours	--	--	2	ASTM-D-2471

**MIX RATIO :**

To 100 parts by weight of Epibond 1539-A resin, add 89 parts by weight of Epibond<sup>®</sup> 1539-B-10 hardener. Mix both components thoroughly insure adequate mixing.

**CURE SCHEDULE**

24 hours at 77°F (25°C), or gel at room temperature plus 30 minutes at 250°F (121°C).



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