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Product Data

EPIBOND® 420-A/B STRUCTURAL EPOXY ADHESIVE

- Room-temperature Cure Paste
- Extremely Tough and Resilient

DESCRIPTION

Epibond 420-A/B structural epoxy adhesive is a two-component, modified epoxy, room-temperature curing paste with high strength and toughness. It is suitable for a wide variety of metal, honeycomb and fiber-reinforced composite bonding applications requiring high shear strength and good peel strength. Epibond 420-A/B structural epoxy adhesive replaces REDUX 410 NA epoxy adhesive and meets the requirements of BMS 5-107.

TYPICAL PROPERTIES AS RECEIVED

<u>Property</u>	<u>420-A Resin</u>	<u>420-B Hardener</u>	<u>420-A/B System</u>	<u>Test Method</u>
Color	Yellow	Blue	Blue-green	Visual
Density, g/cc.	1.1	1.0	1.05	ASTM-D-792
Viscosity, cP at 77°F (25°C)	140,000	900	Semi-paste	ASTM-D-2196
Work life, minutes, at 77°F (25°C)	--	--	70	ASTM-D-1338
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

MIX RATIO

To 100 parts by weight of Epibond 420-A resin, add 40 parts by weight of Epibond 420-B hardener. Mix both components for several minutes until uniform color indicates complete blending. Epibond 420-A/B epoxy adhesive may also be mixed at 2:1 parts by volume and is available in Accumix™ cartridges with mixing nozzles.

CURE SCHEDULE

Seven days at 77°F (25°C) or gel at room temperature plus two hours at 140°F (60°C) or 90 minutes at 175°F (79°C) or one hour at 250°F (121°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Property</u> (after one hour at 250°F/121°C)	<u>Result</u>	<u>Test Method</u>
Lap shear strength, AL/AL, at 77°F (25°C), psi (MPa)	3500 (24.1)	ASTM D-1002
Insert shear strength, psi (MPa), as cured	1500 (10.3)	BMS 5-107
after 30 days at 140°F (60°C), 95% R.H.	1400 (9.6)	--

CAUTION:

Huntsman Advanced Materials Americas Inc. maintains up-to-date Material Safety Data Sheets (MSDS) 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. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to adhesives_group@huntsman.com.

FIRST AID!

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation: Remove subject to fresh air.

Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

IMPORTANT LEGAL NOTICE:

Sales of a referenced product ("Product") are subject to the general terms and conditions of sale of Huntsman Advanced Materials Americas Inc. ("Huntsman").

WARRANTY: Huntsman warrants to the Buyer that the Product will conform to the published specifications for that Product at the time of manufacture, and that the Product will be free from defects in material and workmanship in normal use.

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