

EPIBOND® 1210 A-1 / 9615 A Epoxy Adhesive

Product Description

EPIBOND® 1210 A-1/9615 A epoxy adhesive is a two-part system with a paste consistency. This adhesive product is ideal for spacecraft applications due to its low outgassing properties. EPIBOND® 1210 A-1/9615 A epoxy adhesive may be applied by 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

Typical Properties*

Property	Test Method	1210 A-1 Resin	9615 A Hardener	Mixed System
Appearance	Visual	Tan	Tan	Tan
Density at 25°C, g/cm ³	ASTM D792	1.5	1.1	1.3
Viscosity at 25°C, cP	ASTM D2393	250,000	Paste	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
Hardener 9615 A	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.

Processing Data

Parameter	Value
Work life, 100g at 25°C, min	50 - 75
Typical cure cycles	48 hours at 23 - 26°C or
	3 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	Condition	Value
Maximum service temperature, °F (°C)	ASTM D648	N/A	200 (93)
Tensile lap shear, psi (MPa)	ASTM D1002	Al-Al at 25°C (cured 25°C / 2 days) Al-Al at 25°C (cured 25°C / 2h + 121°C / 30min) Al-Al at 150°C (302°F) Steel to steel at 25°C polyester to polyester at 25°C	2,500 (17.2) 3,100 (21.3) 525 (3.6) 1,800 (12.4) 1,500 (10.3)
Fluid Immersion (7 days at 75°F(23°C)), psi (MPa)	ASTM D1002	JP-4 Skydrol Distilled water	2,000 (13.8) 2,000 (13.8) 2,300 (15.9)
CTE (TMA)	Huntsman	Above transition Below transition	α 1: 73.5ppm/C α 2: 132.4ppm/C
Thermal Conductivity, W/mK	C-Therm TCi	N/A	0.45
Heat Capacity, J/Kg/K	C-Therm TCi	N/A	700
Hardness, Shore D	ASTM D2240	at 25°C	80

Storage

EPIBOND® 1210 A-1 / 9615 A 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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