



# 10-3500 5 MINUTE SET STRUCTURAL ADHESIVE

## DESCRIPTION:

This high bond strength adhesive is 100% solids, two component and has a non-sag consistency with a quick setting time of 5 minutes at room temperature. It is excellent for bonding plated metals, pewter, glass, wood, ceramic, felt, cement, gem stones, most plastics and rubbers, etc...

This adhesive was tested in our laboratory for flame retardency properties. According to our test results, it meets the requirements of UL94HB.

## APPLICATIONS:

This unique adhesive is ideally suited for a wide range of electronic, electrical, industrial, structural, and jewelry applications. It is also an excellent choice for field repairs. 10-3500 is offered in the popular TriggerBond® dual barrel cartridge dispensing system.

## FEATURES:

- High bond strength
- Fast room temperature cure
- Water and chemical resistance
- Outstanding thermal shock resistance
- 1:1 mix ratio
- Impact resistance

## TYPICAL SPECIFICATIONS

Color	Dark Gray
Mix ratio by volume	1:1
Resin viscosity, 25°C cps	50,000
Hardener viscosity, 25°C cps	85,000
Mixed viscosity, 25°C cps	Non-sag paste
Solids content, %	100
Specific gravity, 25°C	1.15
Shore D hardness	86
Work Life, 25°C, minutes	3-5
Handling time, 25°C, minutes	15-20
Full Cure, 25°C, hours	24-48
Coefficient of thermal expansion (in/in/°C)	$60 \times 10^{-6}$
Operating temperature range, °C	-50 to +130
Tensile Lap Shear strength, psi	
Aluminum (etched)	1,500
Tensile Strength, psi	7,100
Tensile Elongation, %	3-5
Dielectric strength, V/mil	420
Volume resistivity, ohm-cm at 25°C	$2.0 \times 10^{14}$
Dielectric constant, 1KHz at 25°C	4.00
Dissipation factor, 1KHz at 25°C	.017

epoxies.com

21 Starline Way  
Cranston, RI 02921 USA

t 401.946.5564

f 401.946.5526

**INSTRUCTIONS FOR USE:**

1. Thoroughly mix equal parts of resin to catalyst by weight or volume.
2. Apply evenly to both surface(s) to be bonded.
3. Application to the substrates should be made within five minutes. Larger quantities and/or higher temperatures will reduce the working time. Avoid mixing large quantities and/or at high temperature due to the possibility of creating a high exothermic temperature.
4. Join the coated surfaces. Allow to cure at 60°F (16°C) or higher until adhesive is set. Heat may be added up to 200°F (93°C) to accelerate the cure.
5. Avoid moving parts during cure. Pressure to the substrates is recommended. Maximum shear strength is obtained with a 3-5 mil bond line.

**PREPARATION OF SURFACES:**

Surfaces to be bonded must be clean and grease free. Adhesion can be substantially increased by abrading the surface with emery cloth, sand paper, etc... A roughened porous surface will produce the best results. Any oxidized metal films should be removed just prior to application of the adhesives.

**AVAILABILITY:**

Available in the TriggerBond® 50ml, 75ml, 200ml and 400ml dual barrel cartridges.

**SHELF LIFE:**

12 months at 25°C from the date of manufacture.

**IMPORTANT:**

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