EPOXIES
INNOVATIVE BONDING SOLUTIONS ETC.

TECHNICAL BULLETIN

10-3092
HIGH PERFORMANCE EPOXY ADHESIVE

DESCRIPTION:
10-3092 is a two-component, high strength epoxy adhesive system. This adhesive is formulated with fiberglass for added impact, compression and thermal shock resistance. 10-3092 is a reliable bonding agent with excellent electrical insulation properties.

BENEFITS:
- Fiberglass reinforced for added strength
- Bonded parts can withstand thermal shock
- Can be cured with a variety of curing agents
- Provides good chemical resistance

TYPICAL PROPERTIES:

Viscosity, 25°C, cps,	
Mixed with Cat.190	26,000
Mixed with Cat.145	3,500
Mixed with Cat.30	32,000
Mix Ratio (Resin:Catalyst)	
Cat.190	100:6.5
Cat.145	100:15
Cat.30	100:13
Color	Black
Hardness, Shore D	80
Operating Temperature Range, °C	
Cat.190	-40 to +135
Cat.145	-65 to +110
Cat.30	-55 to +155
Pot Life, 100 grams, 25°C	
Cat.190	45 min.
Cat.145	60 min.
Cat.30	> 4 hrs.
Specific Gravity, 25°C,	
Resin	1.54
Cat.190	0.99
Cat.145	1.0
Cat.30	0.995
Glass Transition Temperature, °C	
Cat.190	91
Cat.145	65
Cat.30	110

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Tensile Lap Shear, psi	
Cat.190	3,500
Cat.145	3,000
Cat.30	4,000
Coefficient of Thermal Expansion, °C	45×10^{-6}
Thermal conductivity, W/m·K	0.504
Dielectric strength, V/mil	400
Volume resistivity, 25°C, ohm-cm	10^{14}

PREPARATION OF SURFACES:

Surfaces must be clean and grease free. Adhesion can be substantially increased by abrading the surfaces to be bonded with emery cloth, sandpaper, carbide grinding tools, and sand blasting. A roughened, porous surface will produce the best results. Any oxidized metal films should be removed just prior to application of the epoxy adhesive mixture.

INSTRUCTIONS FOR USE:

ROOM TEMPERATURE CURING WITH CATALYST 190

Catalyst 190 is designed for applications requiring a room temperature curing system with excellent physical and electrical insulation properties.

1) By weight, thoroughly mix 100 parts 10-3092 epoxy to 6.5 parts Catalyst 190.
2) Cure according to one of the following schedules:

25°C	24 hours
45°C	4-6 hours
65°C	1-2 hours

ROOM TEMPERATURE CURING WITH CATALYST 145

Catalyst 145 is designed for applications requiring a room temperature curing system with excellent thermal shock and low temperature performance.

1) By weight, thoroughly mix 100 parts 10-3092 epoxy to 15 parts Catalyst 145.
2) Cure according to one of the following schedules:

25°C	24 hours
45°C	4-6 hours
65°C	2-4 hours

HEAT CURING WITH CATALYST 30 (Recommended for higher operating temperature and physical property applications):

Catalyst 30 is designed for applications requiring the optimum in electrical insulation, physical and thermal properties.

1) By weight, thoroughly mix 100 parts 10-3092 epoxy to 13 parts Catalyst 30.
2) Pour and cure according to one of the following recommended cure schedules:
   a) 85°C (185°F) 3-4 hours
   b) 100°C (212°F) 2-3 hours

   For optimum performance, an additional 2 hours @ 365°F (185°C) is recommended.

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STORAGE, HANDLING & SAFETY:

Store both components at 25 °C in original containers. Store away from excessive heat and humidity. The expected shelf life is 12 months in original containers.

Please read the Safety Data Sheet before using this or any other chemical.

AVAILABILITY:

10-3092 is available in quart and gallon containers.

IMPORTANT:

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