

# Fast Cure Thixotropic Epoxy Adhesive

## 10-3005 HV – 5 MINUTE SET HIGH VISCOSITY EPOXY

### DESCRIPTION:

This high bond strength adhesive is a clear 100% solids, two component, high viscosity adhesive 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...

### 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. It is offered in the popular TriggerBond® dual barrel cartridge dispensing system and bulk packaging.

### FEATURES:

- Slightly Thixotropic consistency
- High bond strength
- Fast room temperature cure
- Water & chemical resistance
- Outstanding thermal shock resistance
- 1:1 mix ratio
- Impact resistance

### TYPICAL SPECIFICATIONS (10-3005HV)

Color	Semi-transparent (available in black)
Mix ratio by volume	1:1
Mixed viscosity, 25°C cps*	Slightly Thixotropic, Approximately 35,000 to 45,000
Solids content, %	100
Specific gravity, 25°C	1.15
Shore D hardness	
10-3005HV	86
Work Life, 25°C, minutes	
10-3005HV	3-5
Handling time, 25°C, minutes	
10-3005HV	15-20
Cure time, 25°C, hours	24-48
Coefficient of thermal expansion (in/in/°C)	60x10 <sup>-6</sup>
Operating temperature range, °C	-50 to +130
Dielectric strength, V/mil	420
Izod Impact ft-lb/in	2.7
Dielectric constant, 1KHz at 25°C	4.00
Dissipation factor, 1KHz at 25°C	.017
Volume resistivity, ohm-cm at 25°C	2.0 x 10 <sup>14</sup>

Shear strength, psi	
Aluminum (etched)	1,500
Cold rolled steel	1,000
Copper	960
Brass	725
Stainless Steel	750
Galvanized Steel	900
ABS	500
PVC	335
Polycarbonate	250
Compression strength, psi	8,500
Coverage, .005 in. thick bond line, sq. ft./gallon	320

\* Also available in lower viscosity version (10-3005)

### 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. Also packaged in quarts, gallons, and 5 gallon pails.

### IMPORTANT:

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