



A Meridian Adhesives Group Company

Fast Cure Epoxy Adhesives

10-3005: 5 MINUTE SET EPOXY

10-3020: 20 MINUTE SET EPOXY

10-3046: 46 MINUTE SET EPOXY

DESCRIPTION:

These high bond strength adhesives are clear 100% solids, two component, low viscosity adhesives with a quick setting time of 5-46 minutes at room temperature. They are excellent for bonding plated metals, glass, wood, ceramic, felt, cement, gemstones, most plastics, rubbers, etc...

These adhesives were tested in our laboratory for flame retardancy properties. According to our test results they meet the requirements of UL94HB.

APPLICATIONS:

These unique adhesives are ideally suited for a wide range of electronic, electrical, industrial, structural, and jewelry applications. They are also an excellent choice for field repairs and are offered in the popular TriggerBond® dual barrel cartridge dispensing system and bulk packaging.

FEATURES:

- High bond strength
- Fast room temperature cure – three speeds to choose from
- Water and chemical resistance
- Outstanding thermal shock resistance
- 1:1 mix ratio
- Impact resistance

TYPICAL SPECIFICATIONS (10-3005)

Mixed Viscosity, 25°C, cps *	12,000
Color	Clear (available in black)
Hardness, Shore D	
10-3005	86
10-3020	72
10-3046	65
Mix Ratio by Volume	1:1
Work Life, 25°C, minutes	
10-3005	3-5
10-3020	10-15
10-3046	25-30
Handling Time, 25°C, minutes	
10-3005	15-20
10-3020	30-35
10-3046	55-60
Operating Temperature Range, °C	-50 to +130
Specific Gravity, 25°C	1.15
Cure time, 25°C, hours	24-48
Solids content, %	100



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Dielectric Constant, 25°C, 1 kHz	4.00
Dissipation Factor, 25°C, 1 kHz	.017
Dielectric Strength, V/mil	420
Volume Resistivity, 25°C, ohm-cm	2.0×10^{14}
Coefficient of Expansion, 1/k	60
Izod Impact, ft-lb/in.	2.7
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. bond line, sq. ft./gallon	320

* Also available in Non-Sag versions (10-3005NS, 10-3020NS, 10-3046NS).

INSTRUCTIONS FOR USE:

1. Thoroughly mix equal parts of resin to catalyst by weight or volume.
2. Apply evenly to both surfaces within five minutes. Larger quantities and/or higher temperatures will reduce the working time and may create a high exothermic reaction.
3. Join the coated surfaces. Cure at 16°C or higher until adhesive is set. Heat may be added up to 93°C to accelerate the cure.
4. 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 sandpaper or similar. A roughened porous surface will produce the best results. Any oxidized metal films should be removed just prior to application of the adhesives.

PACKAGING:

Available in Triggerbond® 50ml, 75ml, 200ml and 400ml dual barrel cartridges. Also packaged in quarts, gallons, and 5-gallon pails.

STORAGE & HANDLING:

Store at room temperature. Expected shelf life is 12 months in original unopened containers. Please read the Safety Data Sheet before using this or any other chemical.

IMPORTANT:

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