



TECHNICAL INFORMATION Provisional

EPOCAP® 43649/EPOWELD® 58173 Epoxy Adhesive System

PRODUCT DESCRIPTION

EPOCAP 43649/EPOWELD 58173 is a two-component, room temperature cure epoxy system. It is fast setting and has a convenient 1:1 mix ratio by volume. This system is recommended for a variety of adhesive applications.

HOW TO USE

Stir parts A & B separately in their original containers. Weigh out the correct proportions of parts A & B. Mix thoroughly.

MIXING AND CURING SCHEDULE

<u>Ratio</u>	<u>Part A</u>	<u>Part B</u>
By weight	100	93
By volume	100	100

The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties. The recommended schedule to achieve the typical properties is shown below:

24 hours at 25°C (77°F)

TYPICAL UNCURED PROPERTIES

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Black	Amber	Black
Viscosity @ 25°C, cps	12,000	10,000	10,000
Weight per Gallon, lbs.	10.1	9.4	9.75
Specific Gravity @ 25°C	1.21	1.13	1.17
Gel time, 4g mass @ 25°C, mins.	---	---	5
Shelf Life (in separate sealed containers), months	12	12	---

TYPICAL CURED PROPERTIES

(Tested at 25°C unless otherwise indicated)

<u>Test</u>	<u>Result</u>
Hardness, Shore D	85
Tensile Lap Shear, psi, Aluminum to Aluminum	2845

STORAGE AND HANDLING

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60 °F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products. A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes. For more information on proper recommendations and procedures, contact the Technical Department.

SAFETY

These materials are intended for industrial use only and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, care should be taken in handling. Use adequate ventilation in the work area.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water.

In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheets for additional information.

ADDITIONAL INFORMATION

Visit our web site at:

www.royaladhesives.com

Contact us at:

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NOTE

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