1 Industrial Circle, Lincoln, RI 02865, USA
Phone: (401) 726-4500 ■ Fax: (401) 726-4502
Email: info@epoxyset.com ■ Web: www.epoxyset.com

TECHNICAL BULLETIN

EPOXIBOND-103F
FAST CURE, LOW VISCOSITY EPOXY ADHESIVE

EPOXIBOND-103F is a clear epoxy resin system for use as an adhesive and for casting of small electrical components. This two part system with non critical 1 to 1 mixing ratio, and fast room temperature curing system, gives high impact and bond strength. It can be used for bonding glass, metals, woods and some plastics. It is also a good choice for field use.

TYPICAL HANDLING PROPERTIES:

Epoxibond	EB-103F
Hardener	EH-1
Mix ratio by weight, (Resin/Hardener)	100/100
Mixed Viscosity at 25°C, cp	4,000-6,000
Pot Life at 25°C (100 grams), minutes	15

Recommended Cure **24 hr at 25°C**

TYPICAL CURED PROPERTIES AFTER RECOMMENDED CURE:

(Tested @ 25°C unless otherwise indicated)

Color	Clear
Specific Gravity	1.1
Hardness, Shore D	65
Lap Shear Strength to Aluminum, psi	
At -55°C	2300
At 25°C	2350
At 95°C	150
Tensile Strength, psi	3000
Service Temperature range, °C	-55 to 90
Glass Transition Temperature, °C	40
Coefficient of Linear Thermal Expansion, 10^{-6}/°C	
Below Tg	100
Dielectric Strength, volts/mil	600
Dielectric Constant, 1 kHz	3.2
Dissipation Factor, 1 kHz	0.03
Volume Resistivity, ohm-cm	$1x10^{15}$

INSTRUCTIONS FOR USE:

1. Weigh each 100 grams of EB-103F to 100 grams of Hardener EH-1.
2. Mix until uniform. Scrape the sides and bottom of container repeatedly during mixing.
3. Apply to clean bonding surfaces and cure as recommended to achieve the desired properties. Typical cured properties were determined using recommended cure schedule. Some difference in properties may occur with the alternate or other cure schedules.

FROZEN ADHESIVE:

Thaw premixed frozen adhesive at room temperature for 5-10 minutes. Dispense adhesive and cure at recommended schedules**.**

AVAILABILITY:

2 parts Kit - Packaged in Pint, Quart, Gallon, and 5-Gallon size.

FOR INDUSTRIAL USE ONLY:

Practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

WARNING!

Adequate ventilation of work place and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. In case of skin contact, wash thoroughly with soap and water. For eyes, flush immediately with plenty of water for at least 10 minutes and seek medical attention. Refer to Material Safety Data Sheet **(MSDS)** for additional health and safety information.