ISO 9001-2015 Certified

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TECHNICAL BULLETIN

EPOXIBOND EB-260
HIGH STRENGTH, TOUGHENED EPOXY ADHESIVE

EB-260 is a toughened, high strength, structural epoxy adhesive. This adhesive has an excellent combination of shear and peel strength. It has also excellent impact and vibration resistance and low temperature flexibility. This high-performance epoxy adhesive exhibits very good physical, thermal, and electrical insulation properties.

It is recommended for bonding engineering thermoplastics, SMC (sheet molding compounds) in aerospace and automotive applications. **EB-260** is also recommended for bonding gold club heads.

TYPICAL HANDLING PROPERTIES:

Epoxibond	260-A
Hardener	260-B
Mix ratio (Resin/Hardener) - by weight	100/48
Mix ratio (Resin/Hardener) - by Volume	100/50
Mix viscosity (25°C), cps	30,000-40,000
Pot Life at 25°C (20 grams), minutes	60-80
Recommended Cure	24hrs/25°C
Alternate Cure	1 hr/65°C

TYPICAL CURED PROPERTIES AFTER RECOMMENDED CURE:

(Tested @ 25°C unless otherwise indicated)

Color	Off-White
Specific Gravity	1.14
Hardness, Shore D	77
Lap Shear Strength at temperature, psi	
-55°C (-67°F)	4500
25°C (77°F)	4500
82°C (180°F)	2200
120°C (248°F)	400
T-peel strength to aluminum, 25°C, pli (5-8mil bondline)	50
Service Temperature range, °C	-55 to 120
Glass Transition Temperature, °C	60
Coefficient of Linear Thermal Expansion, 10^{-6}/°C	
Below Tg	77
Above Tg	195
Dielectric Strength, Volts/mil	900
Dielectric Constant, 1 kHz	4.28
Dissipation Factor, 1 kHz	0.4
Volume Resistivity, ohm-cm	$2x10^{15}$

INSTRUCTIONS FOR USE:

1. Mix at room temperature, 100 grams of Part-A with 48 grams of Part-B and vacuum degas.
2. Cure as recommended achieving the desired properties.
3. Typical cured properties were determined using recommended cure schedule.
4. Some difference in properties may occur with the alternate or other cure schedules.

FOR INDUSTRIAL USE ONLY:

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.

PACKAGING OPTIONS:

Available in Pint, Quart, Gallon, and 5-gallon kits.
Also available in 50mL,200, and 400mL dual cartridge systems.

WARNING!

Although the system contains low volatility materials, care should be taken in handling. 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 Safety Data Sheet (SDS) for additional health and safety information.

SHELF LIFE:

The shelf life of these materials is greater than two years when stored in unopened containers at an average temperature of 25°C.

DISCLAIMER: All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.