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TECHNICAL BULLETIN

EPOXIBOND™ EB-290

HIGH STRENGTH, TOUGHENED EPOXY ADHESIVE

EB-290 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-290 is also recommended for bonding gold club heads.

TYPICAL HANDLING PROPERTIES:

Epoxibond	290-A
Hardener	290-B
Mix ratio by vol, (Resin/Hardener)	2/1
Mix viscosity (25°C), cps	20,000-30,000
Pot Life at 25°C (20 grams), minutes	120
Recommended Cure	2 hrs/65°C
Alternate Cure	24-48/25°C

TYPICAL CURED PROPERTIES AFTER RECOMMENDED CURE:
(Tested @ 25°C unless otherwise indicated)

Color	Off-White
Specific Gravity	1.1
Hardness, Shore D	82
Lap Shear Strength at temperature, psi	
Aluminum (etched & abraded)	4800
Aluminum (anodized)	2000
Stainless Steel	3500
Polycarbonate	1050
ABS	1000
Elongation, %	8-10
Service Temperature range, °C	-55 to 120
Glass Transition Temperature, °C	91
Coefficient of Linear Thermal Expansion, 10^{-6}/°C	
Below Tg	77
Above Tg	195
Dielectric Strength, Volts/mil	700
Dielectric Constant, 1 kHz	4.28
Dissipation Factor, 1 kHz	0.4
Volume Resistivity, ohm-cm	$2x10^{15}$

INSTRUCTIONS FOR USE:

1. Insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger.
2. Remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely.
3. Attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive.

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 50ml, 200ml, and 400ml dual cartridge systems.

WARNING!
Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of workplace 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 one (1) year 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.