

Epibond[®] 1210A / 9615-10 Epoxy Adhesive

Product Description

Epibond[®] 1210 A / 9615-10 epoxy adhesive is a two-part system with a semi-paste consistency. The blue Hardener 9615-10 is mixed with the tan Epibond[®] 1210 A until a completely uniform color is achieved. Epibond[®] 1210-A / 9615-10 epoxy adhesive may be applied by brush, spatula, or automatic dispensing equipment. The adhesive is designed for bonding metal, wood, wood products, glass, ceramics, most plastics and many other materials.

Features

- Non-structural adhesive
- Long work life
- Room temperature cure

Typical Properties*

Property	Test Method	1210-A Resin	9615-10 Hardener	Mixed System
Appearance	Visual	Tan	Blue	Grey-blue
Density at 25°C, g/cm ³	ASTM D792	1.5	1.03	1.3
Viscosity at 25°C, cP	ASTM D2393	250,000	100,000	Semi-paste
Solids, %	ASTM D1644	--	--	100

*Properties are based on Huntsman test methods. Copies are available upon request.

Processing

Mix Ratio

Product	Parts by weight
Epibond [®] 1210 A Resin	100
Hardener 9615-10	50

Material temperatures should be above 65°F (18°C) when mixing. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

Processing Data

Parameter	Value
Work life, 100g at 25°C	3 - 4 hours
Typical cure cycles	48 hour at 23 - 26°C, or
	Gel at RT + 1 hour at 93°C

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

Property	Test Method	Value
Lap shear strength, Al-Al, psi (MPa) -65°F (-55°C) 77°F (25°C) 180°F (82°C)	ASTM D1002	2,800 (19.3) 2,500 (17.2) 800 (5.5)
Tg (DMA), °F (°C)	E' Onset Tan δ peak	Huntsman 165 (74) 212 (100)
CTE (TMA), ppm/°C	α1: Below transition α2: Above transition	Huntsman 80.0 206.9
Thermal Conductivity, W/mK	C-Therm TCi	0.40
Hardness, Shore D	ASTM D2240	80

Storage

Epibond® 1210-A/9615-10 should be stored in a dry place in the original sealed containers at temperatures between 2°C and 40°C (36°F and 104°F). After use, tightly reseal containers. Under these storage conditions, and when supplied under Huntsman standard certification, the product has a shelf life of **1 year** (from date of shipment). The product should not be exposed to direct sunlight.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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