

**Advanced Materials****Epibond® 1217 A/B Epoxy Adhesive**

- **Quick Set Adhesive**
- **Room Temperature Cure**
- **One to One Mix Ratio**

**DESCRIPTION**

Epibond® 1217 A/B epoxy adhesive is a two-part, translucent white paste that cures quickly at 77°F (25°C). It is recommended for bonding steel, aluminum, wood, ceramics and a variety of polymeric substrates.

**TYPICAL PROPERTIES AS RECEIVED**

Property	Test Method	1217 A Resin	1217 B Hardener	Mixed System
Color	Visual	Translucent	Amber	Translucent
Density, g/cc	ASTM D792	1.20	1.18	1.19
Viscosity at 77°F (25°C), cP	ASTM D2196	Paste	90,000	Paste
Gel Time, 50g at 77°F (25°C), min	ASTM D2471	--	--	4-8

**MIX RATIO**

To 100 parts by weight of Epibond® 1217 A resin, add 100 parts by weight of Epibond® 1217 B hardener or 1:1 by volume. Mix only that quantity which can be applied immediately after mixing. Due to the very fast setting properties of Epibond® 1217 A/B, hand mixing of the components should preferably be avoided. Epibond® 1217 A/B is available in 50 mL twin cartridges. For best results, Epibond® 1217 A/B should be dispensed using manual or pneumatic dispensing equipment through a 0.25 in diameter, 20 element static mixing nozzle (Nordson EFD #7701488), or equivalent.

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**CURE SCHEDULE**

One to two hours at 77°F (25°C).

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**TYPICAL CURED PROPERTIES** (Not for specification purposes)

Test	Test Method	Results
Tensile lap shear, Al-Al, psi (MPa)	ASTM D1002	
at -67°F (-55°C)		1350 (9.3)
at 77°F (25°C)		2500 (17.2)
at 180°F (83°C)		500 (3.4)

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**STORAGE**

Epibond® 1217-A/B should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). The product should not be exposed to direct sunlight. Under these storage conditions, and when supplied under Huntsman standard certification, this product has a shelf life of 1 year from date of shipment (expiration date may differ based on customer specification).

Material temperatures should be above 18°C (65°F) when mixing. After use, tightly reseal containers.

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**PRECAUTIONARY STATEMENT**

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) 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 MSDS as mentioned above.

**KEEP OUT OF REACH OF CHILDREN****FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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