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## 119-01

### GRAY, FAST CURING EPOXY ADHESIVE

**DESCRIPTION:** 119-01 is a two component, very fast curing epoxy adhesive. Product is designed to bond to plastics, metals and ceramics. Part A (black) and Part B (white) allows for easy and reliable indication of proper mixing. 119-01 exhibits unsurpassed resistance to moisture, freon and thermal degradation.

	<u>Part A</u>	<u>Part B</u>
Appearance:	Black	White
Viscosity:	Paste	Paste
Mix Ratio (parts by weight):	60	70
Mix Ratio (parts by volume):	1	1
Specific Gravity:	1.32	1.53

**MIXING & CURING INSTRUCTIONS:** Mix equal volumes of Part A and Part B until uniform gray color is obtained. To get best results, mix gently but thoroughly without beating air into product. Keep in mind that this is a fast curing system. Product will start to gel in approximately four (4) minutes at normal room temperature and be hard in less than six (6) minutes. Fixturing devices can be removed when product is hard to the touch, i.e., usually about ten (10 ) minutes. Full properties are obtained within a normal working day.

#### TYPICAL CURED PROPERTIES:

Tensile Strength (psi)	8,875
Tensile Shear (psi, 1hr cure)	850
Tensile Shear (psi, 8hr cure)	2,000
Elongation (%)	3.6
Flexural Strength (psi)	12,600
Flexural Modulus (psi)	450,000
Hardness (shore D)	78
Impact Strength (Izod)	1.47 ft.lbs/inch notch
Weight Gain (% , 24hrs)	
Water	< 0.5
Xylene/isopropyl alcohol	0.2
5% acetic acid	1.8

**SAFETY & HANDLING:** Use with adequate ventilation. Keep away from sparks and open flames. Avoid prolonged contact with skin and breathing of vapors. Wash with soap and water to remove from skin.