



Advanced Materials

Epibond® 1536-A/B

EPOXY ADHESIVE

- Plastic Bonding Adhesive
- Long Work Life
- One to One Mix Ratio (PBW)

DESCRIPTION :

Epibond® 1536-A/B epoxy adhesive is a two-part system which may be applied by brush, if desired. Epibond® 1536-A/B epoxy adhesive is specifically formulated for bonding composite fiberglass-reinforced panels together or to other materials. The epoxy adhesive is qualified to BMS 5-126 Type 3, Class 1.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1536-A Resin</u>	<u>1536-B Hardener</u>	<u>1536-A/B System</u>	<u>Test Method</u>
Color	Lt. Amber	Amber	Amber	Visual
Density, g/cc.	1.15	0.97	1.05	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	3,000	2,000	2,500	ASTM-D-2196
Work life, 100 gms at 77°F (25°C), hours	--	--	2	ASTM-D-1338

MIX RATIO :

To 100 parts by weight of Epibond 1536-A resin, add 100 parts by weight of Epibond® 1536-B hardener. Mix both components thoroughly for several minutes.

CURE SCHEDULE :

Three to five days at 77°F (25°C) or gel at room temperature plus 20-30 minutes at 250°F (121°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Tensile lap shear: AL/AL, at -67°F (-55°C), psi (MPa)	3,000 (20.7)	ASTM-D-1002
at 77°F (25°C), psi (MPa)	3,000 (20.7)	--
at 180°F (83°C), psi (MPa)	550 (3.8)	--
After seven days at 77°F (25°C), psi (MPa)		ASTM-D-543
JP-4 fuel immersion	2,300 (15.8)	--
TT-2-735 Type III test fluid	2,500 (17.2)	--
Distilled water	1,600 (11)	--



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STORAGE :

Epibond® 1536-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 2 years (expiration date may differ based on customer specification).

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

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

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