



Advanced Materials

Epibond[®] **1539-A/B-10**

EPOXY PASTE ADHESIVE

- Bonds Plastic and Metal
- Good Composite Bonding

DESCRIPTION:

Epibond® 1539-A/B-10 epoxy adhesive is a blue, two-part paste developed specifically for bonding thermoset, fiberglass reinforced plastics, metals and a variety of other materials. Epibond® 1539-A/B-10 epoxy adhesive meets the requirements of BMS 5-25C, Type 2, Grade 1. Surfaces to be bonded should be clean and thoroughly degreased. Best results are achieved on metal surfaces which have been chemically cleaned.

TYPICAL PROPERTIES AS RECEIVED :				
<u>Property</u>	<u> 1539-A</u>	<u>1539-B-</u> 10	1539-A/B-10	Test Method
	Resin	<u>Hardener</u>	<u>System</u>	
Color	Off-White	Blue	Blue	Visual
Density, g/cc.	1.10	1.05	1.10	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	Paste	Paste	Paste	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), hours			2	ASTM-D-2471

MIX RATIO:

To 100 parts by weight of Epibond 1539-A resin, add 89 parts by weight of Epibond® 1539-B-10 hardener. Mix both components thoroughly insure adequate mixing.

CURE SCHEDULE

24 hours at 77°F (25°C), or gel at room temperature plus 30 minutes at 250°F (121°C).





TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u> Tensile lap shear: AL/AL, at -67°F (-55°C), psi (MPa)

at 77°F (25°C), psi (MPa)

at 180°F (83°C), psi (MPa)

Result 3,500 (24.1) 2,500 (17.2)

800 (5.5)

Test Method ASTM-D-1002

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STORAGE:

Epibond® 1539-A/B 10 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 (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 <u>prior</u> 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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