

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022
262-253-5900 FAX 262-253-5919

DESCRIPTION:

Resinlab® EP1238 Black is a two part acrylic/epoxy hybrid adhesive designed for bonding metals and plastics. It cures quickly at room temperature to a tough, semi-rigid material. It has good wetting to most surfaces and has controlled flow characteristics to prevent excessive running or dripping. This product has good vibration and impact resistance. It has good resistance to water, salt spray, inorganic acids and bases and most organic solvents.

It was formulated to a 2A:1B by volume mix ratio for use in side-by-side dispensing cartridges and meter/mix and dispense equipment. EP1238 Black will reach handle cure at room temperature within 6 – 12 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 2 hours at 65 °C to 30 minutes at 100 °C are typical for most applications. Time to heat substrate must be taken into account. Cooler temperatures will also extend work time and increase cure times.

TYPICAL PROPERTIES:

All properties given are at 25 °C unless otherwise noted.

Property:	Value:	Test Method or Source:
Color	Black	Visual
Mix Ratio	Part A to Part B	Calculated
By weight	2.12 to 1	
By volume	2 to 1	
Cure Schedule	6-12 hours @ 25 °C 2 hours @ 65 °C 30 minutes @ 100 °C	
Viscosity – Part A	44,000 cps	Rheometer parallel plate 25mm@1/s 455300006291
Viscosity – Part B	50,000 cps	
Viscosity - Mixed	47,000 cps estimated	
Specific Gravity – Part A	1.16	Calculated
Specific Gravity – Part B	1.09	
Specific Gravity - Mixed	1.13	
Pot Life	12 minutes	Rheometer parallel plate 25mm@1/s 455300006291
Glass Transition Temperature/Tg	60 °C	453560822409 by DSC
Hardness	80 Shore D	455300006287/ASTM D2240
Water Absorption	0.25% after 24 hours	457561824543/ASTM D570
Tensile Properties:		455300006285/ASTM D638
Strength	8,500 psi	
Elongation	3-4%	
Modulus	450,000 psi	
Lap Shear Strength		455300005642/ASTM D1002
0.010" bond line 2024 T3 Al	4600 psi	Abraded / solvent wiped Extrapolated from EP1238
0.010" bond line Chemical Resistant PVC	280 psi	
0.010" bond line Polycarbonate	700 psi	
0.010" bond line Acrylic	490 psi	
0.010" bond line ABS	520 psi	

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022
262-253-5900 FAX 262-253-5919

Compressive Properties:		455300006265/ASTM D695
Yield Strength	12,000 psi	
Compressive Strength	16,000 psi	
Modulus	350,000 psi	
T Peel Strength (Al to Al)	25 pli*	Estimated
Thermal Conductivity	<0.2 W / (m.K) *	Estimated
Coefficient of Thermal Expansion	64 ppm/ °C (below Tg) 207ppm/ °C (above Tg)	455300005340 /ASTM E831 TMA, 5 °C/min
Dielectric Strength	888 V/mil* 35.0 kV/mm*	
Surface Resistivity	3.35 x 10 ¹⁵ ohm/sq (@18.1%RH)	455300006612/ASTM D257
Volume Resistivity	2.12 x 10 ¹⁶ ohm-cm (@19.1°C)	
Dielectric Constant/Dissipation Factor		455300006513/ASTM D150
@ 100 Hz	3.9, 0.005	
@ 100 kHz	3.6, 0.03	
Temperature Range	-40 to 150 °C**	

* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

** Temperature Rating is based on average design requirements and is not intended as a guarantee of suitability for all applications operating at that temperature.

*** This TDS contains values that have been updated. The values reported in this technical data sheet are typical values of the product, and are highly dependent on test conditions and methodology. We actively seek the most precise and accurate ways to measure and interpret performance of our products, and to update estimated values with measured values. The formula has not been revised or changed in any way. Although the values on paper have changed, you can expect the same performance of the product.

INSTRUCTIONS:

1. Bring both components to room temperature prior to mixing.
2. Cartridge format: Mixer should be attached keeping the cartridge vertical and any air pocket purged this way. After the mixer contains material, the mixer tip can be dropped to dispense pre-bleed amount. Attach a new static mixer with each cartridge, then pre-bleed the first 3 inches of dispensed material or until a uniform color is obtained. Maintain adequate velocity during dispensing to ensure complete mixing.
3. Bulk format: weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. Do not pour from mixing container, transfer to a new container as residual unmixed material may cause a tacky spot on the surface of the casting. Maintain adequate velocity during dispensing to ensure complete mixing.
4. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
5. Clean up uncured resin with suitable organic solvent such as MEK, acetone or other organic solvent.

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022
262-253-5900 FAX 262-253-5919

SHELF LIFE AND STORAGE:

12 months at 25 °C
Specialty packaging may be less.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50 °C) aggravate this phenomenon. Heating the individual component to 50 to 60 °C while stirring can usually restore products to original state. Storage at 25 +/- 10 °C is optimum for most products.