



EPOXY ADHESIVES

Products: 7522-Clear • 7538-Green • 7575-Clear 7500 Applicator Gun and Static Mixers

Bostik® 7500 series epoxy systems are 2-part, room temperature curing structural adhesives designed to provide exceptional flexibility for many applications. These unique formulae have been engineered with a range of properties to deliver the performance to match your unique and demanding requirements for construction, repair, MRO or product assembly applications.

Bostik® 7522-Clear is a high-performance structural epoxy having high peel and shear strength with adhesion to diverse materials including rubber, plastics, woods and metals. An exceptional epoxy for bonding a variety of materials that will tolerate adverse conditions, its excellent mechanical and electrical properties make it an exceptional electrical insulator.

Bostik® 7538-Green is a general purpose structural epoxy having high shear strength and strong adhesion to metals, woods, reinforced plastics and masonry. The best choice for bonding parts which must withstand weather, moisture and temperature fluctuations, **7538** will adhere with minimum surface preparation and has a low coefficient of expansion. Made in conformance to MIL-A-52194-A.

Bostik® 7575-Clear is a fast and versatile epoxy for structural bonding of metals, phenolic plastics, polyesters, glass, FRP, hardboards, wood, ceramics, rubber and masonry. Unlike conventional 5-minute epoxies, **Bostik 7575** is designed for structural bonding applications requiring a fast-setting epoxy with low shrinkage, good shock resistance and excellent mechanical and electrical properties. It provides superior resistance to vapors, gases, water, galvanic action, petroleum fuels and salt solution. Unique formula also allows for exposure to moist or damp surfaces while bonding. **7575-Clear** is an excellent choice for a variety of applications including potting, encapsulation, sealing electrical components and for many quick repairs.

The **Bostik® 7500 series** epoxy applicator gun is used to dispense the 2-oz., dual-barrel cartridges of epoxy for small product assembly, maintenance or repair operations. Used with a twist-on static mixer, the resin and hardener are mixed completely and dispensed accurately. Static mixers are also available separately and are supplied 10 mixers per bag.

APPLICATION INFORMATION “FOR BEST RESULTS”

- Parts to be bonded with epoxies must be clean and free of surface contaminants, including dirt, dust, oils, plasticizers, silicones or release agents. Aluminum and other metals should be lightly abraded to remove oxides.
- Curing may be accelerated by controlled exposure(s) to elevated temperature(s) but this may also degrade optimum bond performance. Users must verify acceptable bond performance under these conditions.
- User pre-testing on bonds with sample or scrap materials is recommended.
- Always review and retain an up-to-date Material Safety Data Sheet (“MSDS”) for any product being used or considered for use.

STORAGE, HANDLING & SHIPPING

For optimum shelf-life of these products, store @ 50~90°F (10~32°C). Storing at lower temperatures causes a temporary increase in viscosity. The ICC shipping classification is “Adhesives NOI”.

SHELF-LIFE INFORMATION

The maximum shelf-life is 2 (two) years from date of manufacture (“DoM”). Bostik may, in its distribution literature or in other written or verbal communications, state the shelf-life as “one (1) year from time of shipment to the original purchaser” with the intention that this allows for a reasonable period of time the product may be stocked by a distributor while still maintaining an acceptable shelf-life of at least 1 year.



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Properties*	7522 Clear	7538-Green	7575-Clear
Pot Life, per 2 oz. mixed	90~120 minutes	30 minutes	5 minutes
Color - Mixed After Cure	Translucent	Light Green	Clear
Mix Ratio by Volume	1-to-1	1-to-1	1-to-1
Mixed Viscosity cps @ 68°F	11,000	40,000~55,000	12,000~16,000
Service Temperature Range °F	-60 to 210°F	-60 to 210°F	-60 to 185°F
Specific Gravity - Mixed	1.07	1.40	1.14
Shear strength (psi) @ -65°F	3,000	2,000	900
Shear strength (psi) @ 75°F	3,000	3,000	1,500
Shear strength (psi) @ 180°F	200	500	300
Shear strength, steel, PSI	2,800	3,000	2,800
Compressive Strength	12,000	11,000	10,000
T-Peel (lbs/lineal in.) @ 75°F	15~20	3	2
Elongation @ Break (%)	4.5	2.0	8.0
C.T.E.	70 x 10 ⁻⁶	40 x 10 ⁻⁶	60 x 10 ⁻⁶
Shore "D" hardness after cure time @ 68°F	45 after 24 hrs	20 after 6 hrs	26 after 10 mins
Shore "D" hardness after cure time @ 68°F	70 after 48 hrs	70 after 12 hrs	68 after 30 mins
Shore "D" hardness after cure time @ 68°F	75 after 72 hrs	80 after 24 hrs	74 after 60 mins
Shore "D" hardness after full cure	75	80	75
Impact, Izod, ft.lbs./inch of notch	1.0	0.5	1.0
Dielectric Strength, volts/mil.	500	480	400
Volume Resistivity (Ω/cm)	10 ¹²	10 ¹²	10 ¹²

Chemical Resistance

Inorganic acids	Good	Good	Good
Organic acids	Poor	Poor	Poor
Alkalis	Good	Excellent	Good
Alcohol	Good	Poor	Poor
Solvents	Good	Excellent	Fair
Solvents, Chlorinated	Fair	Poor	Poor
Hydraulic fluids	Good	Good	Good

Specification References

Conforms to Navy spec. XWS15351	Yes	Yes	No
Conforms to MIL-A-52194-A	No	Yes	No
Conforms to WS09125C	Yes	Yes	No

* The technical information supplied is typical physical property data shown for reference only and not intended for specification use. Please refer to BOSTIK, Inc. standard warranty disclaimer shown as "IMPORTANT NOTICE" below.

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