



EPOXY 104-25

ADHESIVE SYSTEM

TECHNICAL DATA

Product Description

Epoxy 104-25 is an exceptional epoxy formulation, recommended for lower temperature or wet industrial bonding applications where fast curing is required. This clear, two-part, medium-viscosity system mixes easily at room temperature, contains no solvents, and is suitable for high performance structural-bonding applications where the combination of very fast room temperature cure coupled with low shrinkage and excellent mechanical and electrical properties is required. It develops strong, tough bonds to metals, phenolic plastics, polyesters, glass and glass fabrics, handboards and forestry products, ceramics, rubber, masonry materials, and other construction materials. Fully cured Epoxy 104-25 is an excellent electrical insulator and provides superior resistance to vapors and gases, water, galvanic action, petroleum fuels, salt solutions, and many other organic and inorganic compounds.

APPLICATIONS

- Industrial adhesion
- Small potting
- Laminating

FEATURES

- Convenient two-part mix ratio
- Moisture resistant
- Room temperature cure
- Electrically insulating

RECOMMENDED SUBSTRATES

- Glass ceramics
- Metals
- Plastics

UNCURED PROPERTIES

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class, PT A:B	Epoxy : Amine	N/A
Color, PT A:B	Off White : Light Beige	N/A
Specific Gravity, Pt A	1.37	QPTTEST002
Specific Gravity, Pt B	1.34	QPTTEST002
Viscosity @ 25C, cps, PT A	20,000 to 50,000	QPTTEST001
Viscosity @ 25C, cps, PT B	20,000 to 50,000	QPTTEST001
Mix Ratio by Volume, Resin:Hardener	1:1	N/A

CURED MECHANICAL PROPERTIES

Property	Value	Test Method
Durometer Hardness, Shore D	74	QPTTEST012
Moisture Resistance	Excellent	N/A
Dielectric Strength, Volts/Mil	415	TFTEST011
Operating Temperature Range, C	-60 to 125	N/A
Elongation, %	10	N/A

CURE OVERVIEW

Property	Value	Test Method
Pot Life @ room temperature, min	4 to 5	N/A
Cure Time @ room temperature, hr	48	N/A
Cure Time @ 85C, hr	2	N/A

Storage:

Store material in cool, dry location at a temperature below 25°C. Keep from freezing. Refer to packaging specific quote for shelf life information. Consult SDS for safe handling recommendations.

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