



## Armstrong A-661 Epoxy Resin Adhesive

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### PRODUCT DESCRIPTION

Armstrong A-661 epoxy adhesive is a two-component, room temperature curing adhesive which produces bonds with excellent shear strength, even after long-term exposure at temperatures up to 400°F. It is a smoothly brushable, non-sag, easy to apply paste that will cure to handling strength over night at room temperature, or may be speed cured at 165°F, or higher if desired.

### APPLICATIONS

Store below 25°C out of sunlight and in original unopened containers. Refer to packaging specific quote for shelf life information.

### Instructions

1. The surfaces to be bonded should be clean and dry (for critical applications refer to our suggested surface preparation procedures - Bulletin No. 964)
2. Thoroughly mix the A-661 Part B with the A-661 part A in a clean discardable container using correct mix ratio. Avoid the introduction of excess air.
3. Apply the adhesive to surfaces to be bonded (preferably both surfaces) and press together. Light clamping may be used to keep parts in position during curing.
4. Cure as desired.

### TYPICAL PHYSICAL PROPERTIES

	Part A	Part B
Viscosity @77°F (poise)	---	10,800
Specific Gravity	1.42	1.00
Color	Grey	Dark Amber

#### Mixed Systems (Part A/Part B)

Mix Ratio (by weight )	4:1
Mix Viscosity @ 77°F	Thixotropic
Working Life @77°F (100 grams)	Approx 3 Hrs

### TYPICAL PHYSICAL PROPERTIES OF CURED SYSTEM\*

<b>Tensile Shear (psi) (al/al)</b>	
@ 77°F	3300
@ 180°F	3460
@300°F	760
@400°F	430
Bond Strength (psi)	5300
Tensile Strength (psi)	2800
Elongation, maximum (%)	2.0%
*Cured 10' @ 300°F	

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### Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

### Note

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