

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

DESCRIPTION:

ResinLab® Armstrong™ A-2 with Activator E is a two part filled paste resin. It has a low CTE that is ideal for bonding porcelain, glass, and ceramics. Non metallic oxide fillers provide excellent electrical insulation properties.

Armstrong A-2 will have excellent wetting properties and will maintain strong bonds to rigid materials such as cast iron, steel, aluminum, copper, bronze, magnesium, phenolics, wood, titanium, polycarbonate, polyester, nylon, acrylics, acetates and A.B.S.

Armstrong A-2 can be used with 4 different activators/curing agents. *A-2 with Activator E* will have a longer work life than the Activator A mix, it is recommended to use an elevated cure schedule. *Armstrong A-2* mixed with Activator E will maintain a medium viscosity.

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TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Off white	Visual
Mix Ratio	Part A to Part B	Calculated
By weight	16.67 to 1	
By volume	7 to 1	
Cure Schedule	1 hour @ 100 °C	
Viscosity – Part A	870,000 cps @1/s	Rheometer parallel plate 25mm
Viscosity – Part B	5 cps @1/s	455300006291
Viscosity - Mixed	25,000 cps @1/s	
Specific Gravity – Part A	1.94	Calculated by WPG cup method
Specific Gravity – Part B	0.81	
Specific Gravity - Mixed	1.80	
Pot Life	1.5 hours	453560822627
Work Life	2-3 hours	Extrapolated from Henkel LDS
Hardness	85 Shore D	455300006287/ASTM D2240
Tensile Properties:		Extrapolated from Henkel LDS
Strength	6,570 psi	
Elongation	2.8%	
Lap Shear Strength		Extrapolated from Henkel LDS
At room temp	2,500 psi	
At 180 °F	2,960 psi	
At -60 °F	2,850 psi	

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Lap Shear Strength, after 7 days in:		Extrapolated from Henkel LDS
Ammonia, 28%	3,050 psi	
Distilled water	2,930 psi	
Salt water, 10%	3,380 psi	
Acetone (100%)	3,030 psi	
Glacial acetic acid	2,350 psi	
Toluene (100%)	3,600 psi	
Ethylene dichloride (100%)	3,050 psi	
Ethyl acetate	2,000 psi	
Hexane (100%)	2,520 psi	
After 30 days / 100% RH	2,400 psi	
Compressive Properties:		Extrapolated from Henkel LDS
Yield Strength	16,500 psi	
Coefficient of Thermal Expansion by TMA	72 ppm/ °C below Tg	Extrapolated from Henkel LDS
Operating Temperature Range	-40 to 150 °C**	
Relative Thermal Index (RTI)	90 °C **	UL746B, Table 7.1 Generic Value Based on Composition

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

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

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.

3/02/2020

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SHELF LIFE AND STORAGE:

12 months at 25 °C DOP
9 months at 25 °C DOP C-kit
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.