

# Product Bulletin

# CASS POLYMERS

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SC-9001 Registered



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EA-604  
EPOXY ADHESIVE

0302

## DESCRIPTION

EA-604 is a two component liquid compound with excellent wetting and quick cure characteristics. The blue resin and yellow hardener, when mixed together, give a uniform translucent green color and provides a positive mix indicator. EA-604 will cure at temperatures as low as 0°F. It exhibits an easy 1 to 1 mix ratio with a working life of 4-6 minutes at 25°C/77°F, and sets to handling strength in 10-15 minutes.

**USES** All types of general repair and bonding applications requiring a liquid adhesive. EA-604 offers a quick, easy repair of similar and dissimilar materials.

## HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (by weight or volume)	100R/100H
Density (Mixed)	9.48 lbs/gal
Specific Gravity	1.137 gms/cc
Viscosity	Resin..... 11,000-15,000 cps
	Hardener..... 10,000-16,000 cps
Work Life (30 gms)	4-6 minutes
Cure to Handling Strength	10-15 minutes
Minimum Cure Schedule	6 hours
Maximum Cure	24 hours

## PROPERTIES

Ultimate Tensile Strength (ASTM D-638)	6,200 psi
Tensile Elongation (ASTM D-638)	5.5%
Modulus of Elasticity (ASTM D-630)	375,300 psi
Ultimate Compressive Strength (ASTM D-695)	9,440 psi
Compressive Modulus of Elasticity (ASTM D-695)	174,000
Flexural Strength at Yield (ASTM D-790)	8,996 psi
Flexural Modulus of Elasticity (ASTM D-790)	267,400 psi
Cast Bar Shrinkage (ASTM D-2566)	6.43 X 10 <sup>-3</sup> in/in
Coefficient of Thermal Expansion (ASTM D-696)	4.24 X 10 <sup>-5</sup> in/in°F
Heat Deflection Temperature (ASTM D-648.82)	@ 66 psi 45°C/113°F
	@ 264 psi 41°C/105°F
Moisture Absorption (ASTM D-570.81)	0.65%
Impact Strength (ASTM D-256.93a)	12.98 ([in-lbf]/in)
Hardness (ASTM D-2240.91)	80-85 Shore D

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**TENSILE ADHESION STRENGTH TEST**

Substrate Material ..... Mahogany  
Average Tensile Adhesion Strength..... 1,823 psi  
Maximum Tensile Adhesion Strength..... 2,446 psi  
Typical Failure Mode: 90% substrate failure, 10% adhesive failure

Substrate Material ..... Steel  
Average Tensile Adhesion Strength..... 1,052 psi  
Maximum Tensile Adhesion Strength..... 1,093 psi  
Typical Failure Mode: 100% adhesive failure