

Product Bulletin

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EA-621
EPOXY ADHESIVE FILLER
SEMI-RIGID

0302

DESCRIPTION

EA-621 EPOXY ADHESIVE/FILLER was developed from the latest advanced epoxy technology for permanent and efficient bonding/filling FRP, RTM, RIM, metal, aluminum and other substrates. Its color change mix characteristics (white resin/blue hardener); easy mix ratio of 1 to 1 parts by weight or volume; relatively quick-set, short cure time and early handling strength qualify's EA-621 for many production and repair applications. EA-621 is safe to use as it does not contain any MDA or VCHD.

EA-621 EPOXY ADHESIVE/FILLER can be used to repair cracks, gouges and punctures in thermoset and ABS parts and panels. EA-621 is the ultimate repair material for urethane and ABS flexible parts and panels. Physical properties virtually match the properties of the original panels.

EA-621 has excellent chemical and moisture resistance. Can withstand freeze/thaw cycles and remains tough, semi-rigid and resilient. It can be sanded to a feather edge and accepts most finishes without special primers.

USES

- Bond/fill or repair automotive flexible panels and bumpers
- FRP bonding, sealing and joining
- Aluminum and honeycomb panels many other bonding and filling of similar and dissimilar substrates

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (parts by weight or volume).....	100R:100H
Work Life	5 to 7 minutes
Mixed Viscosity	Thixotropic Workable Paste
Handling Strength/Sanding Time	12-15 minutes
Complete Cure.....	6 hours
Color (Resin White: Hardener Blue).....	Lt. Blue

PHYSICAL PROPERTIES

Ultimate Tensile Strength (ASTM D-3039.93)	490 psi
Tensile Elongation (ASTM D-3039.93)	21.58%
Tensile Modulus (ASTM D-3039.93).....	3,000 psi
Ultimate Flexural Strength (ASTM D-790.92)	240 psi
Flexural Modulus (ASTM D-790.92)	3,900 psi
Ultimate Compressive Strength (ASTM D-695.91)	1,365 psi
Compressive Modulus (ASTM D-695.91)	6,200 psi
Heat Deflection Temperature (ASTM D-648.82)	(@ 66 psi) 44°C/111°F
.....	(@ 264 psi) 42°C/107°F
Moisture Absorption (ASTM D-570.88).....	0.51%
Tensile Lap Shear Strength (Aluminum/Aluminum)	3,058 psi

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