

Product Bulletin

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EA-624
EPOXY ADHESIVE
RIGID BOND & FILL SYSTEM

0302

DESCRIPTION

EA-624 EPOXY ADHESIVE/FILLER was developed from the latest advanced epoxy technology for permanent and efficient bonding/filling of FRP, RTM, RIM, metal, aluminum and other substrates. The system has convenient color change mix characteristics (white resin/red hardener); and an easy mix ratio of one 1 to 1 parts by weight or volume. With its quick-set characteristics and early handling strength, even at temperatures below freezing, EA-624 qualifies for many production and repair applications. EA-624 is safe to use as it does not contain any MDA or VCHD.

EA-624 EPOXY ADHESIVE/FILLER is the ultimate material for the repairing of cracks, gouges and punctures in rigid thermoset or composite parts and panels. The physical properties will virtually match the properties of the original panels.

EA-624 has excellent chemical and moisture resistance. The system can withstand freeze/thaw cycles yet remain tough and hard. It can be sanded to a feather edge and accepts most finishes without special primers.

USES

- Bonding or repairing of rigid automotive parts and panels.
- FRP bonding, sealing and joining.
- Aluminum and honeycomb panels.
- Many other bonding and filling applications with similar and dissimilar substrates

HANDLING CHARACTERISTICS @ 25°C/77°F

| | |
|--|----------------------------|
| Mix Ratio (parts by weight or volume)..... | 100R:100H |
| Work Life | 6 to 8 minutes |
| Mixed Viscosity | Thixotropic Workable Paste |
| Handling Strength/Sanding Time | 15 minutes |
| Complete Cure..... | 6 hours |
| Color (Resin White: Hardener Red) | Pink |
| Storage Life (Containers tightly closed) | One Year |

PHYSICAL PROPERTIES

| | |
|---|-----------------------|
| Ultimate Tensile Strength (ASTM D-3039.93) | 2,980 psi |
| Tensile Elongation (ASTM D-3039.93) | 0.47% |
| Tensile Modulus (ASTM D-3039.93)..... | 1,025,000 psi |
| Ultimate Flexural Strength (ASTM D-790.92) | 4,541 psi |
| Flexural Modulus (ASTM D-790.92) | 654,500 psi |
| Ultimate Compressive Strength (ASTM D-695.91) | 6,610 psi |
| Heat Deflection Temperature (ASTM D-648.82) | (@ 66 psi) 44°C/111°F |
| | (@264 psi) 42°C/107°F |

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