



AN ELLSWORTH ADHESIVES COMPANY 

TECHNICAL DATA SHEET EP1294

03/29/2009

W186 N11687 MORSE DRIVE GERMANTOWN, WI 53022
262-502-6610 FAX 262-502-4743

DESCRIPTION:

Resinlab™ EP1294 is a two part mineral filled, flame retardant epoxy syntactic foam. It utilizes glass microspheres to reduce cured density and improve machinability. This product will be self-extinguishing when tested at 1/4" thickness. It also provides excellent protection against water, humidity, salt spray and other chemicals. It was formulated to an easy 2:1 volume mix ratio for use in meter-mix and dispense equipment.

EP1294 will cure to a firm handle strength at room temperature in about 8 to 10 hours. Full cure requires 24 hours. Cure time can be accelerated by the application of heat. Time to heat substrate must be taken into account. Cooler temperatures will also extend work time and increase cure times. Warming the cartridge will aid in increasing dispensing flow rate and boost cure speed. Depending upon method used to warm the cartridge care should be taken to avoid localized overheating. If a microwave is used, any metal components should be removed and user should carefully determine optimum time for each microwave as they can vary in power output.

TYPICAL PROPERTIES:

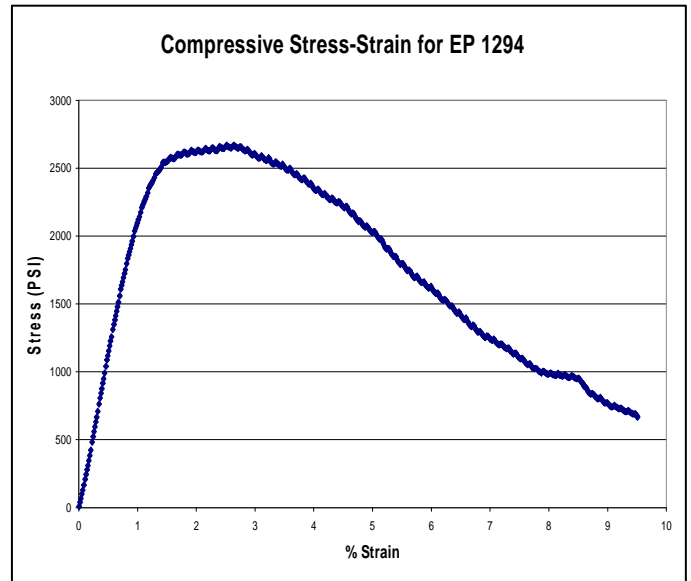
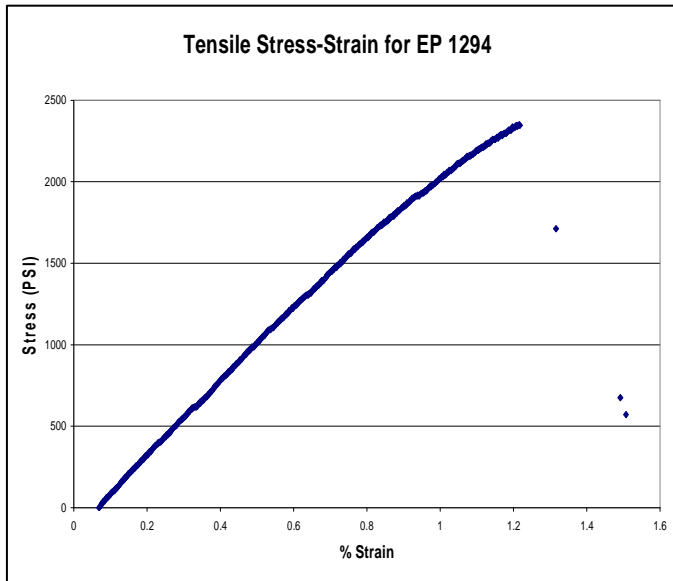
All properties given are at 25°C unless otherwise noted.

<u>PROPERTY:</u>		<u>VALUE:</u>	<u>TEST METHOD:</u>
Color		Yellow	
Viscosity	Part A Part B Mixed	Soft Paste Soft Paste Soft Paste	TM R050-12
Specific Gravity	Part A Part B Mixed	0.58 0.55 0.57	TM R050-16
Pot Life Mass		8-12 min. 50 grams	TM R050-19
Hardness Scale		55 Shore-D	TM R050-17
Water Absorption 24 Hours		0.37 %	TM R050-35
Temperature Range		-40 to 150°C	

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<u>PROPERTY:</u>	<u>VALUE:</u>		<u>TEST METHOD:</u>
Tensile	PSI	N/mm²	TM R050-36
Yield Strength	1,000	6.9	
Ultimate Strength	2,400	16.6	
Break Strength	2,400	16.6	
Elongation At Break	1-2 %		
Modulus	230,000	1,590	
Lap Shear Strength (2024 T3 Al Abraded / MEK Wipe)	1,300	9.0	TM R050-37
Compression			TM R050-38
Yield Strength	2,500	17.2	
Ultimate Strength	2,700	18.6	
Break Strength	1,000	6.9	
Modulus	220,000	1,520	



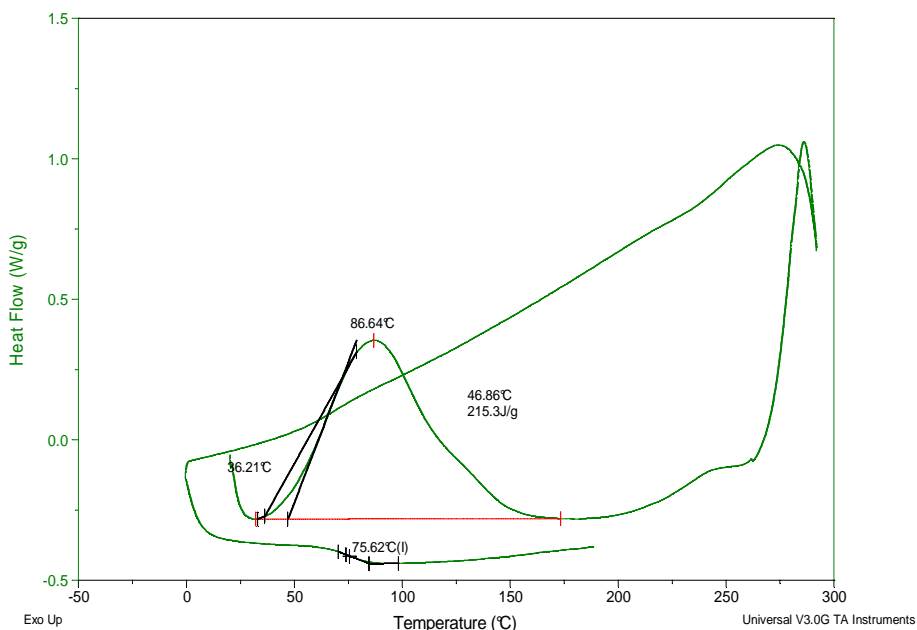
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<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Glass Transition Temp	75°C	TM R050-25
Exothermic Energy	215.3 J/g	
Onset Temp (by DSC)	36°C	

Sample: EP 1294
Size: 21.7000 mg
Method: HP DSC
Comment: 300 full cure, Tg

DSC

File: Z:\DSC\EP 1294\EP 1294.002
Operator: NV
Run Date: 3-Apr-09 09:42



CURE SCHEDULE:

24 – 72 hours at 25°C
or 2 - 3 hours @ 65°C

INSTRUCTIONS:

1. Bring both components to room temperature prior to mixing. Cartridges should be stored in a cool, dry place.
2. If used in bulk, 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 surface of casting. If product is used in a side-by-side cartridge, attach a new static mixer with each cartridge,

