

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

### DESCRIPTION:

EP950G Gray is an aluminum filled one part rubber modified epoxy designed for bonding metal and other structural material subject to stress at elevated temperature. It is a medium paste-like viscosity which gives very little sag upon cure at elevated temperature. Being a 100% solids, single component product a variety of simple, low cost dispensing methods are available for application of this product.

This product will cure at temperatures as low as 113°C (235°F) without sacrificing shelf life or need for unusual shipping or storage considerations.

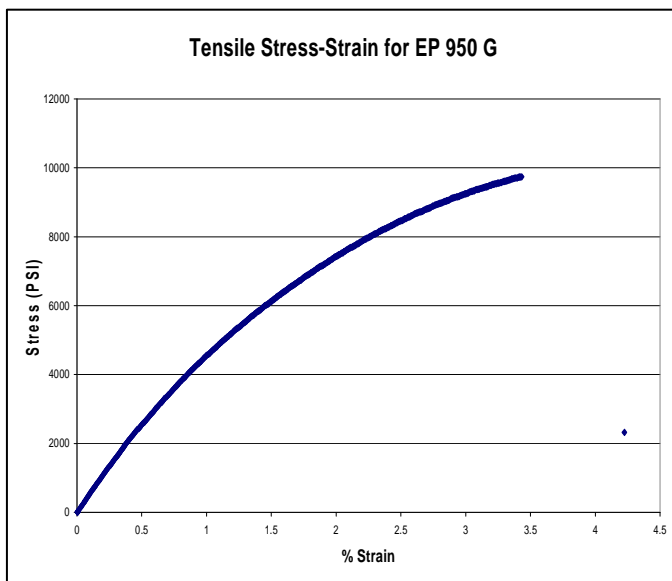
### TYPICAL PROPERTIES:

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

<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Color	Gray	
Viscosity RVT, #7, 2.5 RPM	750,000 cps (mPa·s)	TM R050-12
Specific Gravity	1.40	TM R050-16
Pot Life	3 months at 25°C 6 months at <5°C	TM R050-19
Mass	100G	
Hardness Scale	65 Shore-D	TM R050-17
Water Absorption 24 hours	1.46 %	TM R050-35
Temperature Range**	-40 to 175°C	
T-Peel	5 – 7 pli *	

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<u>PROPERTY:</u>	<u>VALUE:</u>		<u>TEST METHOD:</u>
Tensile	<b>PSI</b>	<b>N/mm<sup>2</sup></b>	
Yield Strength	2,500	17.2	TM R050-36
Ultimate Strength	9,500	65.5	
Break Strength	9,500	65.5	
Elongation At Break	2-4 %		
Modulus	550,000	3,795	
Lap Shear Strength (2024 T3 Al Abraded / MEK Wipe)	3,000	20.7	TM R050-37



Linear Coefficient of Thermal Expansion	49 ppm/ °C*
Thermal Conductivity	0.23 BTU/(hr·ft·°F) * 0.40 W/m*K *
Dielectric Constant (25C, 100Hz)	4.7 *
Dielectric Strength	110 V/mil * 4.3 kV/mm *

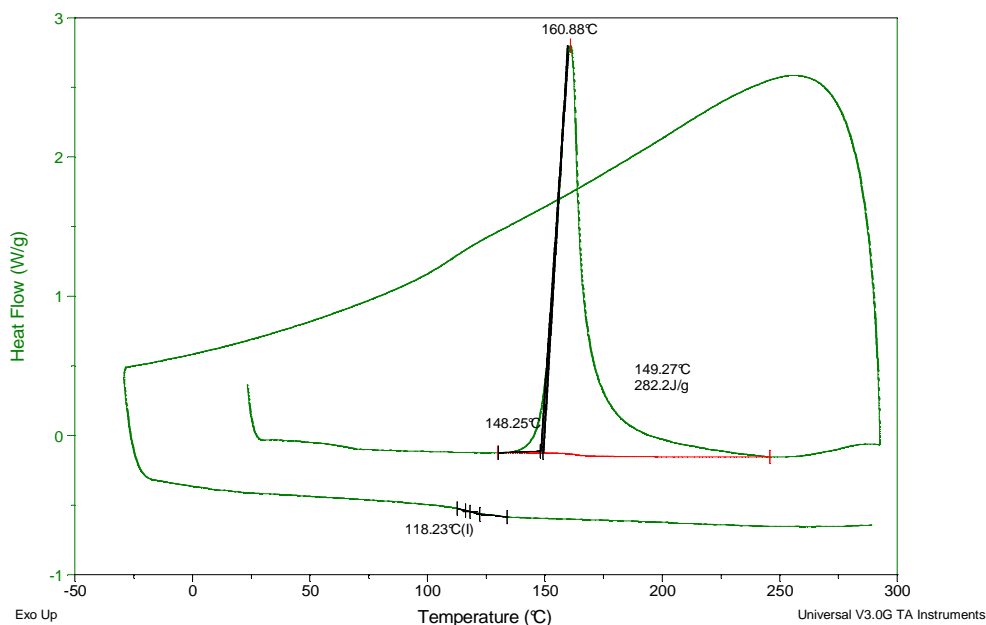
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<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Volume Resistivity	$8 \times 10^9$ ohm-cm	
Glass Transition Temp	118°C	TM R050-25
Exothermic Energy	282.2 J/g	
Onset Temp (by DSC)	148°C	

Sample: EP 950 G 08/22/2007  
Size: 21.9000 mg  
Method: HP DSC  
Comment: 300 Full Cure + Tg

DSC

File: Z:\DSC\EP 950\EP 950 G.001  
Operator: NVo  
Run Date: 22-Aug-07 14:44



### CURE SCHEDULE:

Times at various temperatures in a convection oven required to reach minimum lap shear strengths.

2.5 hours @ 121°C	3500 PSI
45 min @ 135°C	4000 PSI
40 min @ 150°C	4000 PSI
20 min @ 177°C	4000 PSI

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**INSTRUCTIONS:**

- 1) Bring to room temperature prior to use.
- 2) Apply to substrate with flow applicator, allow to cure undisturbed until product is fully gelled or tack-free to the touch.
- 3) Clean up uncured resin with suitable organic solvent such as MEK, acetone or a chlorinated solvent.

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

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

Notes:

Values presented above are considered to be typical properties, not to be used for specification purposes. Contact our Technical Department for further information.

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). In extreme cases it may appear solid and cured. Fluctuating temperatures (within 0 to 50°C) aggravate this phenomena.

**SHELF LIFE:**

3 months @ 25°C