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TECHNICAL DATA SHEET

SOLARITE EA- 0504

DESCRIPTION: Solarite EA- 0504 is a room temperature curing semi-rigid high peel strength epoxy adhesive compound, whose convenient mixing ratio makes it easy to use and well suited to automatic dispensing equipment. EA- 0504 has excellent shock resistance, vibration resistance and impact strength. It is recommended for bonding similar and dissimilar substrates such as wood, metal, ceramics and thermoplastics.

SPECIFICATIONS—UNCURED:

	Part A	Part B
Color, Visual	Neutral	Gray
Mix Ratio—By Weight	100	140
Mix Ratio—By Volume	100	150
Viscosity, cps, ASTM-D-2393	90,000	60,000
Specific Gravity	1.35	1.26
Gel Time, 25°C, Hours		1.5
Mixed Viscosity, cps, ASTM-D-1084		70,000
Shelf Life, 25°C, Months		12

SPECIFICATIONS—CURED:

PHYSICAL:

Durometer, ASTM-D-2240	65D
Tensile Strength, psi, ASTM-D-638	3,300
Tensile Elongation, Percentage, ASTM-D-638	30.0
Thermal Conductivity, BTU-in/ft ² (Hour) (°F)	2.0
Service Temperature, °C	130
Lap Shear (Al/Al, 2024-T3 acid etched) 25C, psi	2800
T-Peel (Al/Al, 2024-T3 acid Etched) 25C, pli	30.2

ELECTRICAL PROPERTIES:

Dielectric Strength, Volts/Mil, ASTM-D-149	422
Dielectric Constant, 1 kHz, ASTM-D-150	4.6
Dissipation Factor, 1 kHz, ASTM-D-150	0.02
Volume Resistivity, ohm/cm, ASTM-D-257	1x10 ¹⁴

USE INSTRUCTIONS:

1. Pre-mix contents of each container before use to ensure the entire contents are uniform. Some settling may occur upon prolonged storage which is soft and easily incorporated.
2. Measure out components of the product by weight or volume and mix thoroughly together to incorporate any settled material.
3. De-air if necessary at 760 mm of Hg for 5-10 minutes.
4. Pour into cavity to be encapsulated or adhered.

CURE SCHEDULE:

Initial cure is achieved in 16-24 hours at room temperature. Final cure takes at least 7-10 days at 72F. To accelerate the cure higher temperatures can be used, 2-4 hours at 150 F is usually sufficient, after allowing the product to gel at room temperature for 3 hours.

STORAGE REQUIREMENTS:

This product has a tendency to settle upon storage and shipment, material should be mixed well prior to use. Store in a cool dry place.

IMPORTANT:

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HEALTH CAUTION:

Avoid breathing possible fumes, mists and vapors, which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clear water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keep away from open flame or ignition source.

PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION.

FOR CHEMICAL EMERGENCY
CALL CHEMTREC (DAY OR NIGHT) 800-424-9300.